

The ART of

Making

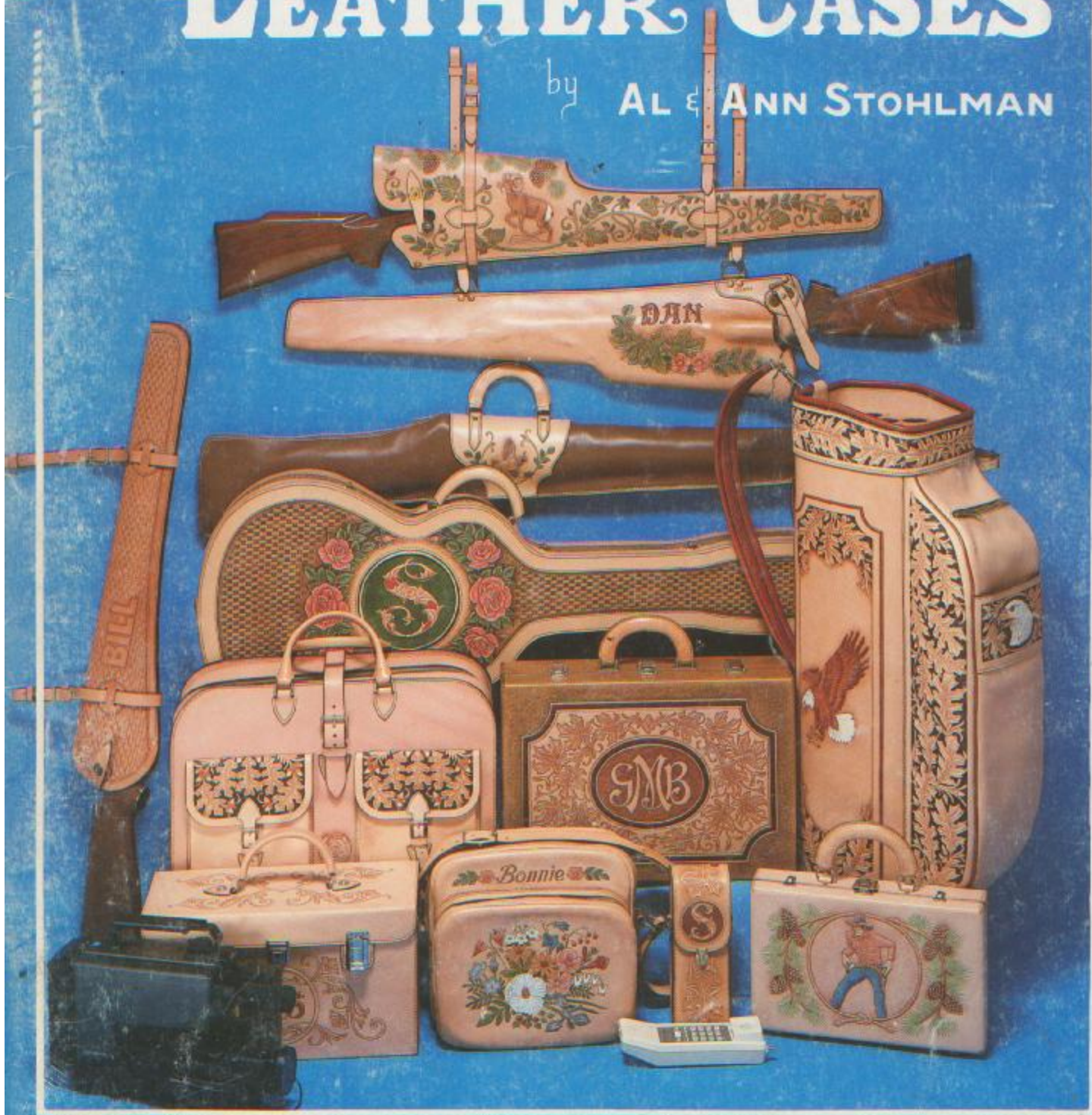
LEATHER CASES

by

AL & ANN STOHLMAN

Volume THREE

STOCK NO. 1941-03

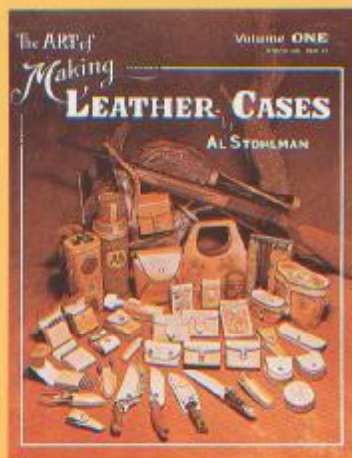


The ART of
Making
LEATHER CASES

THREE VOLUMES

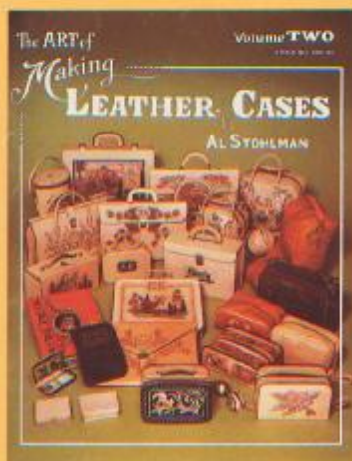
Over 360 pages of Leather Case-Making knowledge.

by AL & ANN STOHLMAN



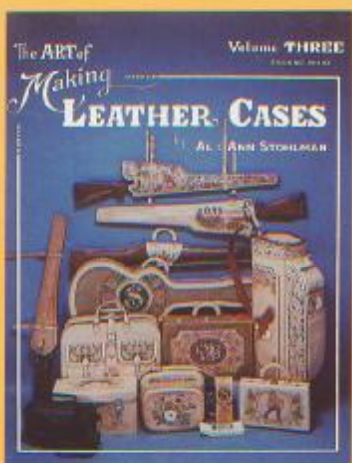
VOLUME ONE: 120 pages

This book offers information on weights (oz.) of leather...to help you understand thicknesses. It also explains the importance of "casing" leather. Hand shoe tacks are introduced with why and how to use them. Many methods of making and installing leather loops are shown along with the proper ways to attach dees, rings, buckles, etc., to the cases. It also shows how to make wooden forms and use them, as well as how to determine the size of a case to insure clearance within it. How to bevel the miter joint. How to carry cases on a saddle. Instructions include the simplest knife sheath to a complex C.B. (citizens band) case featuring many options. Other cases include a wide assortment: pliers, cartridge, playing card, cigar, cigarette, snuff, flashlight, eye-glasses, checkbook, hatchet, camp saw, cameras, binoculars, thermos, and more. And...how to oil them.



VOLUME TWO: 124 pages

This book gives instructions for making 20 styles of handles for cases, luggage, and handbags. Four pages of zipper information include how to make them to proper length, shorten them and proper installation. There are many zippered cases included. Instructions include the installation of hardware and case locks. A special section instructs on how to design cases and lay out the pattern. It also explains how dimensions diminish when the leather is folded, and how to insure room for the contents within. Welts are featured: making, splicing, installing. A unique pattern shows how to make round (ball) cases for shot putt, bowling ball, etc. Other cases: one-piece box, octagon, cassette, attaché, diplomat pouch, brief cases with accorian gussets, travel & toiletry, manicure, knitting & gadget bags, boot case, and more. Many valuable tips are also presented.



VOLUME THREE: 116 pages

This book presents some new techniques on construction and assembly not offered before. Patterns for the shoulder tote and flight bag are given, with different assembly methods. Instructions show how to design and make cases for any cordless phone or video camera. The attaché and pistol cases are leather covered wooden boxes; special instructions show you how. Saddle scabbards are presented in various styles. Scope scabbards are shown formed of one piece of leather; we show you how. Other methods of making scope scabbards are shown. The proper ways are shown for carrying on the saddle. Included are full length zippered cases for carbines, rifles, and shotguns. A "FORMULA" is given for making case patterns for any gun, be it shotgun, lever-action, bolt action, or scope-mounted. Complete instructions are presented for guitar cases and golf bags.

FOREWORD

We have finally completed Volume THREE of "The Art of MAKING LEATHER CASES". It has taken almost a year! We were going to also include garment bags and a complete line of luggage, but this would have taken the book to over 200 pages and at least six months more to complete. We also thought the costs and time involved (for the craftsman) would not warrant their construction, as complete sets of luggage can be purchased at reasonable prices. One has to wonder if he could trust airlines and bus terminals (of today) with a beautiful hand carved suit-case!

You should be able to make a case for almost anything from the information within the pages of our THREE Volumes, from a simple knife sheath to a *cello* case! Of course that would take a lot of leather...but it could be done by following the instructions for making the guitar case.

In all THREE Volumes we have explained how to make the fold gouges and how to insure clearance within the case for the contents. We have shown how cases can be made of one piece, or of individual panels. It would be impossible to give you patterns for every item manufactured. However, if you are serious about making a leather case for a special item...you *can* do it...if you will only read and study these books. The information is there. You may have to adapt some of the construction techniques from each of the THREE Volumes for your particular case. For this reason it is important that you understand what is in each of these books.

We have shown you how to make and install zippers and welts. We have shown you how to make and cover wooden forms of many shapes and odd designs. We have shown you how to

make round and tubular cases, how to make and sew the miter joint, the butt joint, and the *proper* way to install dees, buckles, leather loops, and hardware. We have shown you how to make accordion gussets and how to add stiffeners to your cases. You have, in the THREE Volumes, an extremely varied and wide range of leathercraft knowledge. It is up to you, on how you wish to use it. If you want to make professional-type cases you must read and study all of the pages in *all THREE books* until you understand all of the procedures and techniques. What more can we do?

Before attempting *any* of the cases it would be wise to first read all of the pages concerning the project, and be sure you understand each step from beginning to end. You will often be referred to one of the other books where the steps are identical. This is to save us space, and you less cost in not having to buy extra pages. Printing is very expensive.

We have not included any Tracing Patterns for the carving designs in this book. This would not only have made the book more expensive for you, but chances are your cases may be of a different size than ours. Our carving designs were taken from past publications where you have access to the patterns. Where we have used carving designs, we have indicated (by asterisk*) where you can find them.

So...if you are serious about making leather cases...there is no reason why you cannot. We have certainly written enough words taken enough photographs...and made enough drawings on the subject to make CASE-MAKING easier and more understandable.

Yours for continuing better leathercraft,

Al & Ann Stohlman

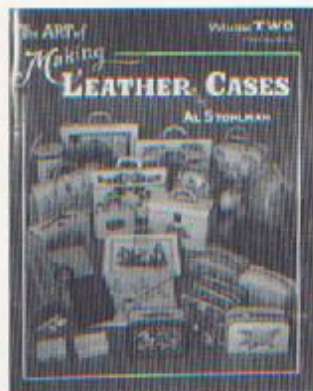




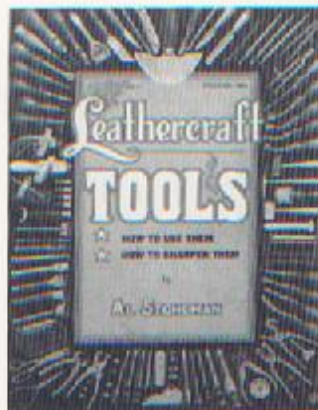
"HAND SEWING"



"CASES"- Vol. I



"CASES"- Vol. II



"TOOLS"

Before we get into making more cases, we should review some past publications. The books shown at left have valuable information that is vital to the success of making leather cases of professional quality. Instead of constantly repeating ourselves in certain areas, we will refer you back to these other books. EXAMPLE: On page 21 of this book ("CASES"- Vol.III) we tell you to make some welts for the Tote Bag. We tell you what weight leather to use, but no step-by-step installing instructions. This has been printed already. If you do not understand all about installation and the making of welts, we give you the name of the book(s) and the pages on which the information will be found.

To save copy space, we will shorten the name of the books as shown below each photo. Below, we have listed a few things that you may want to review while making your cases. This will save you time and give you ready reference to the material desired.

Attaching CATCHES and LOCKS:

"CASES"- Vol.II, pages 32 through 35. "TOOLS", page 82

Attaching DEES, RINGS, BUCKLES:

"CASES"- Vol.I, pages 6 to 9. "HAND SEWING", pages 37 to 40.

Setting SNAPS, RIVETS, FASTENERS:

"CASES"- Vol.I, pages 10,11. "CASES"- Vol.II, page 35. "TOOLS" pages 80 through 89.

LEATHER HANDLES:

"CASES"- Vol.II, pages 2 through 23. "CASES"- Vol.I, pages 32, 58,98 (special types).

ZIPPERS - Making, Installing:

"CASES"- Vol.II, pages 28 to 31 and pages 102 through 117.

WELTS - Making, Installing:

"HAND SEWING", pages 45,46,52,53. "CASES"- Vol.II, pages 75 to 78, 84 to 95 and 123. Proper trimming instructions, page 78.

MITER JOINTS - Beveling, Sewing:

"HAND SEWING", pages 22,23,24,28. "CASES"- Vol.I, pages 27,29, 31,39,43,44,61,62,69,70,75,76,80,83,84,88,114,118. "TOOLS",38.

Gouging for FOLDS:

"HAND SEWING", page 25. "CASES"- Vol.I, page 89. "TOOLS", page 34 to 36. "CASES"- Vol.II, page 27.

LEATHER LOOPS - Making, Attaching:

"CASES"- Vol.I, pages 4,5,9. Belt loops, 13. "CASES"-Vol.II, pages 3,4,5. "HAND SEWING", pages 36 through 40.

CEILING HOOK:

Used for holding large areas of a case out of the way while sewing the project in the stitching horse. The clothes pin can be replaced with a small clamp. "CASES"- Vol.II, page 25.

BROKEN GLASS:

Used to even the edges of two or more pieces of leather, sewn or glued together. "HAND SEWING", page 63. "CASES"- Vol.II, page 25. When dull, break a fresh cutting edge.

Cordless PHONE CASE

Most cordless phones are similar in shape and design. Therefore it will be easy to make a case for any of them by following the instructions presented here. This case is for the Radio Shack Model ET-395.

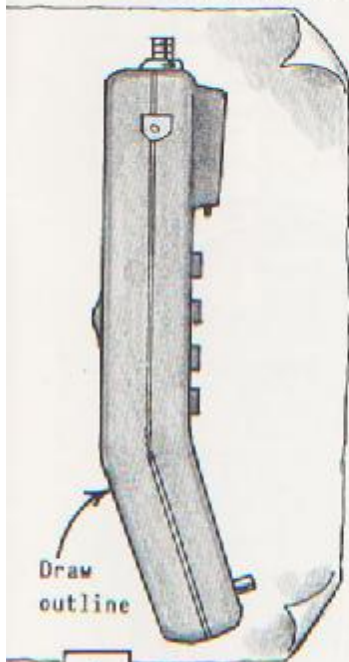
Among the considerations is whether you wish to use a shoulder strap or carry it on your belt. This case is made with both options. If carried on the belt, the belt loop can be set at an angle if desired. This may serve better especially in the sitting position. You will have to make this determination yourself by holding the phone against your belt at various angles while standing or sitting. See step 14.

Page 13 of "CASES Vol. I" shows many methods of installing belt loops. Be sure to study it.



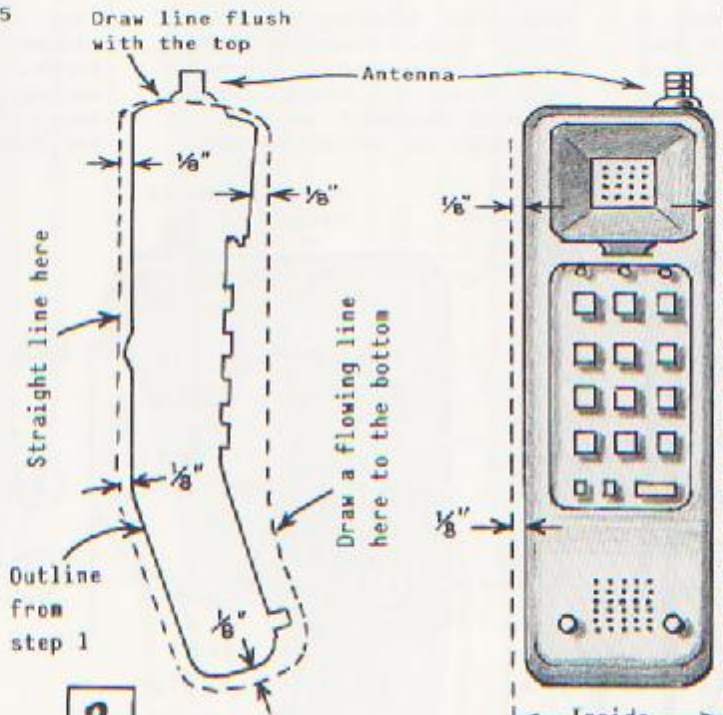
Carving Design*

Radio Shack Model ET-395



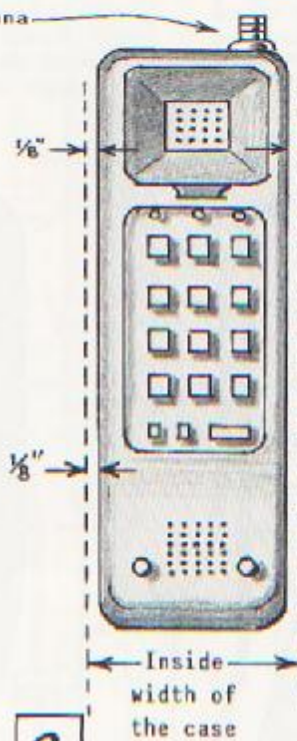
1

The first step in making a pattern is to lay the phone on its side on a sheet of paper. With pencil draw around all of the contours to establish the outline of the phone.



2

Remove the phone. Now draw a line (shown broken) for the side pattern. This line should be about 1/8" away from the body and protuberances of the phone.



3

Measure the width of the phone and add 1/8" to each side. This will be the inside dimension of the case.

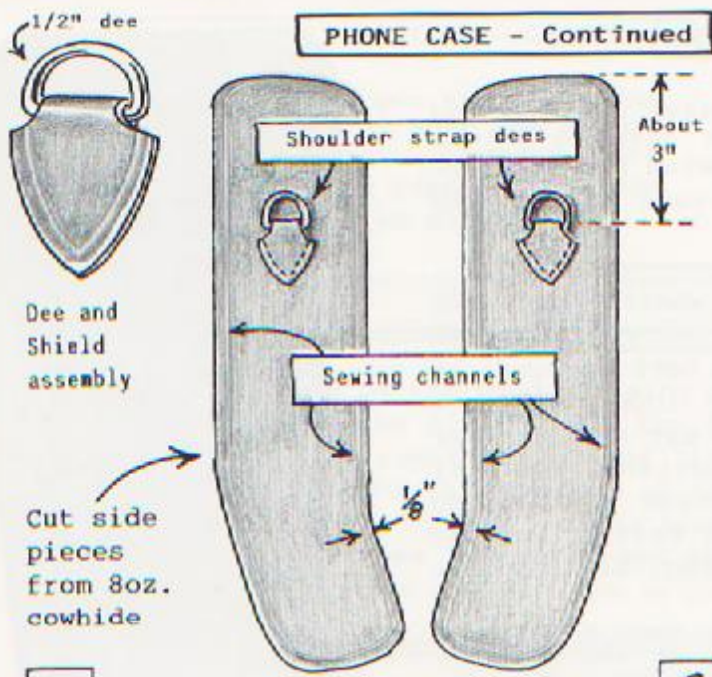


4

The above diagram shows how to determine the width to cut the case leather. This will overlap the thicknesses of the lining and outside leathers of the side pieces. (continued)

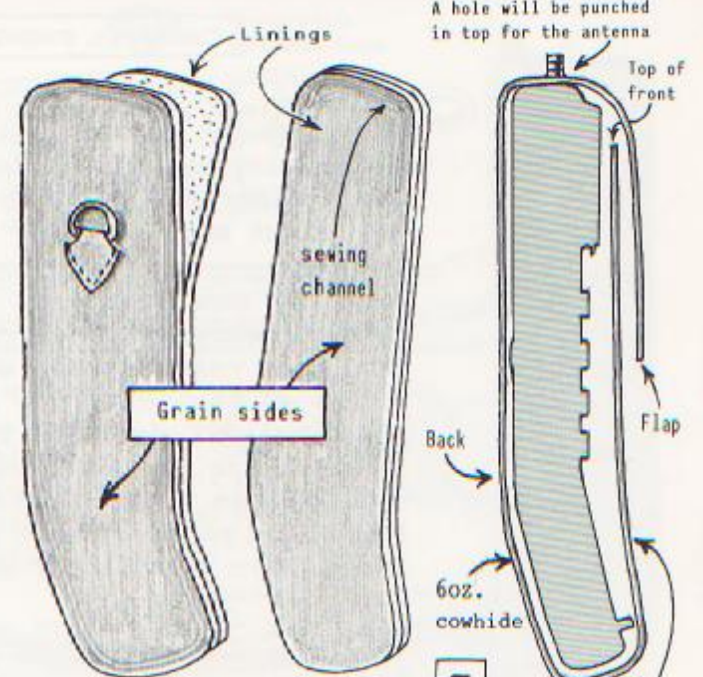
NOTE: The width of a leather case must never be wider at the bottom than the top! Most of these phones have parallel widths at the sides.

*Letter "S": Craftaid No.2710. MAPLE LEAF: "Inverted Leather Carving".



5 OUTSIDE SIDE PIECES

From pattern (in step 2) cut out a left and right Side Piece. If you want a shoulder strap, attach dees to the outside pieces as suggested above. Gouge a sewing channel all around the edges.

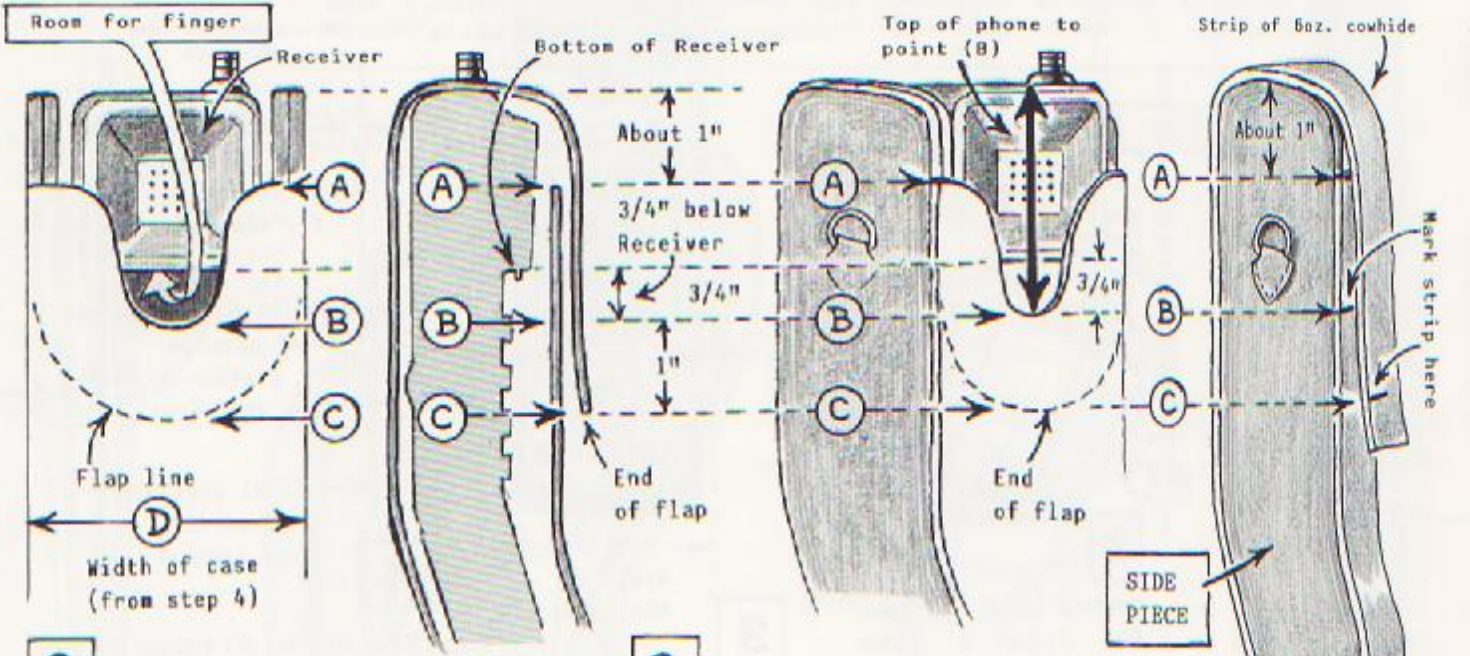


6 OUTSIDE INSIDE

Cut two lining leathers from 8oz. cowhide. Cement flesh sides together; trim to size. Gouge sewing channel in top of linings as shown above.

7

The case is planned as shown in the profile above. The flap will overlap the front of the case. A Tuck-Catch will be used for the closure.



8

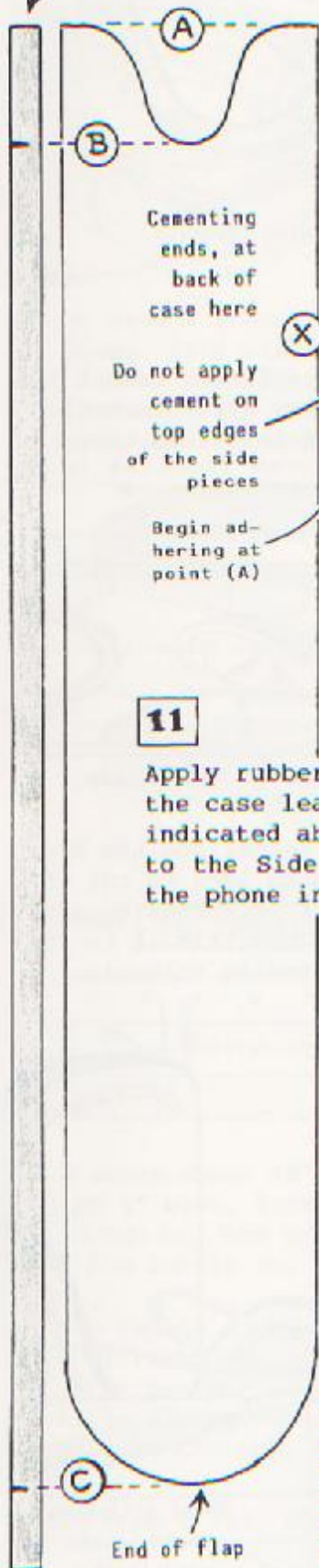
The front of the case will have to dip down (at B) so a finger can pull up on the receiver to remove the phone from the case. The flap (C) should overlap the cut (B) by about 1". (D) is the full width of the case leather.

9

To determine how long to cut the case leather, cut a strip from the same leather as the case will be made of (on this we used 6oz. cowhide). Begin by placing the strip about 1" down from the top of one of the end pieces (at A). Put a mark on the strip at (B). This is located by measuring down from the top of the phone (see above). Fold the strip around the Side Piece. Hold snugly at overlap of point (A) and put a mark on the strip at (C), 1" down from mark (B).

(continued)

Leather strip
from step 9



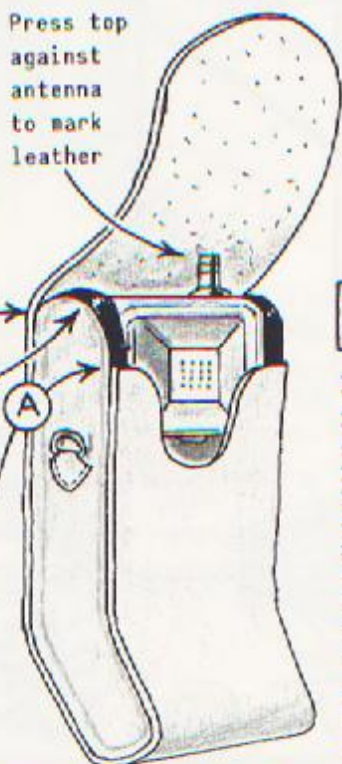
Cementing
ends, at
back of
case here

Do not apply
cement on
top edges
of the side
pieces

Begin ad-
hering at
point (A)

10

Now make a pattern for the case from the measurements and instructions of steps 8 & 9. Use the marks on the leather strip to assist as shown at left. Cut the case from 6oz. cowhide.

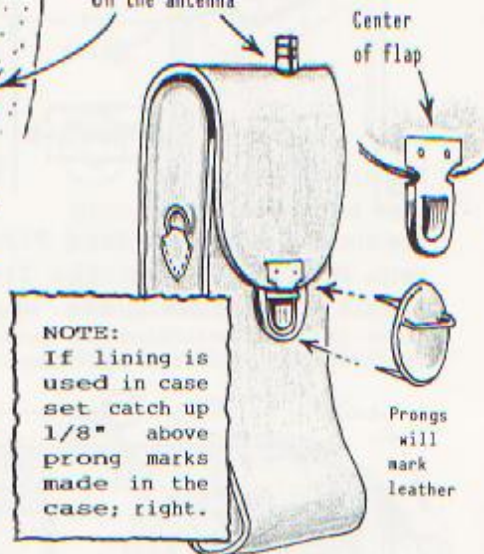


12

from step 11

Punch a hole for the antenna in the flap. Note that the hole is not centered on the mark. Different sizes & styles of antennas determine size or shape of hole.

NOTE: Some trimming or elongation of hole may be necessary, depending on the antenna



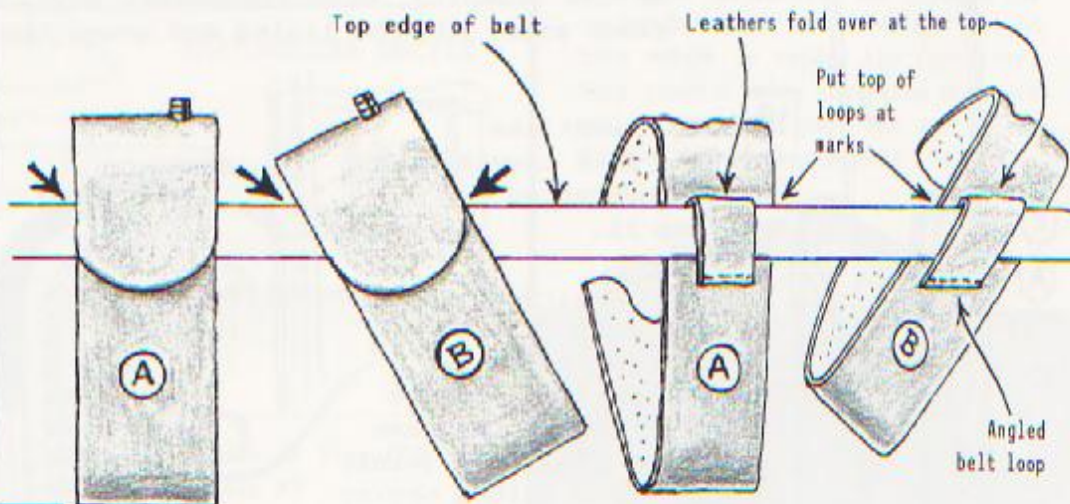
NOTE:
If lining is used in case set catch up 1/8" above prong marks made in the case; right.

11

Apply rubber cement to the edges of the case leather and Side Pieces as indicated above. Adhere the leather to the Side Pieces as shown. Place the phone inside of the case.

13

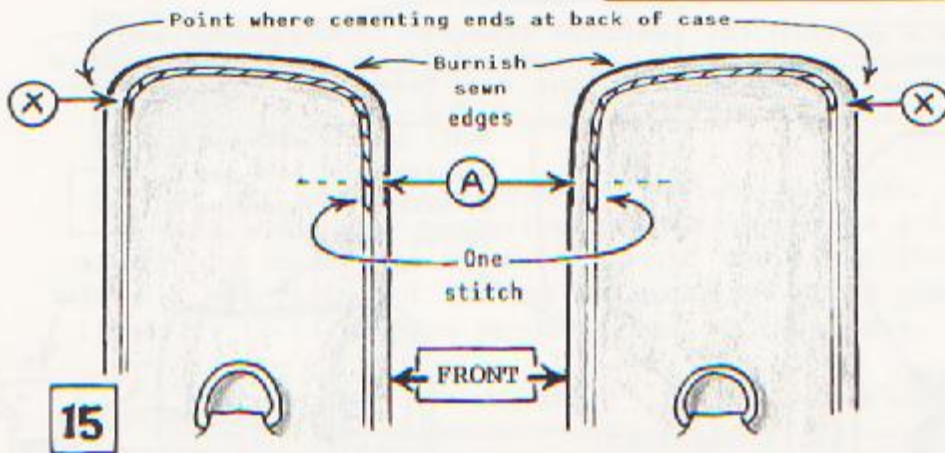
Fit the catch on the flap (do not attach yet) and join the parts together. Hold the flap down at the top and push on the catch unit so the prongs will mark the leather on the front of the case. Be sure you are centered on the case. Remove the parts of the catch. Observe the note above if the case is to be lined with leather.



14

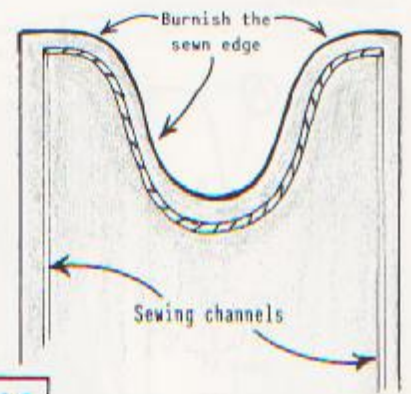
To determine the position of the belt loop hold the case against your belt as suggested above. Move it up or down to whatever position you think it will ride the best, or be most comfortable. Often times the angled position will be more comfortable especially in the sitting posture. Mark the edges on the back of the case indicated by the heavy arrows above. Now peel the case leather off the side pieces. (continued)

PHONE CASE - Continued



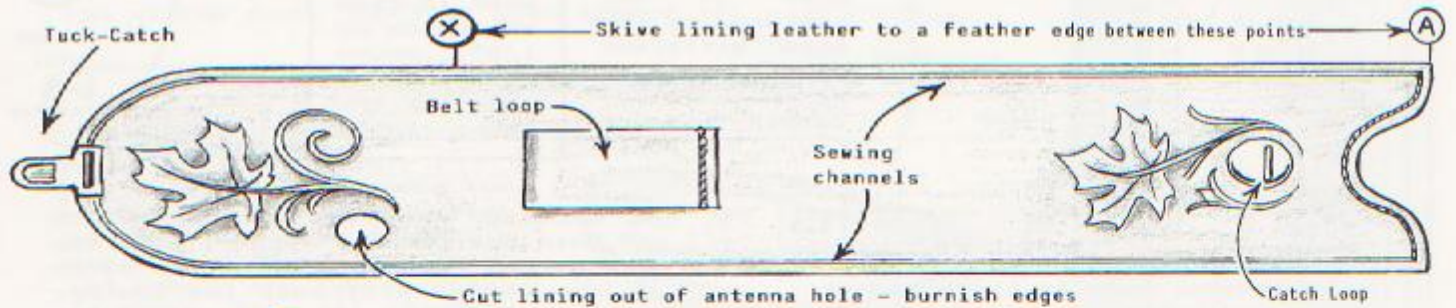
15

Sew the top ends of the Side Pieces as shown above. Point (A) is where the front of the case cements to the sides...take one stitch beyond point (A). End stitching at point (X). This is the transfer point for stitches (see step 20).



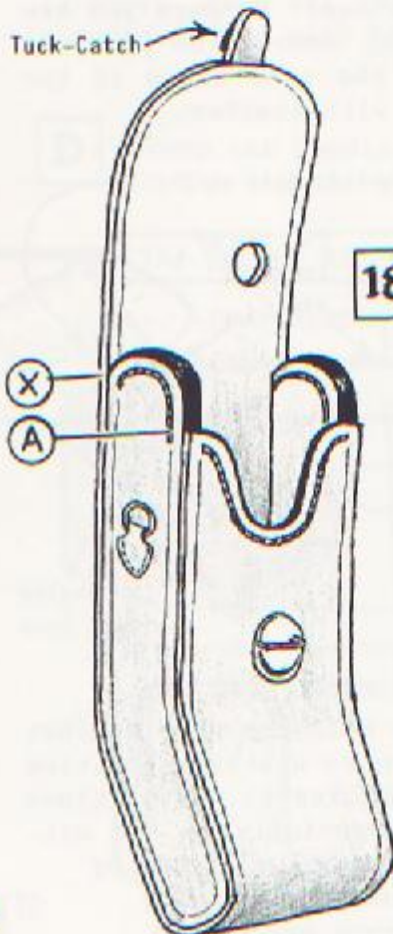
16

If the case is lined, cement the lining in place after installing the catch and belt loop. Sew the top edge of the front as shown in the illustration above.



17

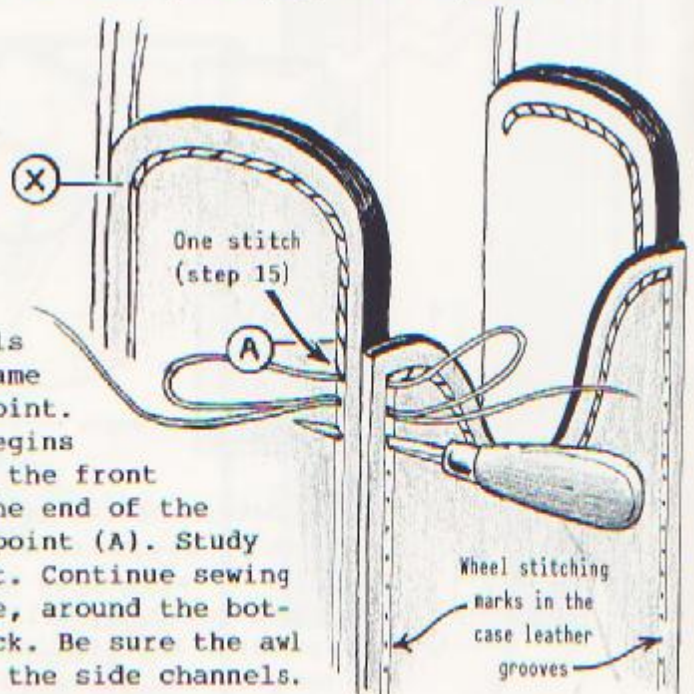
Complete all carving and stamping before installing the belt loop and catch parts. It is generally a good idea to cut the leather a bit oversize in case the leather stretches because of the stamping. When thoroughly dry you can trim it to the exact size. Add the lining and gouge the sewing channels.



18

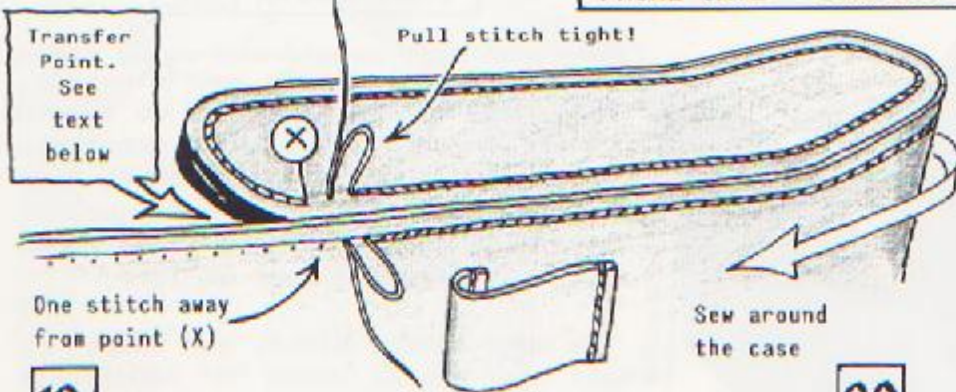
Now cement the case back together as instructed in step 11.

Begin sewing at the front of the case. Stab the awl through the channels at an angle, the same as for the miter joint. The first stitch begins at the top edge of the front and comes out at the end of the "one stitch" near point (A). Study the sketch at right. Continue sewing down the front edge, around the bottom, and up the back. Be sure the awl blade comes out in the side channels. (continued)



PHONE CASE - Continued

Transfer Point. See text below

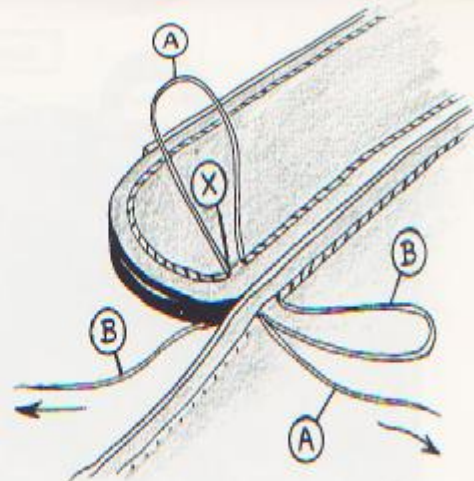


One stitch away from point (X)

Sew around the case

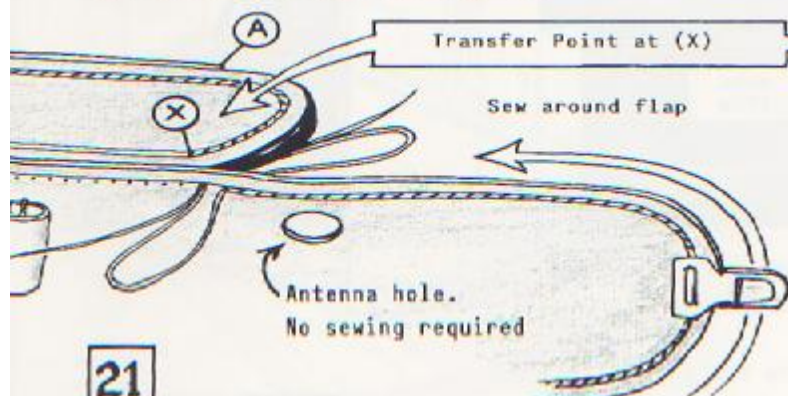
19

Continue sewing up the back until you are one stitch away from the transfer point (X) as shown above. Pull this stitch tight. Now one of the threads must be transferred to the inside of the top of the case. Follow the instructions in step 20.



20

Stab the next hole from the back to come out at point (X). Bring thread (A) down through this hole and pull tight. Now stab a hole in the same hole that thread (A) is in, only angle the awl to come out inside the case. Put thread (B) through as shown. Pull stitch tight! Continue sewing.



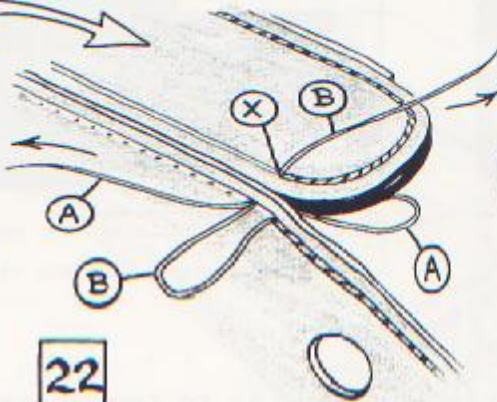
Transfer Point at (X)

Sew around flap

Antenna hole. No sewing required

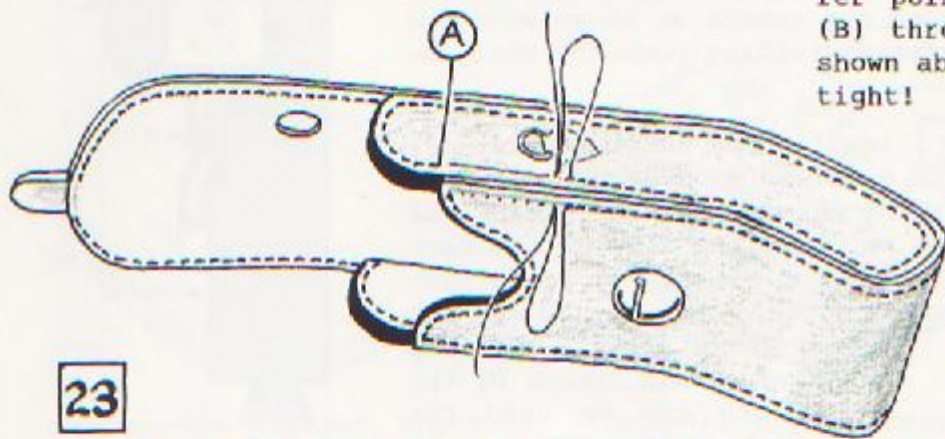
21

Sew around the flap up to the Tuck-Catch. Backstitch, cut off threads. Resume sewing on the other side of the catch. Sew to within one stitch of the point (X). Pull stitch tight! Continue with step 22.



22

Stab next hole to inside of case, bring thread (A) to outside. Angle awl to come out in Side Piece at transfer point (X). Pull thread (B) through this hole...as shown above. Pull stitch up tight!



23

Continue sewing down the back, around the bottom, and up to point (A) on the front side. Backstitch and cut off the threads. Use a large Edge-Beveler around the case where stitching joins the side pieces; A smaller beveler on the top and flap. Burnish these edges. Apply your favorite leather finish.

The completed case is shown at right.



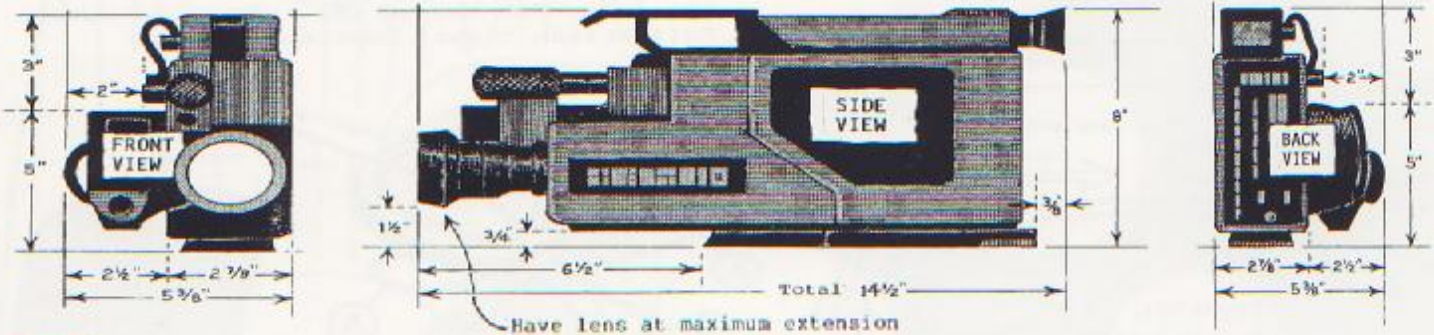


Carving Design*

Camera:
KYOCERA
8mm Camcorder

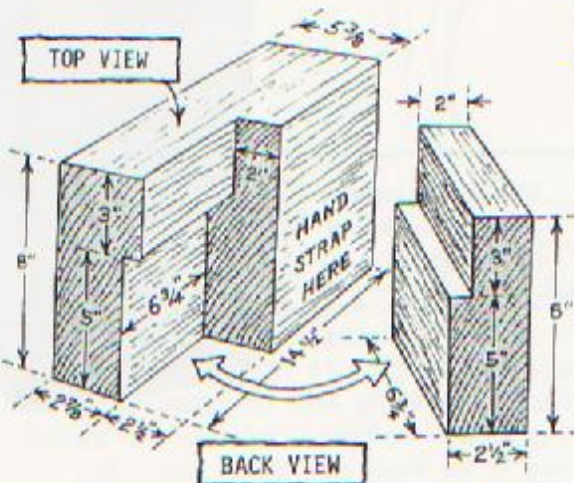
More and more people are using Video cameras for business and pleasure. Many vacationers use them to record their holidays and other memorable experiences and enjoy playing them back for viewing on the TV set. We have also purchased one. It is shown with our personal case at left.

The many makes, sizes, and shapes of all the models makes it impossible to give patterns for all. We present patterns for our model with information and suggestions on how to make a case for your own Video camera regardless of its size or shape.



1

The first thing you have to do is to record some of the measurements. Lay these out on a sheet of paper as we have shown here. The measurements should be as exact as possible. The main measurements are the height, length, width. You must add to these dimensions to have ample clearance within the case for the camera. These dimensions are determined by the type of case construction, whether it is to be lined or not. Also measure the open spaces around the camera as shown with our sketches, as these areas can be used for installing pockets, etc., inside of the case.

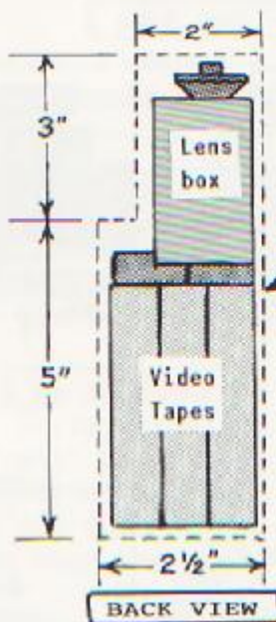
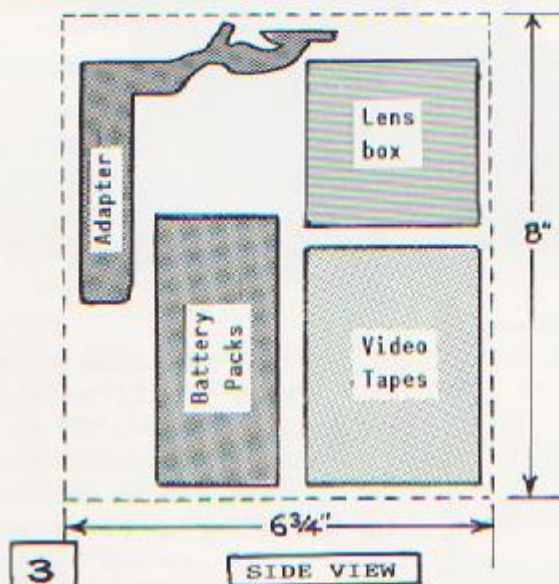


2

Imagine the total outside dimensions as a block of wood. By cutting out the dimensions on the right side of the back and top views, you would have a section of the block cut out as shown (left). This area is space not taken by the camera and can be used for pockets for video tapes, battery packs, etc. Pockets must not be placed above any part of the camera to restrict its withdrawal from the case.

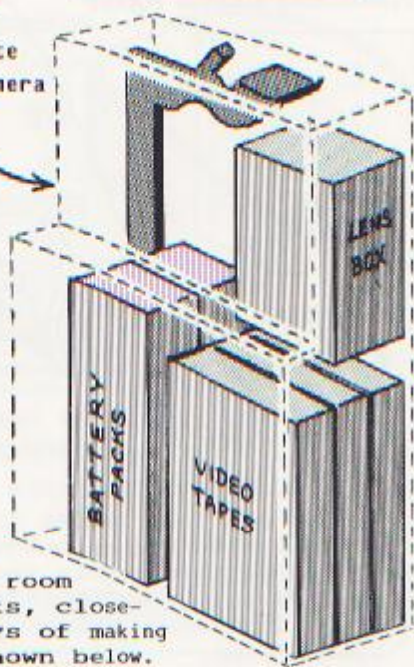


VIDEO CAMERA CASE - Continued

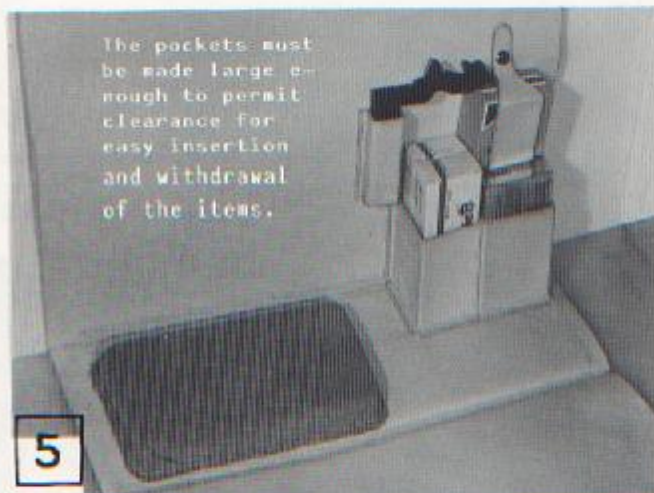
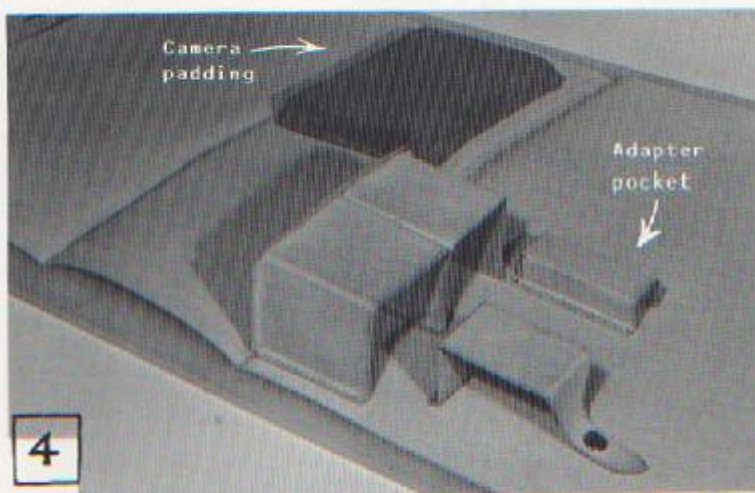


Broken lines indicate non-camera space

THREE-DIMENSION VIEW

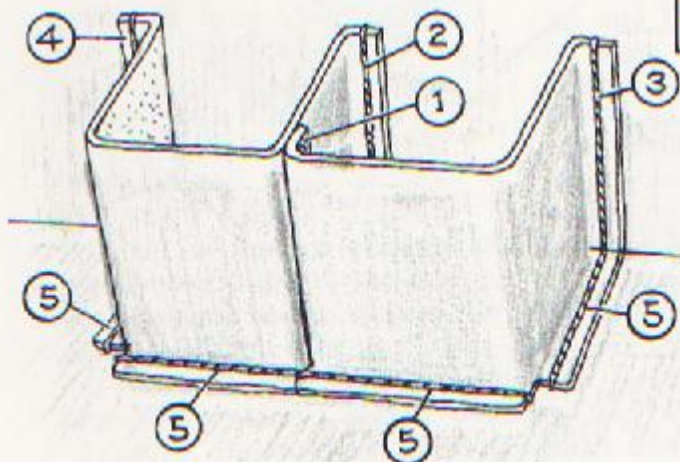


From the measurements in step 2 you will see that we have room in this non-camera space for 3 video tapes, 2 battery packs, close-up lens box, and a view-finder adapter. There are many ways of making pockets for these items. We have chosen a simple method shown below.



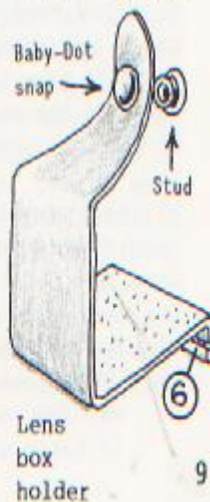
Establish the bottom folds in the lining. Pockets are shown sewn to the back panel of the lining. Positions of the pockets must be preplanned and marked on the leather.

To sew the pockets to the bottom lining the back must be folded up at a right angle and bottom edges cemented in place. Items are shown in pockets. Padding is sewn in place.

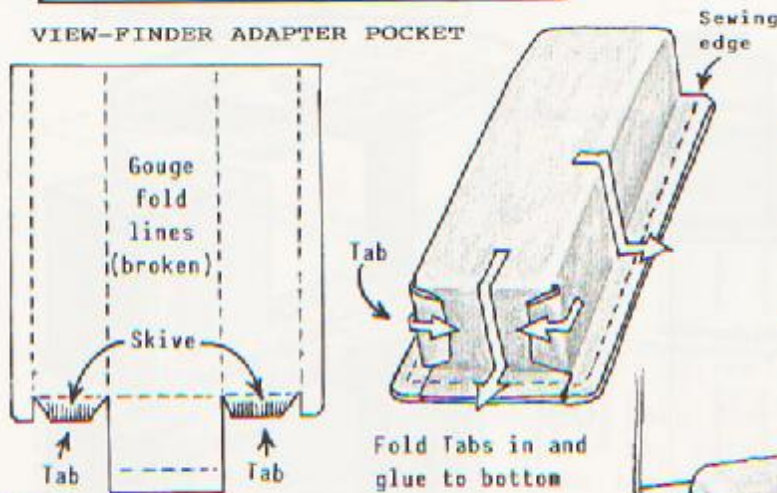


6 Install the pockets in the following manner: Sew edge (1) to other pocket. Cement (2) to back panel. Fold right pocket aside and sew (2). Cement (3&4) to back panel; sew. Fold back panel up, cement edges (5) to bottom and sew.

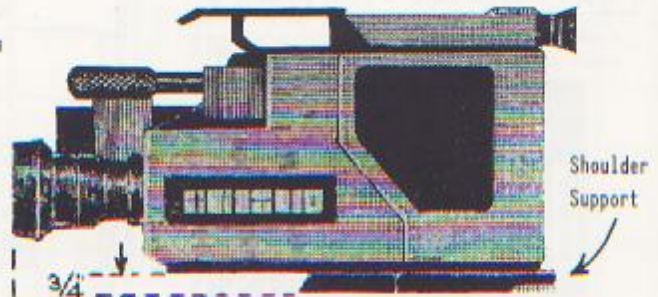
The lens box holder is a simple strap cut to fit around the box. Sew edge (6) at top of video tape height. Install snaps in proper location. Snap stud is set in the lining leather. Cut parts from 4/5 oz. cowhide. Gouge all fold lines.



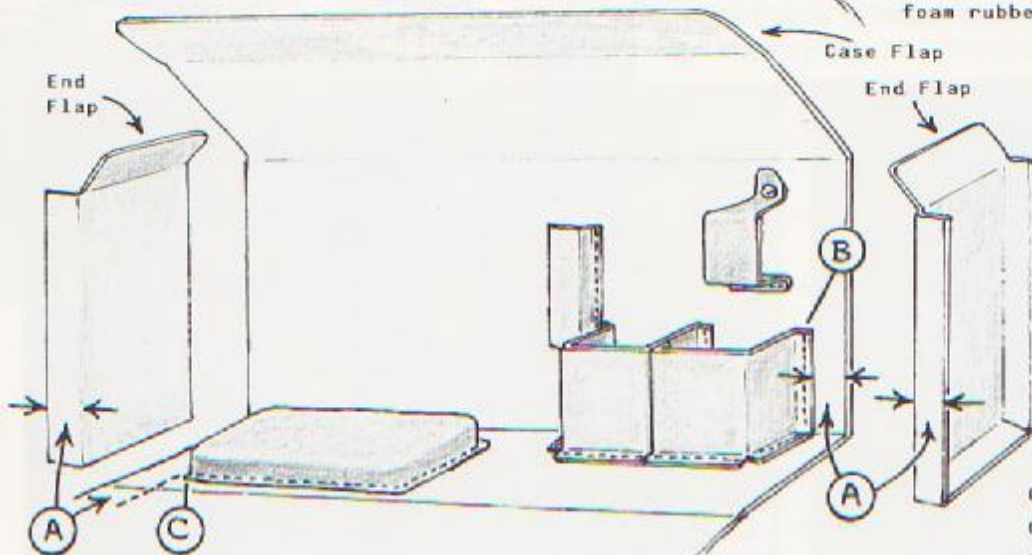
VIEW-FINDER ADAPTER POCKET



7 Cut the view-finder pocket to the shape shown above. Moisten gouges and fold as shown. Other pockets can be made in the same manner...to fit other items.



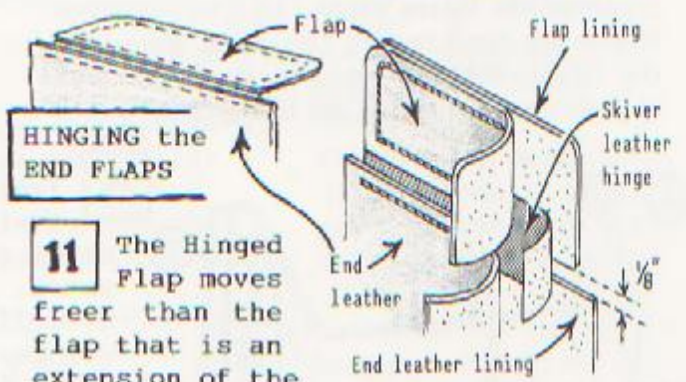
8 From the side view on page 8 you'll notice an area $3/4"$ x $6-1/2"$ below the camera under the lens. This can be filled by covering a piece of $3/4"$ foam rubber with leather and sewn to the lining, on the bottom. This not only cushions the camera but prevents its forward movement to keep the lens from rubbing on the case.



9 CAUTION: In step 1 we mentioned adding to the length, width and height to give clearance in the case for the camera. If the case will be lined, the distance between fold lines must be increased the thickness of the lining leather. If stiffeners are to be added on all panels, the distance between folds must again be increased by double thickness of the stiffening material. All of these things must be considered when designing your case.

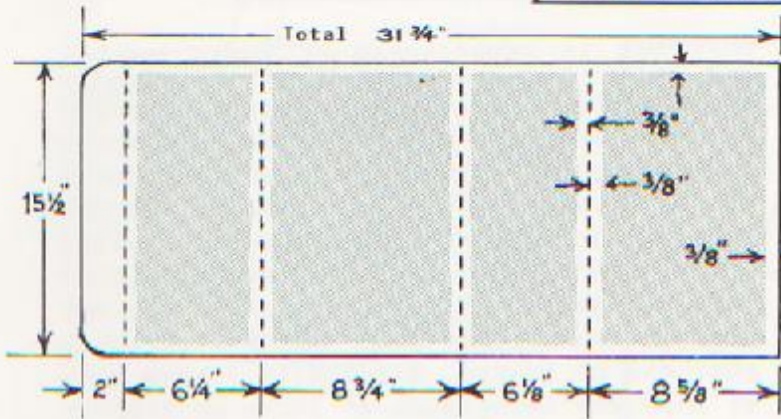
10 NOTE: If you are going to install the ends with the edges turned out, above, then you must increase the length of the case at each end by this amount (A). To allow room for the ends to fit in the case, the edge of pocket (B) and padding (C) will have to be set back from the edge equal to the width of the turned edges (A) of the ends. This is usually about $3/8"$.

If the ends will be sewn with the miter-joint then this extra length is not necessary. The ends of the case shown on page 8 are sewn with a miter-joint. It is a good idea to experiment with leather scraps using fillers and lining leathers. In this way you can see just how much space is taken up within the folds, the end assemblies, etc.

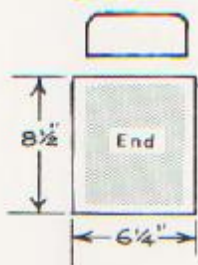


11 The Hinged Flap moves freer than the flap that is an extension of the End Piece. It folds freely in or out of the case; stays out of the way. Cut the skiver hinge about 1" wide, skive both sides. Glue about $1/2$ between the flap and its lining as shown. Glue the other $1/2$ as shown. Leave about $1/8"$ of exposed hinge between flap and top of End Piece. Sew as indicated. (cont.)

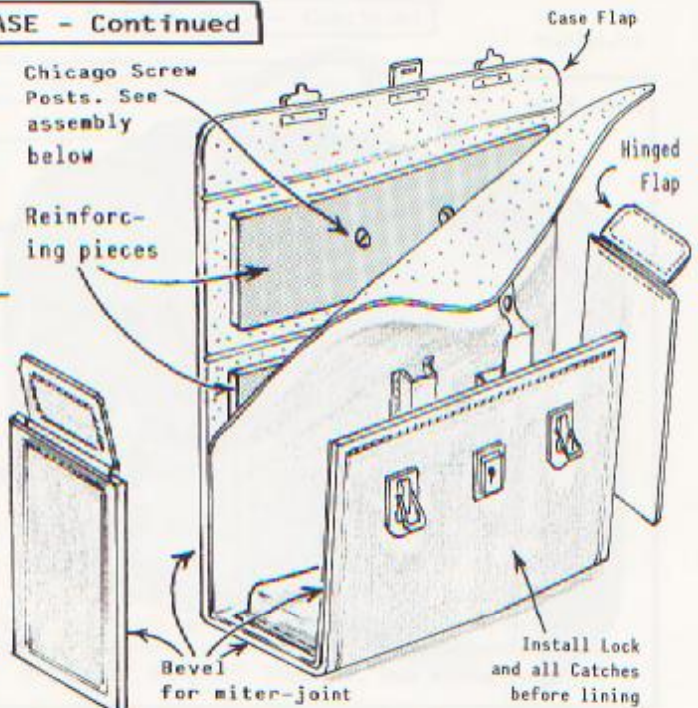
VIDEO CAMERA CASE - Continued



Flap
2" x 5 3/4"



12 The dimensions for our case are shown above. All of the panels (and ends) were reinforced with 1/8" veneer indicated by the shaded areas. Except for the ends this construction is identical to that of the Cassette Recorder on pages 48-49 in "CASES Vol. II". The ends are installed with the Miter Joint construction...and have the Hinged Flaps as shown on page 10.



13 Because of the pocket assembly (page 10) the lining at the bottom and back must be cemented to the case at right angles. The lining cements to the flap of the case same as step 14, page 49, of "CASES Vol. II". Sew the top of the front, around the case flap (including edges of the top) before cementing in the ends. This makes sewing easier in these areas. Also burnish these edges before proceeding with ends.

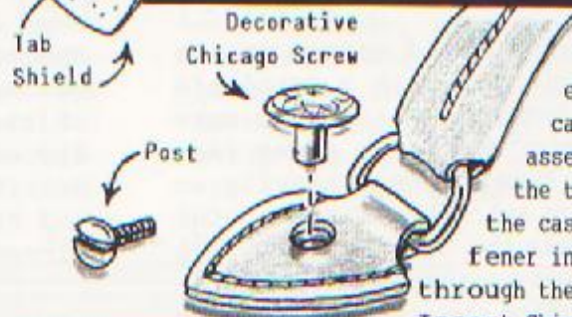
SPECIAL NOTE: If studs are to be used on the bottom of the case, they will have to be installed before gluing in the lining.

Handle No. 4

ATTACHING the HANDLE

Prepare the shields with tabs as shown. Push tabs through dees and cement to the flesh side of the shields. Punch holes through tabs and shields as illustrated.

This makes a secure and attractive handle attachment.



No. 7 punch

Before the stiffeners are glued to the case, glue the shield assemblies (centered on the top) and sew them to the case. Cement the stiffener in place. Drill holes through the top and stiffener. Insert Chicago Screws in holes and secure by screwing posts up through stiffener on the inside of the case. Screw down tight. Now lining can be cemented in.

NOTE: When handles are put in the top of most cases the area should have some type of stiffener to give firm support.

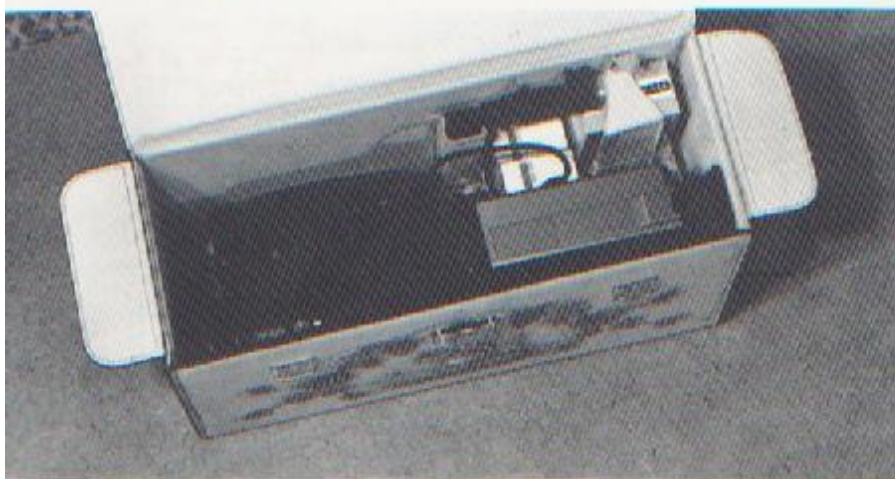


Photo shows camera and all items in their pockets. You'll notice how the hinged flaps fold out.

13"x19½"x7"

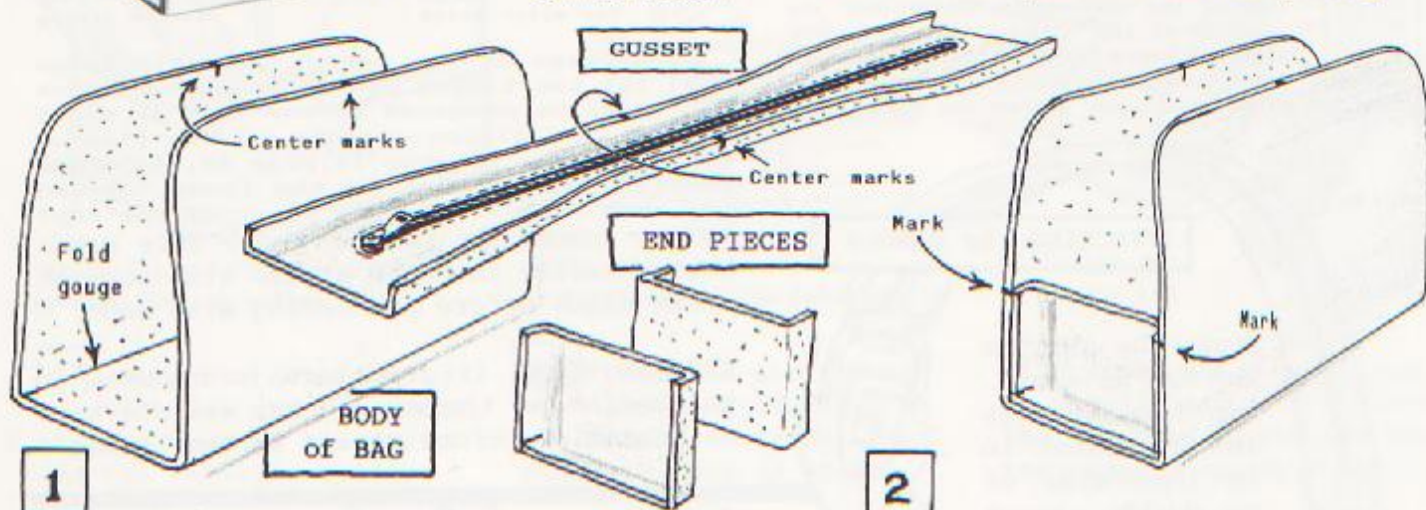
Handle No.20



Carving Design*

This bag is constructed of heavy leather and built for rugged use. It is designed to be carried on board and fits easily under the seat of modern jet airliners. It meets Pacific Western Airlines specifications. It has two outside expandable pockets that will hold a multitude of smaller items. The inside can be lined and fitted with any number or size of pockets you may desire. The zipper pull has a Tuck-Catch that can be locked. Personally I have never seen the importance of locks on zippered cases as anyone determined to get into them could slash the zipper tape around the sewn edges with a knife.

Carefully observe the instructions. Patterns are given on the following pages. Cut out the parts as exact as possible.



1

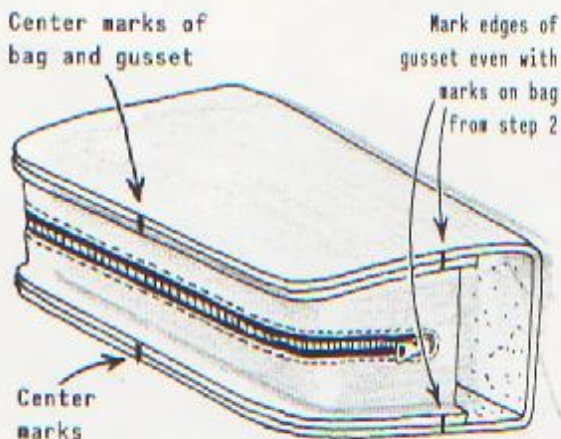
Cut out the bag. Make deep fold gouges in the bottom. Moisten and fold. Tap with a Cobbler's hammer and/or use a Saddler's Slicker to make crisp folds. Put "center" marks on edges (see above). Make two End Pieces. Gouge heavily on the fold lines. Moisten and fold as shown. Cut out the Gusset and make the fold gouges (see pattern). Sew in a heavy zipper. If you wish to line the Gusset, follow the instructions on page 29 & 115 of "CASES Vol.II". Put "center" marks on the edges (see above).

2

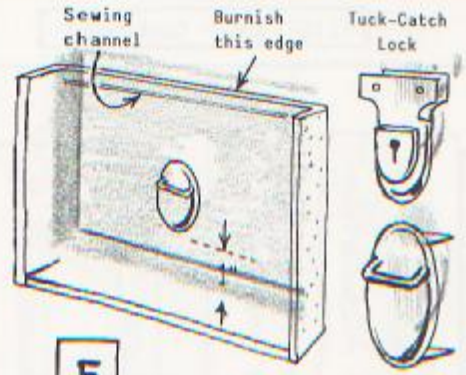
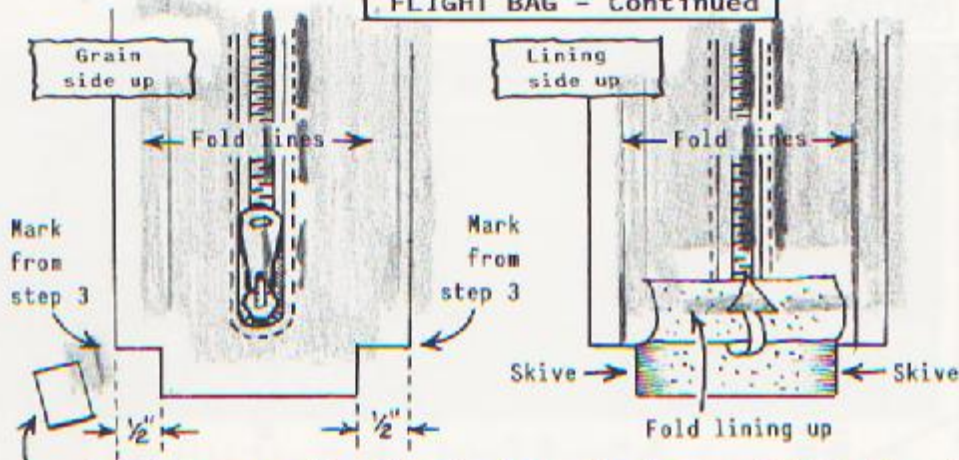
Rubber cement the End Pieces in the bag as shown above. Put marks on the edges of the bag right at the top of the End Pieces. Remove End Pieces. Put some identification marks inside the bag and End Pieces so each End Piece can be returned to its former position.

3

With rubber cement, adhere the gusset to the bag (right). Begin by aligning the center marks. Use care to keep all edges even. Put marks on the gusset. Also be sure and mark the gussets to match the end pieces so they do not get sewn to the wrong ends.



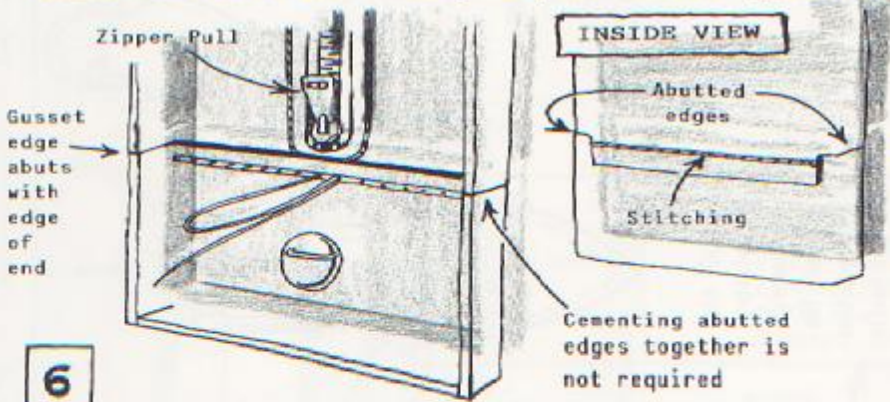
FLIGHT BAG - Continued



5

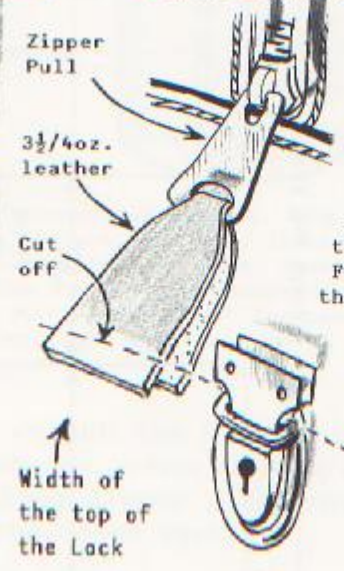
Install the lower part of the catch, centered on one of the End Pieces. This goes on the end with the zipper pull when the zipper is closed. Burnish top edge; gouge sewing channel. Cement lining to the ends.

4 Remove the Gusset from the bag and lay it out with the turned edges flat. Cut in at the marks and cut out a 1/2" section. Turn Gusset lining side up. Peel lining loose (above) and skive the edges thin. Re-cement the lining. Repeat on the opposite end.



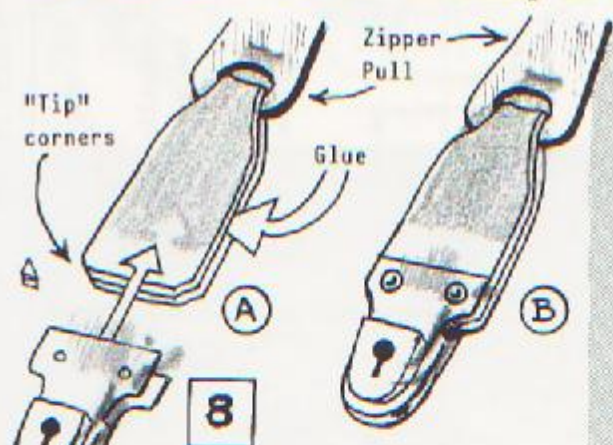
6

Turn the edges of the Gusset back up. Cement the Ends to the Gusset. Force End Pieces up so that the turned edges are tightly abutted. Be sure you have the proper Gusset end matched with the proper End Piece (review step 3). Now sew the ends to the Gusset. The Gusset Assembly is now complete.



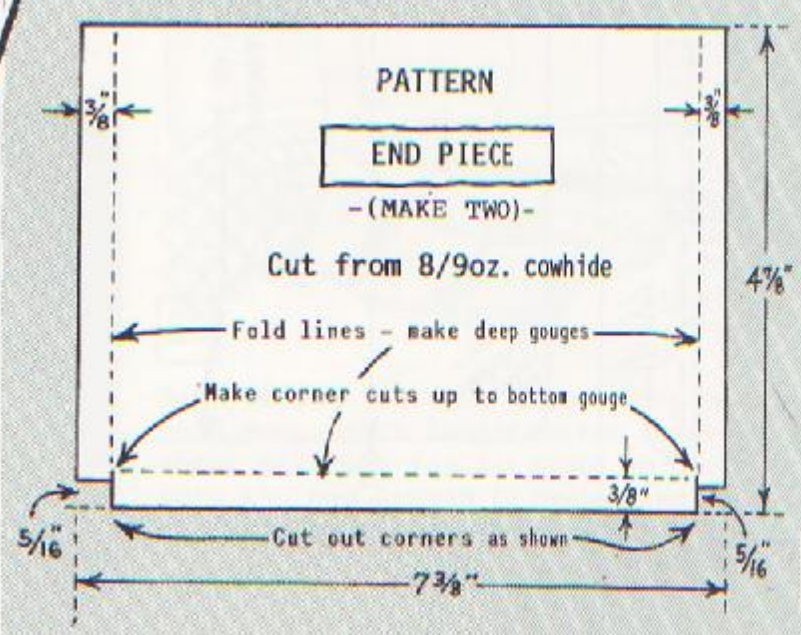
7

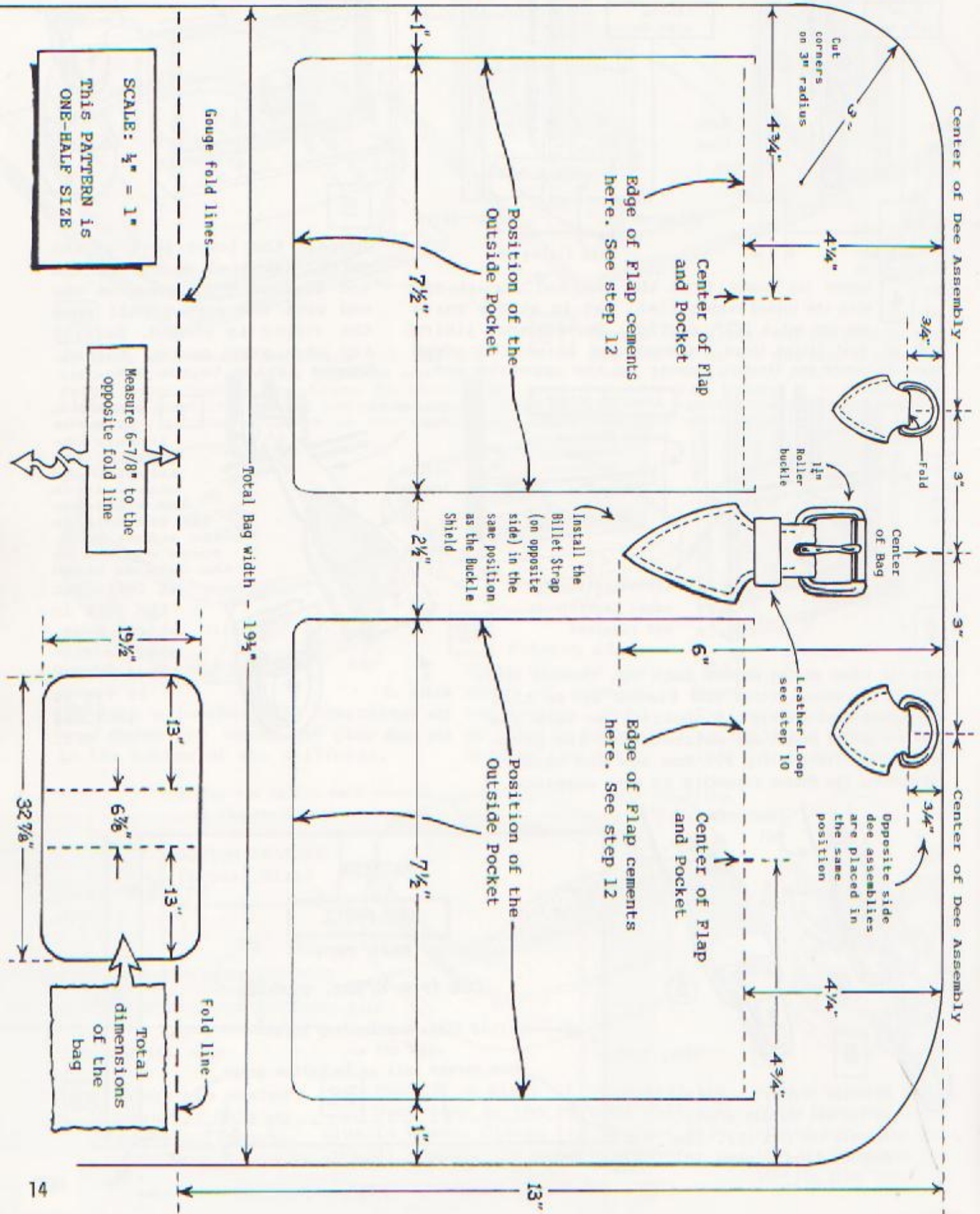
Now cut a piece of leather the width of the lock top and narrow it in the middle to fit the hole in the zipper pull. Force one end in the hole as shown at left. Put the lock in place. Measure the distance needed to fit in lock and cut off.



8

Glue the leathers together (A) and burnish edges. Install the lock (B). See completed bag on page 12.

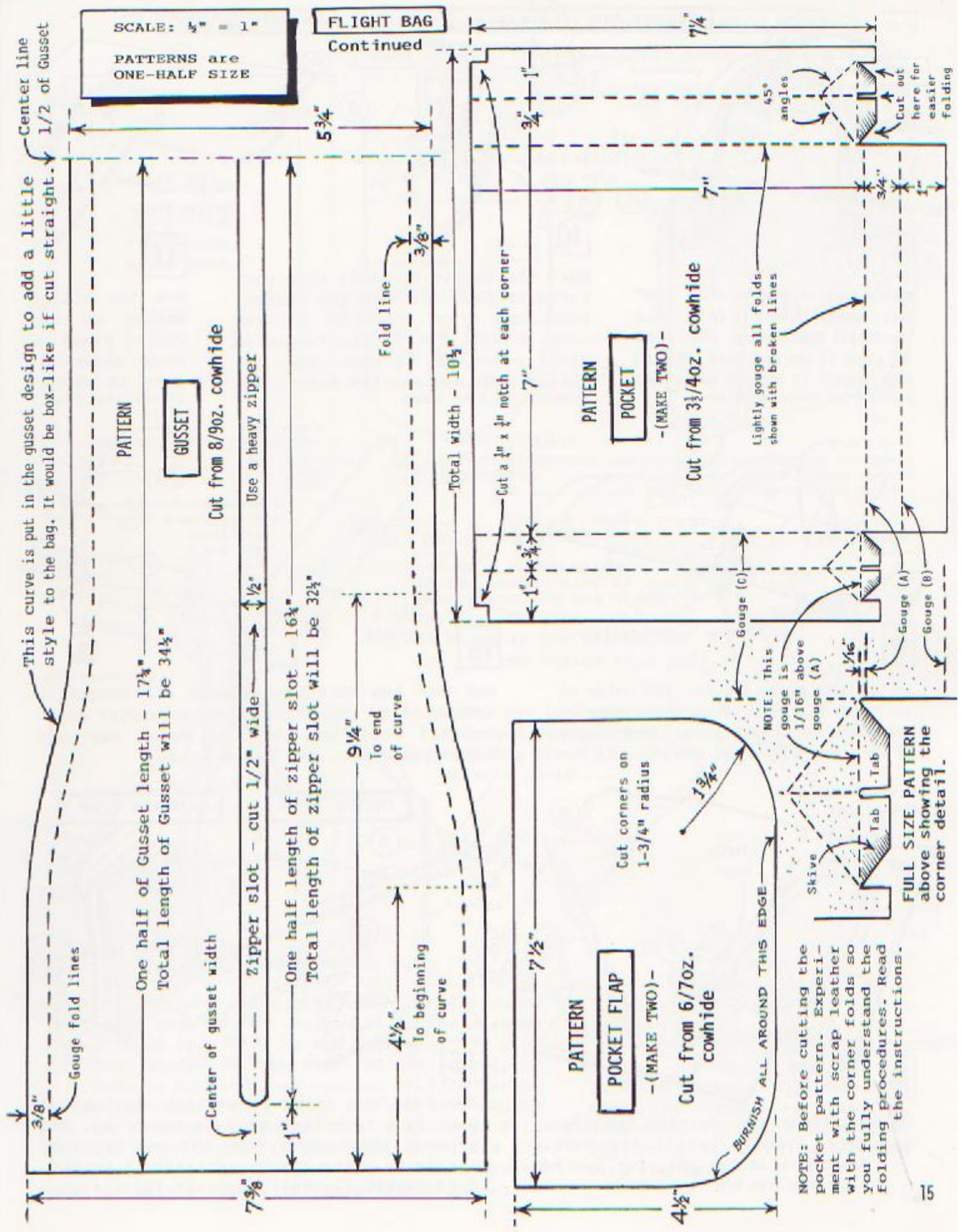




SCALE: $\frac{1}{4}'' = 1''$
 This PATTERN is
 ONE-HALF SIZE

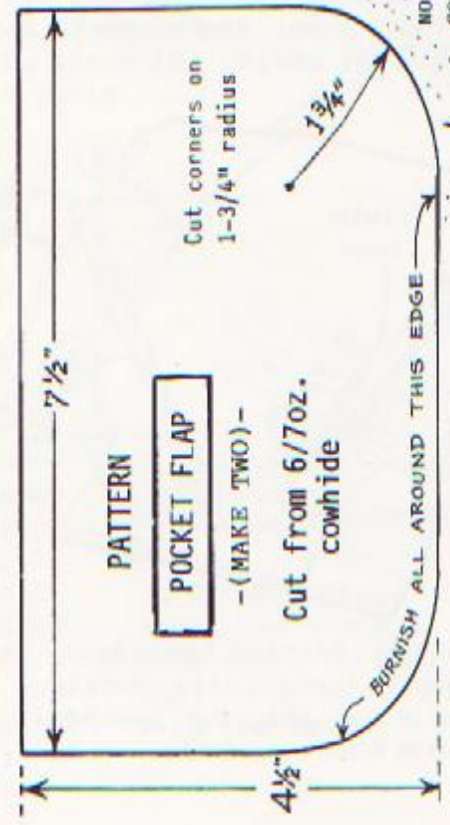
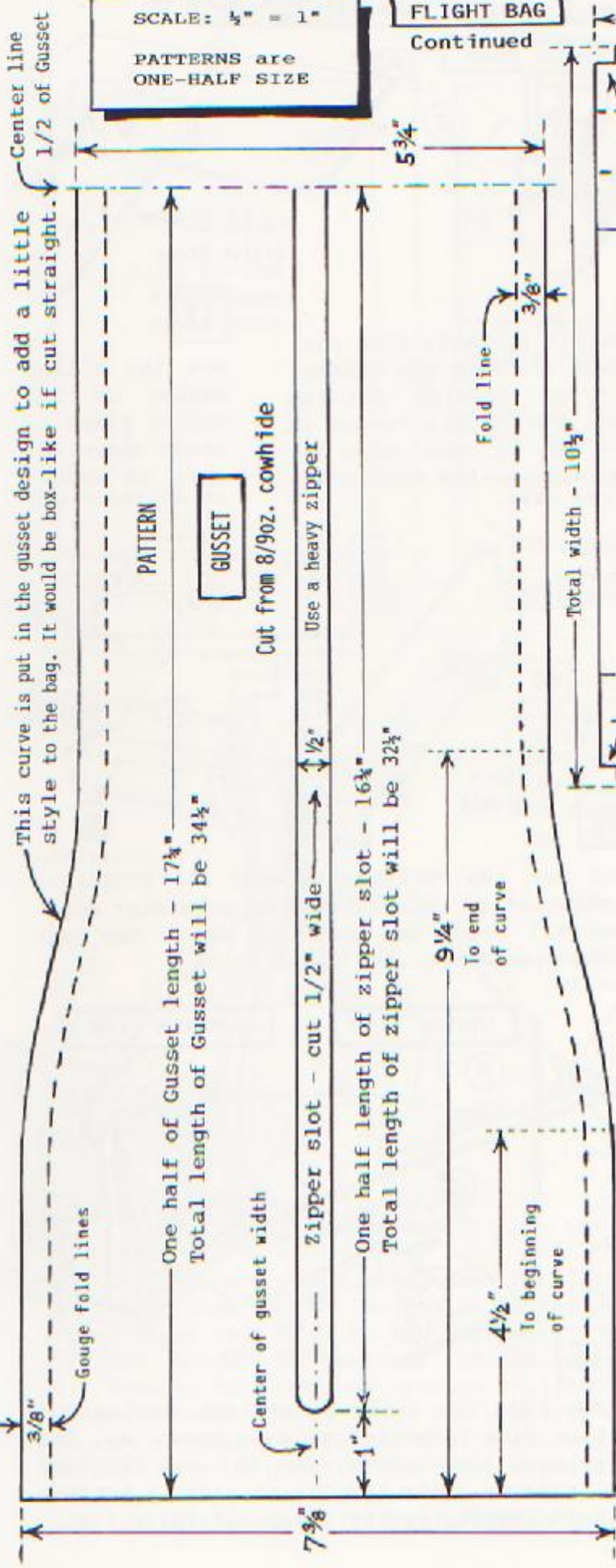
Measure 6-7/8" to the
 opposite fold line

Total
 dimensions
 of the
 bag

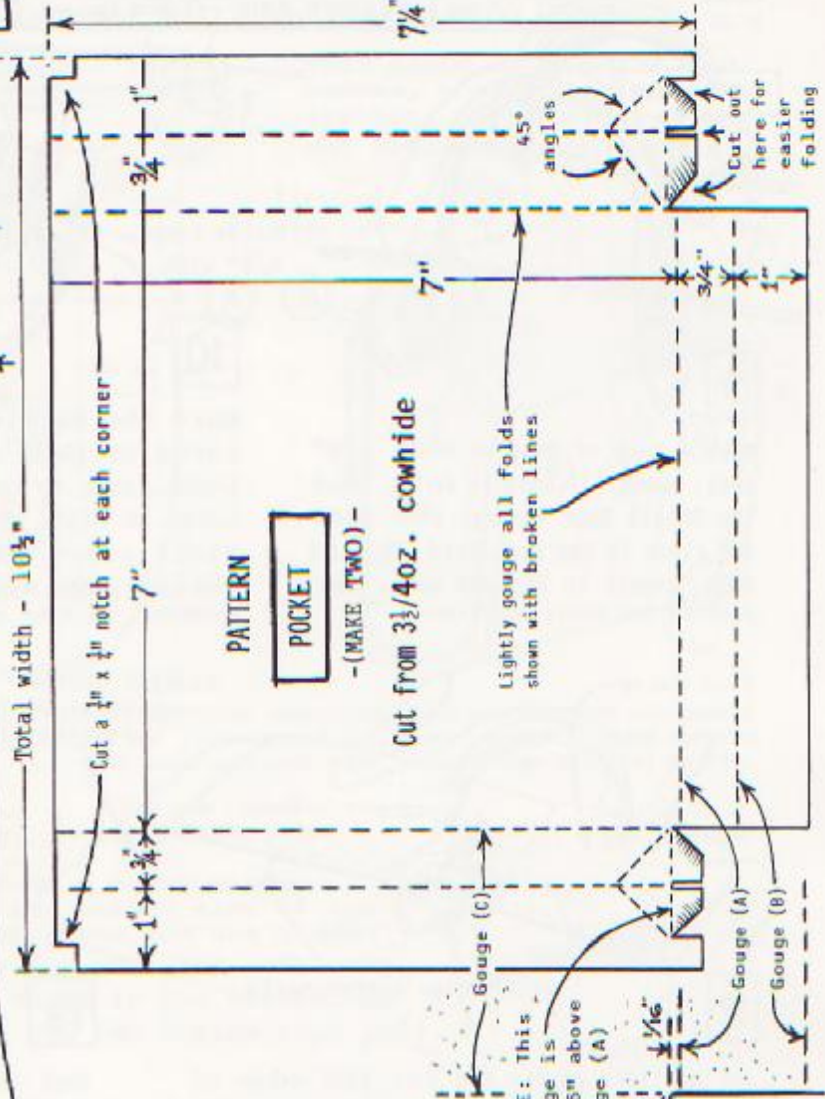


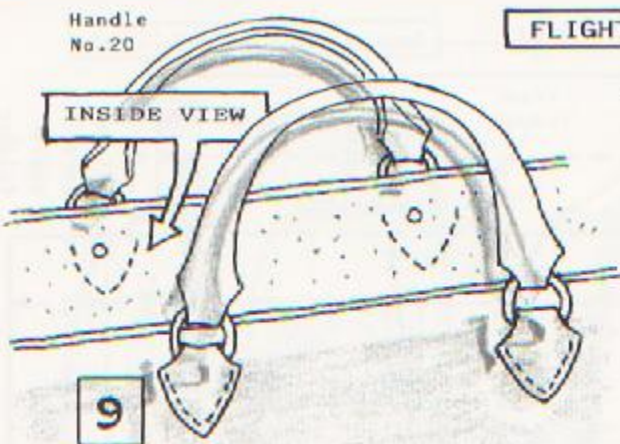
SCALE: $\frac{1}{2}'' = 1''$
 PATTERNS are
 ONE-HALF SIZE

FLIGHT BAG
 Continued

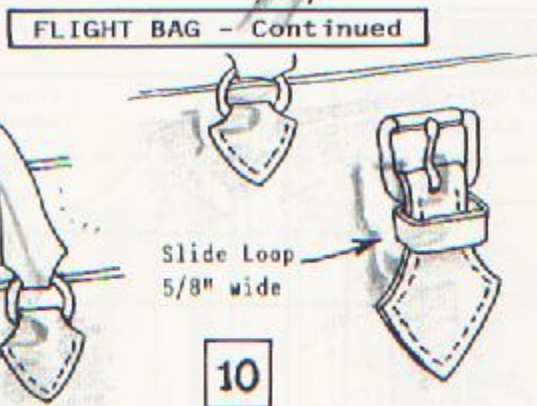


NOTE: Before cutting the pocket pattern. Experiment with scrap leather with the corner folds so you fully understand the folding procedures. Read the instructions.

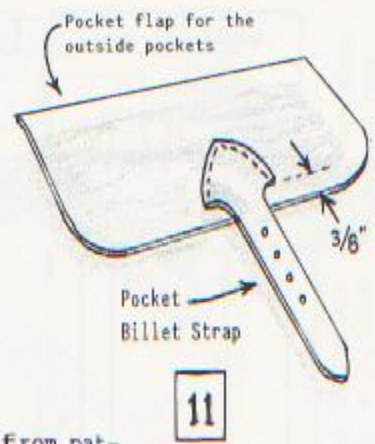




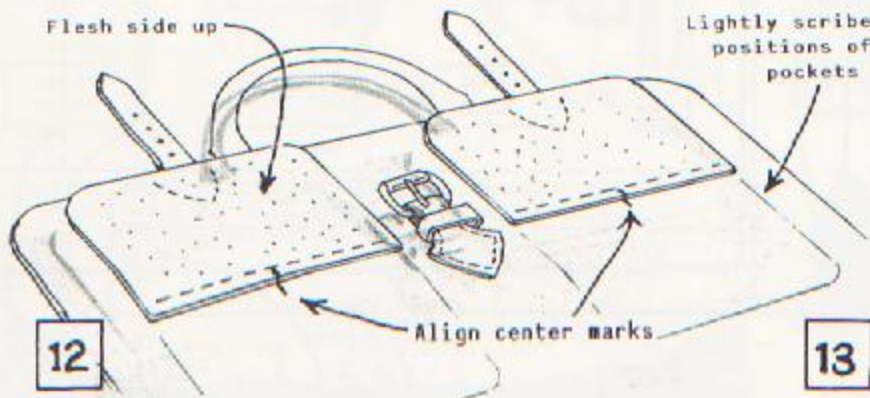
Make a pair of handles with $7/8$ " dees, about 13" fold to fold. Put the Shield Tabs through the dees and rivet to the bag. Fold Shield down, cement to bag and sew. See pattern for their positions.



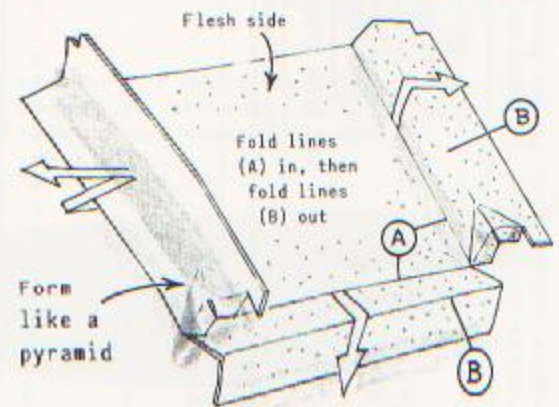
Make the Buckle Assembly from patterns on page 17. Make the Leather Loop from $6/7$ oz. cowhide. Put the Loop on Tab. Put buckle tongue in slot; rivet Tab to case. Glue the Shield down and sew the Buckle Assembly to the case.



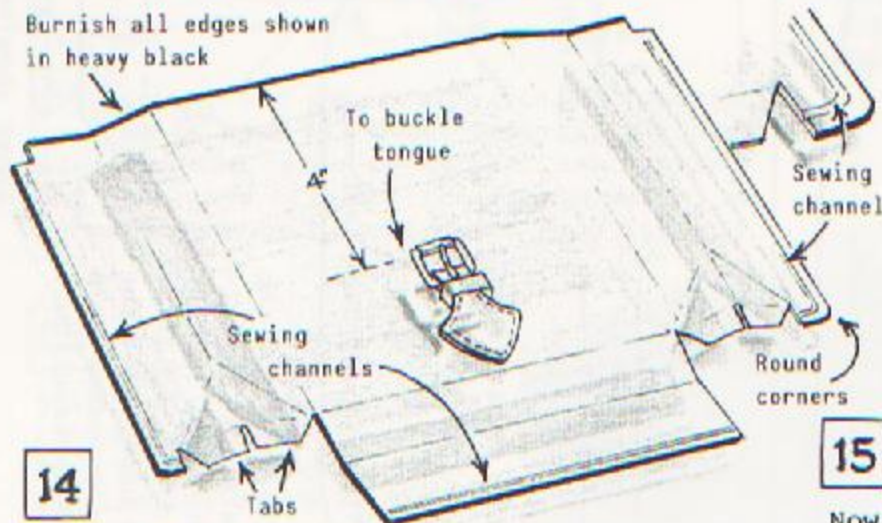
Sew the billet straps on the Pocket Flaps as shown above. Be sure to center it on the Flap.



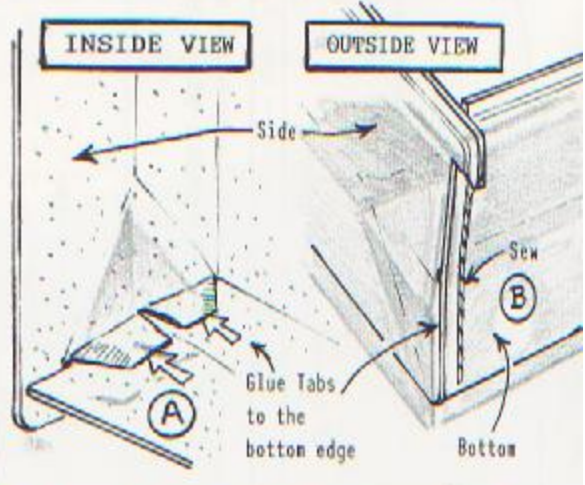
Scribe lines on the bag for the edge of the Pocket Flaps. See pattern on page 14 for proper locations. Cement the edges of the Flaps in place and sew.



Cut out the Pockets and make all gouges as indicated on the pattern. Be accurate! Moisten all folds and shape as above. Tap each fold line down...for sharp folds.

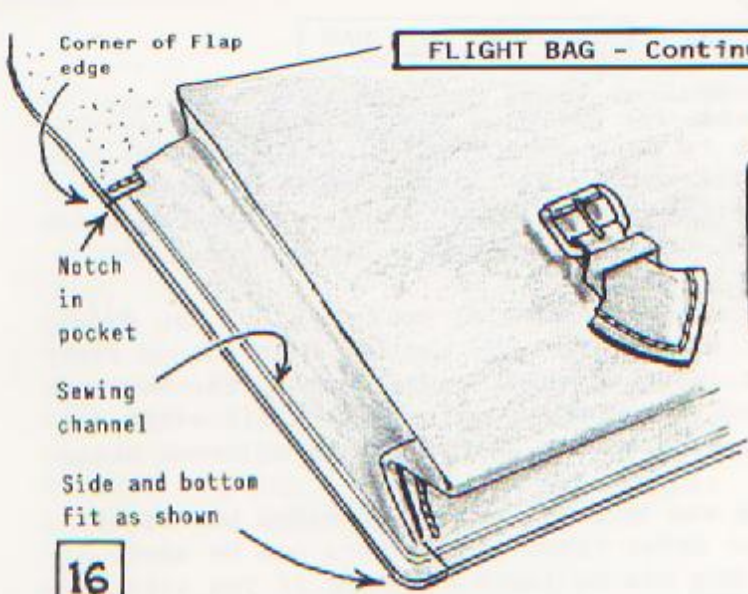


Lay the Pocket out flat. Burnish the edges, gouge sewing channels. Install the Buckle Assembly (as in step 10). Cut leather Slide Loop from $4/5$ oz. cowhide.



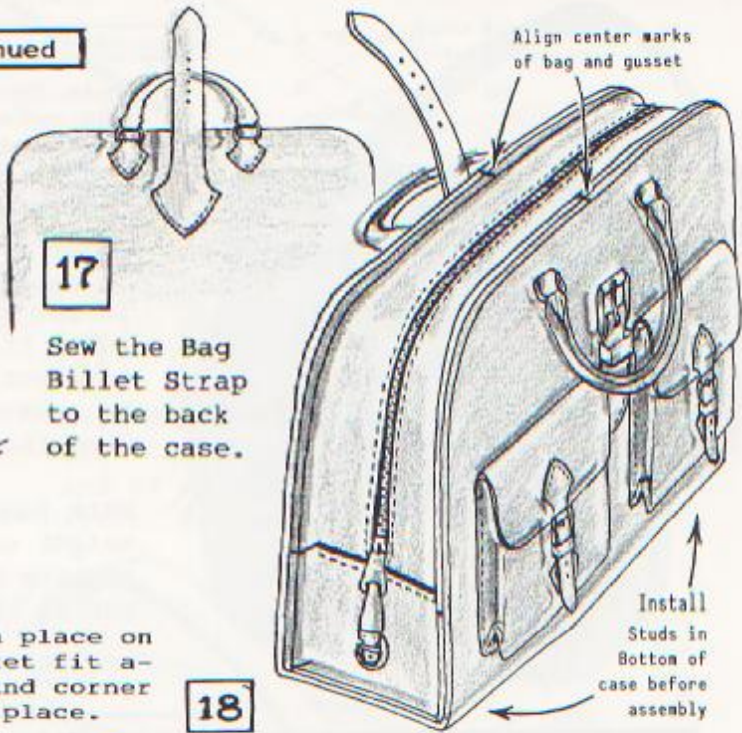
Now fold the sides in against the bottom. Glue Tabs to bottom edge as shown (A). Sew through the bottom edge (B) and the Tabs inside to unite the Gusset sides & bottom. Fold Pocket together, tap all folds flat.

FLIGHT BAG - Continued



16

Fold the Pocket together and cement it in place on the Bag. Note how the notches in the Pocket fit against the edge of the Flap. The bottom and corner should fit as shown. Sew both Pockets in place.

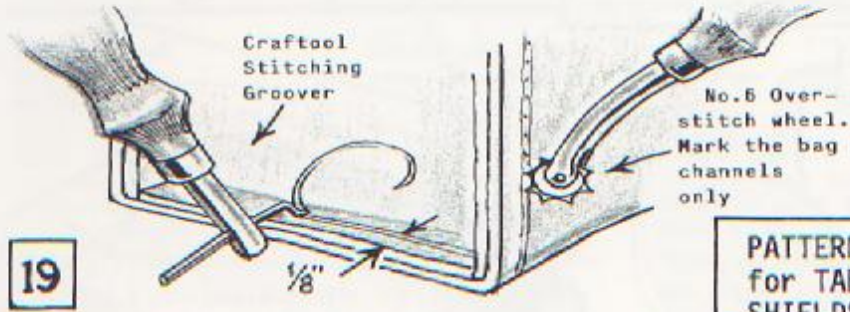


17

Sew the Bag Billet Strap to the back of the case.

18

Now cement the Gusset back in the Bag. Align all edges as evenly as possible. Tap with a hammer to insure adhesion.



19

Gouge sewing channels in the gusset and the Bag, about 1/8" in from the edges. Sew Bag together. Burnish all edges.

PATTERNS for TABS SHIELDS & BILLET STRAPS

SEE INSTRUCTIONS FOR ASSEMBLY

For 3/4" buckle
7/8oz. cowhide
MAKE TWO

For 7/8" dee
7/8oz. cowhide
MAKE FOUR

For 1 1/4" buckle
8/9oz. cowhide
MAKE ONE

BAG BILLET - cut from 8/9oz. cowhide
MAKE ONE

Use this SHIELD PATTERN for the Billet Strap.

Use this SHIELD PATTERN for the Billet Strap.

Labels in diagram: Skive, Rivet holes, 7/8", Fold, 1/4", Buckle tongue slot, POSITION OF SLIDE LOOP, Sewing channels, Space holes 1/2" apart, 3/4", 5 5/8", 1 7/8", 18", 1 1/4", 3 1/2".

11" x 12" x 5"

Shoulder TOTE BAG



This is a large roomy bag with an added pocket on the outside for carrying smaller items or articles you wish to keep separated. It features some special construction techniques that we have never before offered. It is all welt constructed which makes for durable seams and a more stylish look.

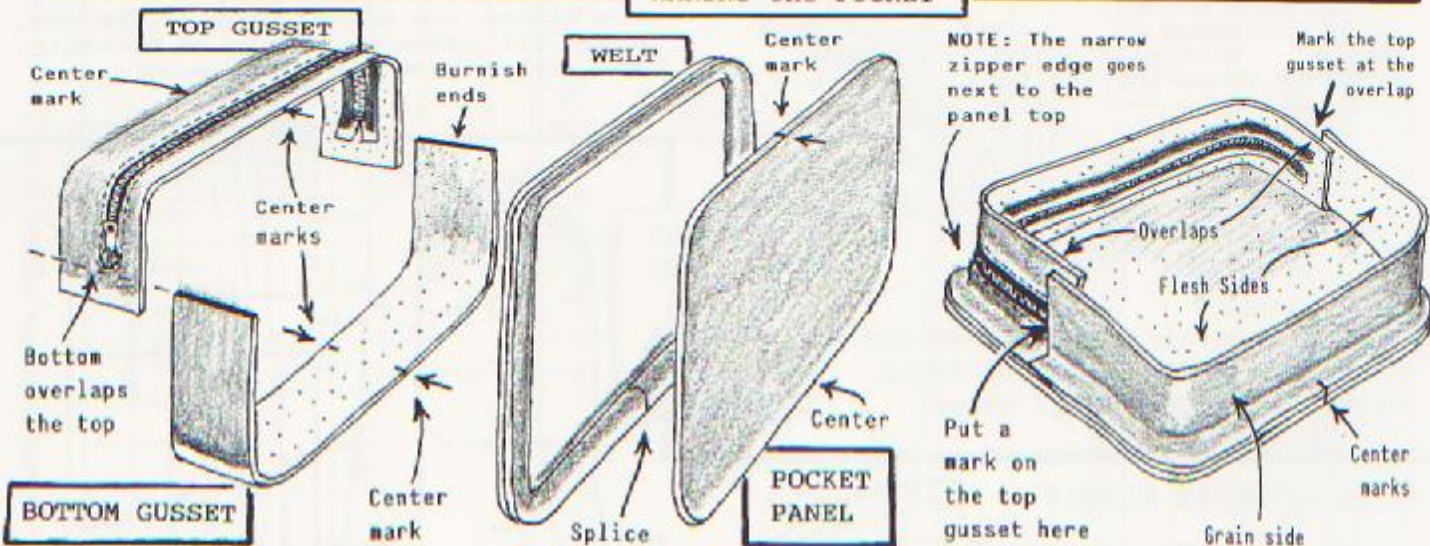
If you carve a design on your bag, do not dye or color it until after the bag has been turned right side out. With the welt construction, the bag must be soaked in water to turn it and this might subject the dyes to run or bleed into adjacent areas.

This bag was made of 6/7oz. cowhide, but lighter-weight or other types of leathers can be used. Also, the bag can be laced together if you like this better than the welt construction (see page 23).

Follow the step-by-step instructions carefully!

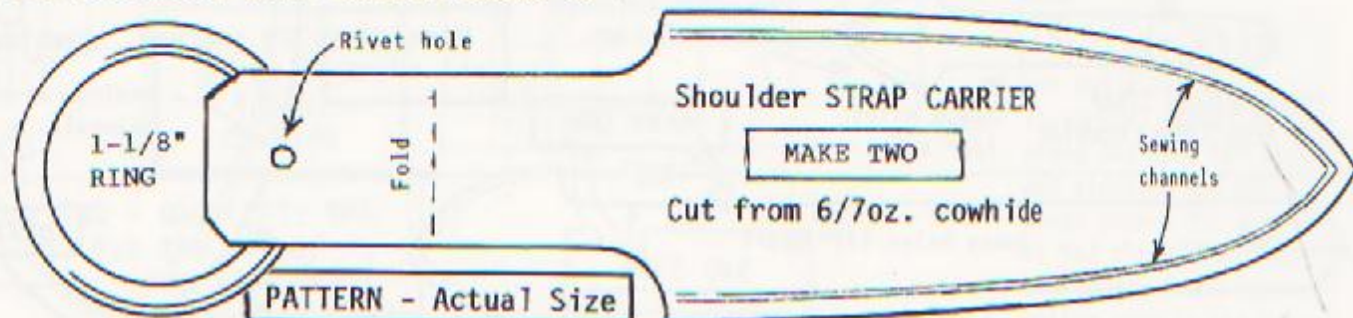
Carving Design*

MAKING the POCKET



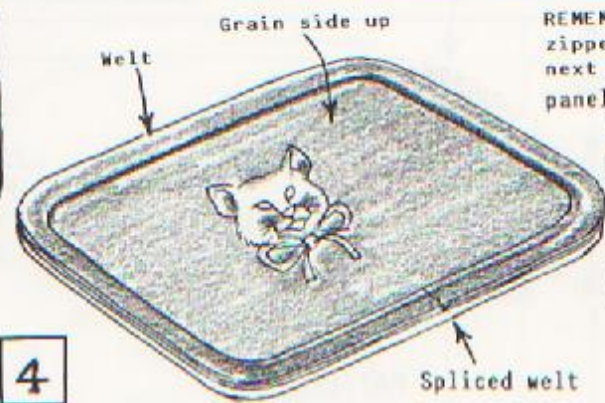
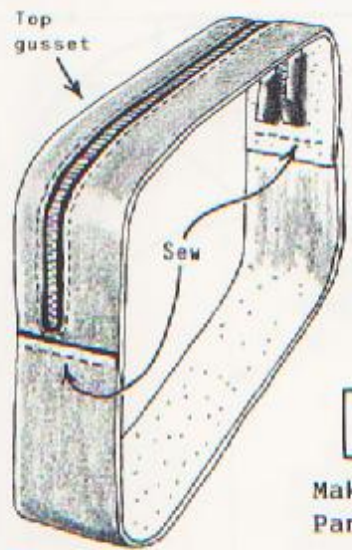
1 Cut out the parts from the patterns on pages 19, 20. Carve & stamp the panel. Skive the gusset ends as indicated on the patterns. Sew a light zipper in the gusset. Burnish ends of the bottom gusset. Make a welt from 3/4oz. cowhide or other similar weight leather. A colored leather could be used for contrast. Welt length; about 38".

2 To establish the correct positions of the gussets, first cement the Top Gusset to the top of the Panel. Next, cement the Bottom Gusset in place. Begin adhering at the center marks. Where the Bottom Gusset overlaps, put a mark on the Top Gusset at each side. Observe the sketch above.

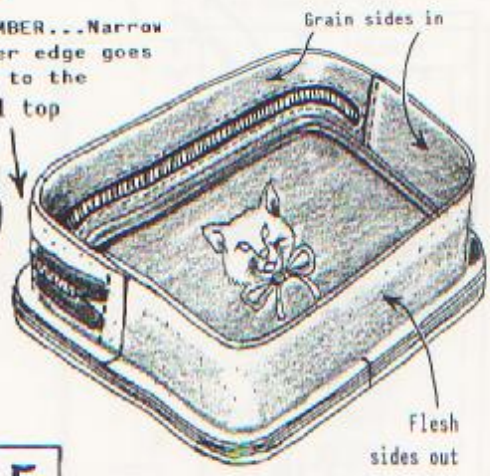


*BOUQUET: From various Garden Books. Stamping is Inverted

TOTE BAG - Continued



REMEMBER...Narrow zipper edge goes next to the panel top



4

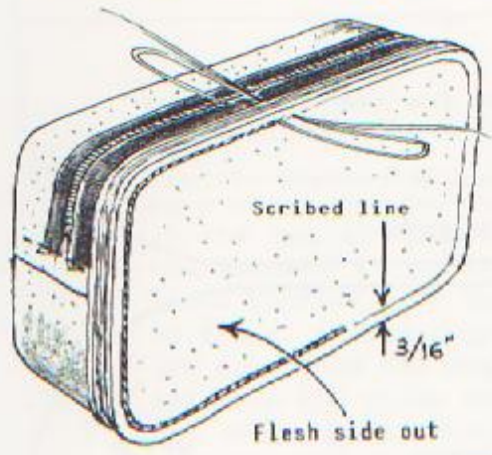
Make the Walt and cement it to the Panel. The splice is at bottom.

5

Now cement the Gusset Assembly to the Walt on the pocket Panel. Use the center marks to insure proper position, as in step 2. Only this time, grain sides are in (above).

3

Now peel the Gussets loose from the Panel and burnish the ends of the Bottom Gusset. Gouge a sewing channel on each end. Glue ends of the Bottom Gusset to the Top Gusset at the marks from step 2. Sew the ends in place. Observe sketch above.



6

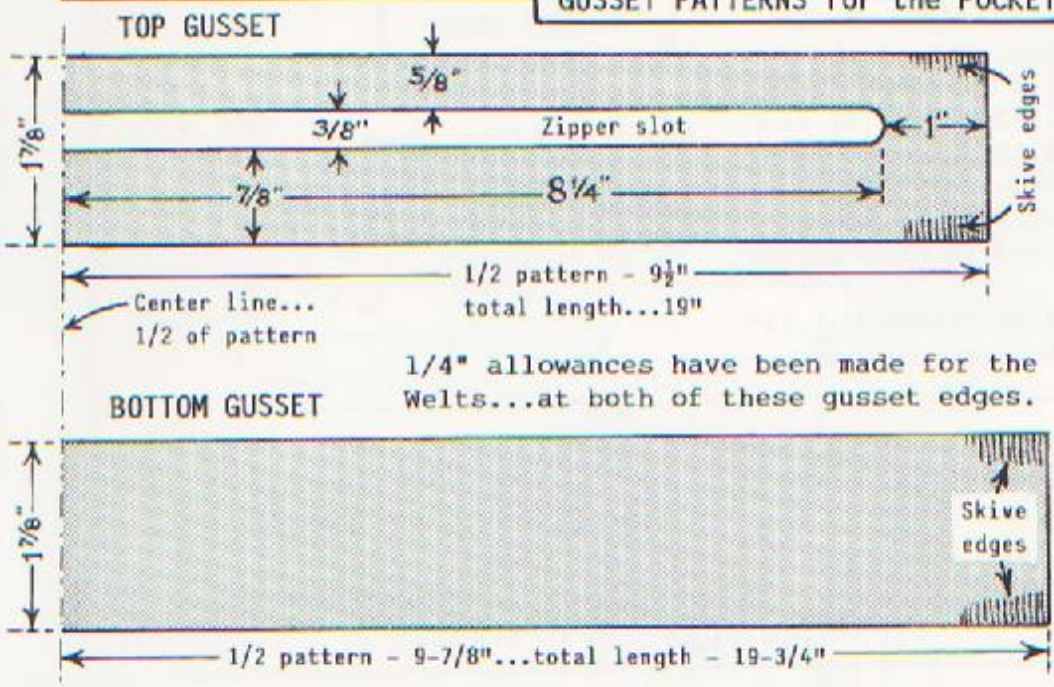
Scribe a line 3/16" from the edge, on both sides. "Wheel" the line on the Panel side and sew the parts together. Trim off excess Walt.

7

Submerge the project under water and quickly remove it. Then just hold sewn edges under until soaked. Turn pocket right side out and tap WELTS to flatten the seam. Now shape the Gussets and remove any wrinkles. Set aside to dry.



GUSSET PATTERNS for the POCKET



SCALE: 1/2" = 1" PATTERNS are shown ONE-HALF SIZE

Cut both gussets from 4/5oz. cowhide

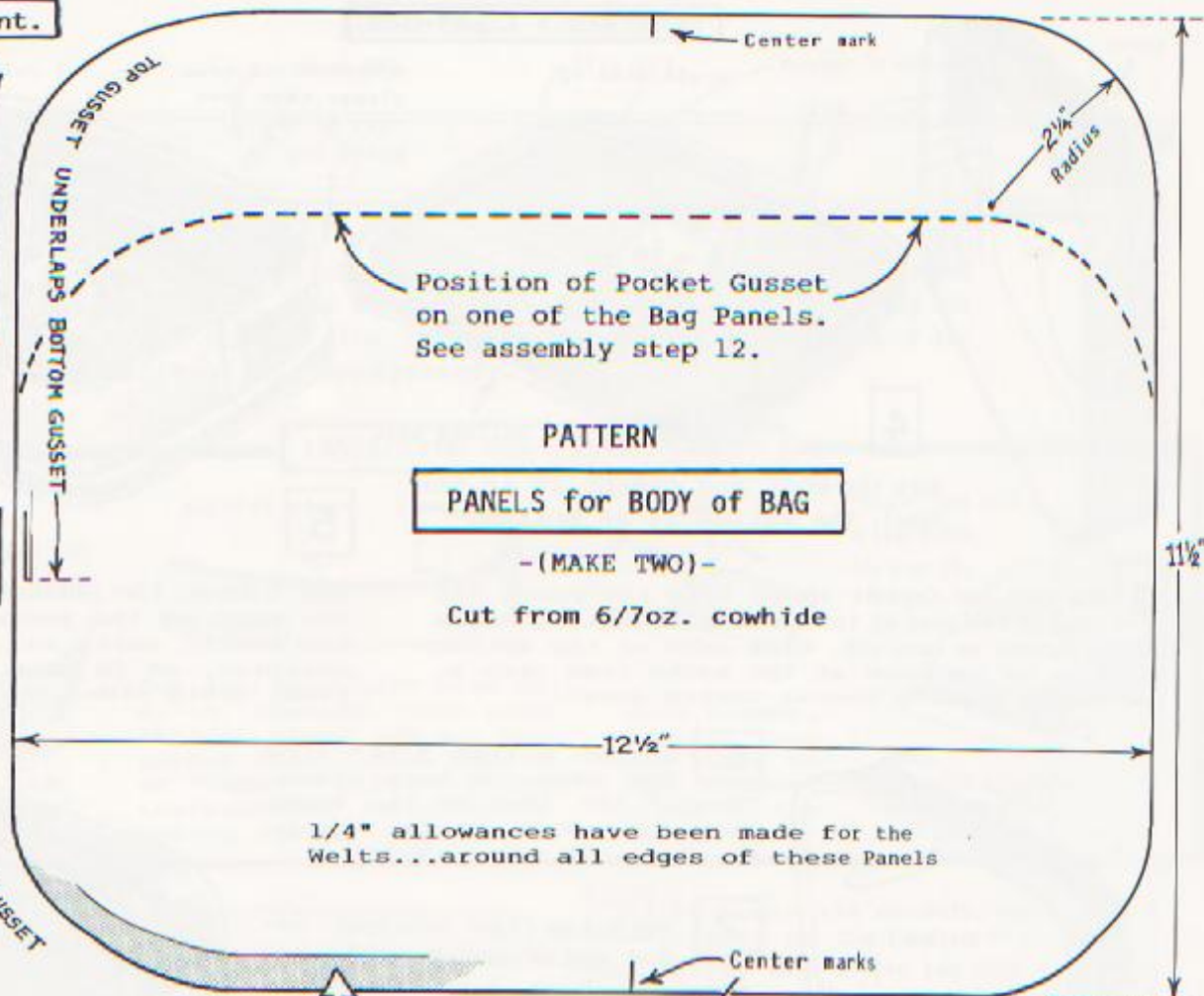
Observe all of the notations here for making the Gussets. About 1/2 the thickness must be skived off as indicated. Always skive from the flesh side. Notice that the zipper slot is not centered. Make a zipper 16 1/2" long from light zipper tape. Follow assembly steps 1, 2, 3. (continued on page 21)

TOTE BAG - Cont.

SCALE:
1/2" = 1"

PATTERNS
are shown
ONE-HALF
SIZE

BOTTOM GUSSET OVERLAPS
 ABOUT 3/4"
 TOP GUSSET



NOTE:

The Panels and the Gussets can be cut from lighter weight leathers if desired. It would make turning the welted seams right side out much easier. Colored leathers could be used for this bag. There are many varied and possible combinations.

SPECIAL NOTE:

For Welt construction, the thickness of most leathers over 4/5oz. should be skived off around the edges where the Welt goes. Make a gouge about 3/8" in from the edge and remove 1/3 to 1/2 of the thickness with a French Edge Tool. The edges of the gussets on the opposite page should also be skived in this manner.

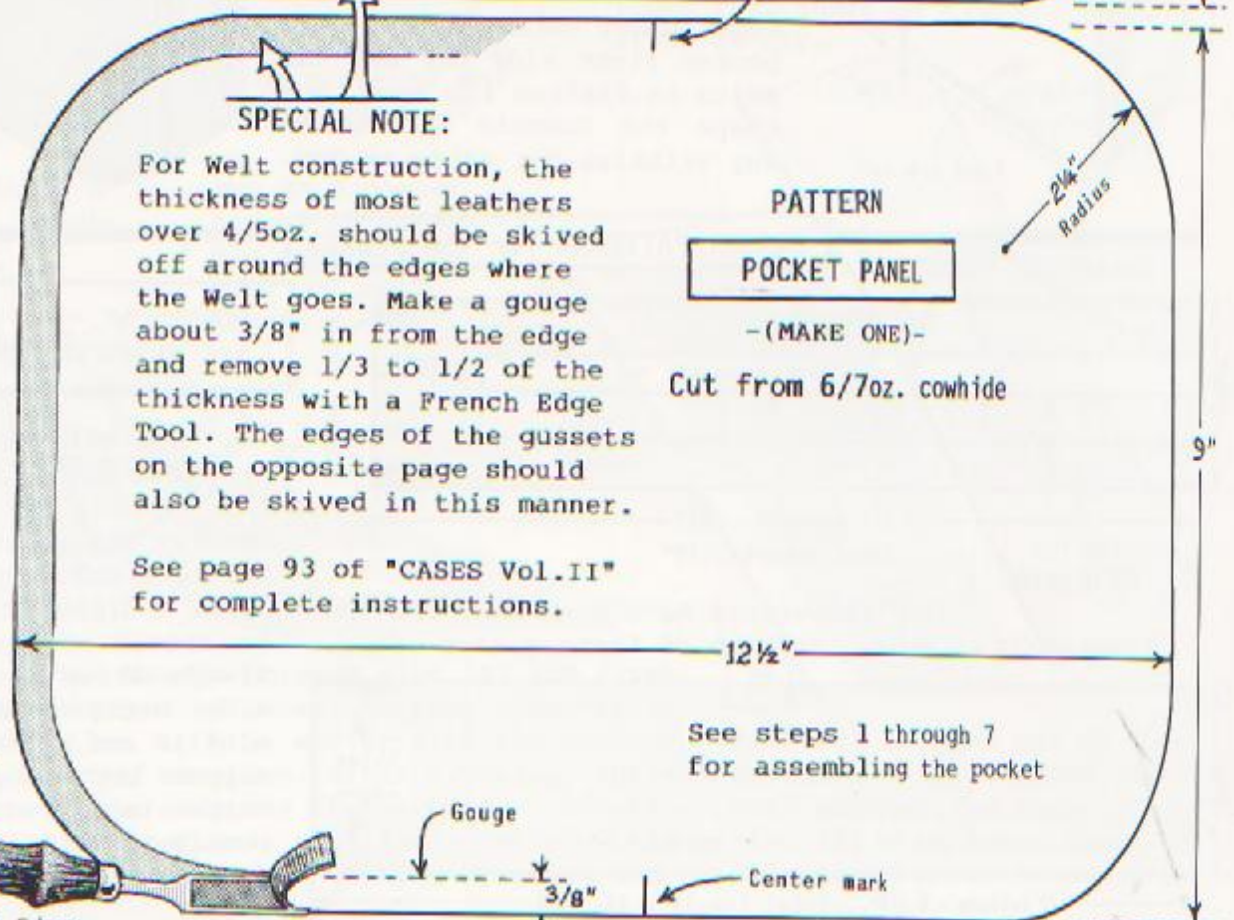
See page 93 of "CASES Vol. II" for complete instructions.

PATTERN

POCKET PANEL

-(MAKE ONE)-

Cut from 6/7oz. cowhide



French Edger

Gouge

3/8"

Center mark

GUSSET PATTERNS for the BAG

TOP GUSSET

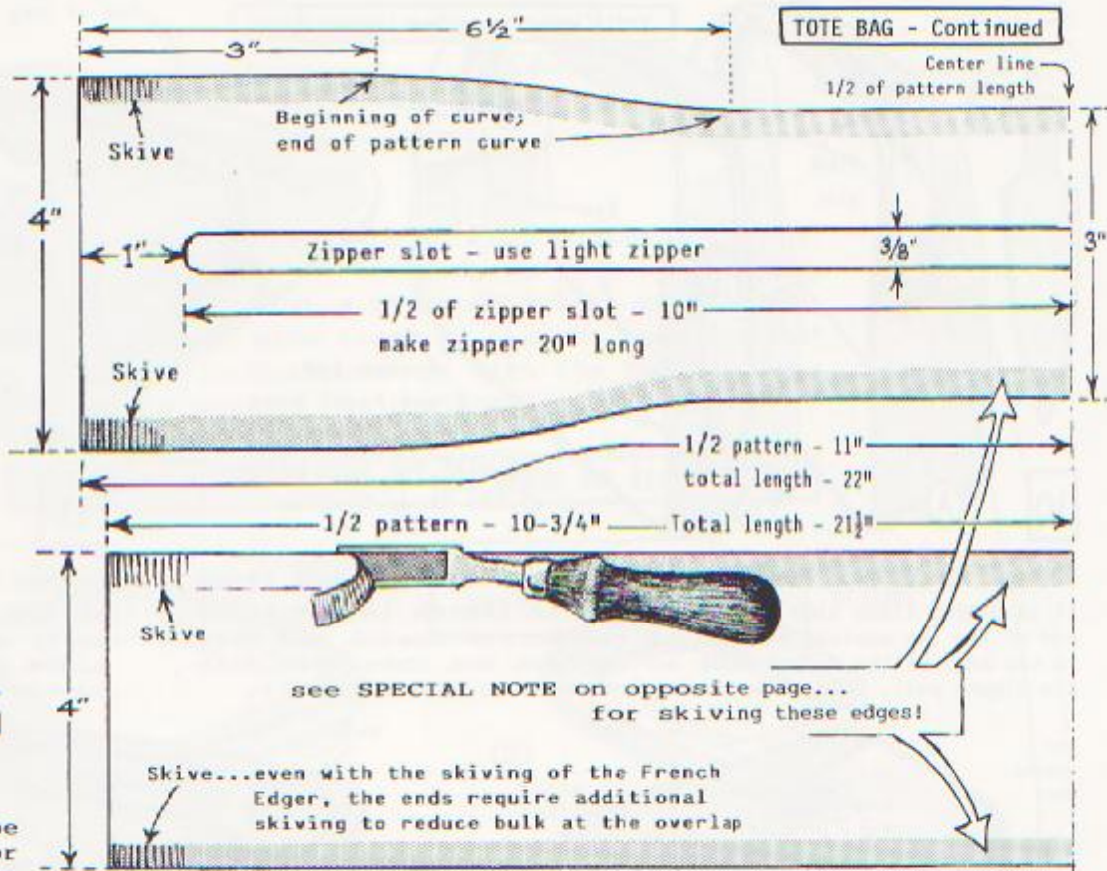
Cut from 6/7oz. cowhide

SCALE:
 $\frac{1}{2}'' = 1''$
PATTERNS
 are shown
ONE-HALF
SIZE

BOTTOM GUSSET

Cut from 6/7oz. cowhide

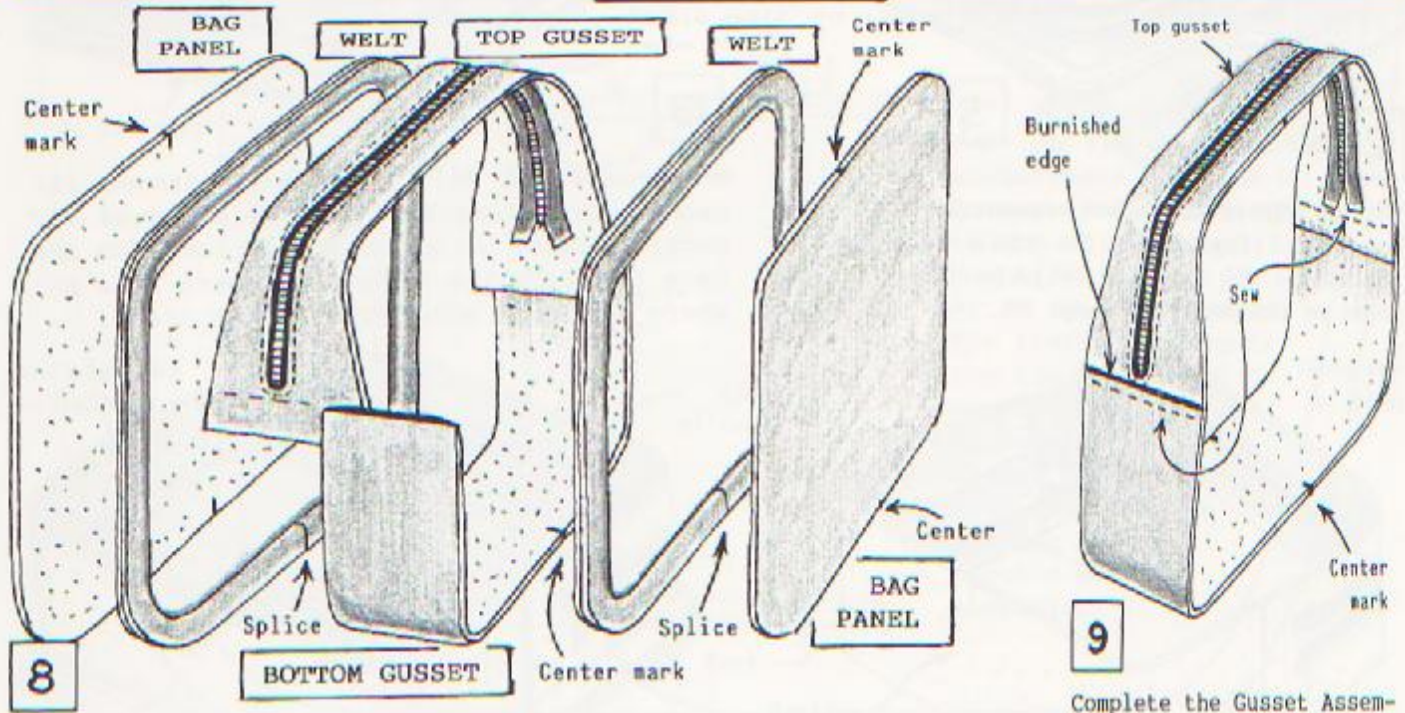
These gussets can be made from colored or lighter oz. leathers



TOTE BAG - Continued

see SPECIAL NOTE on opposite page... for skiving these edges!

MAKING the BAG

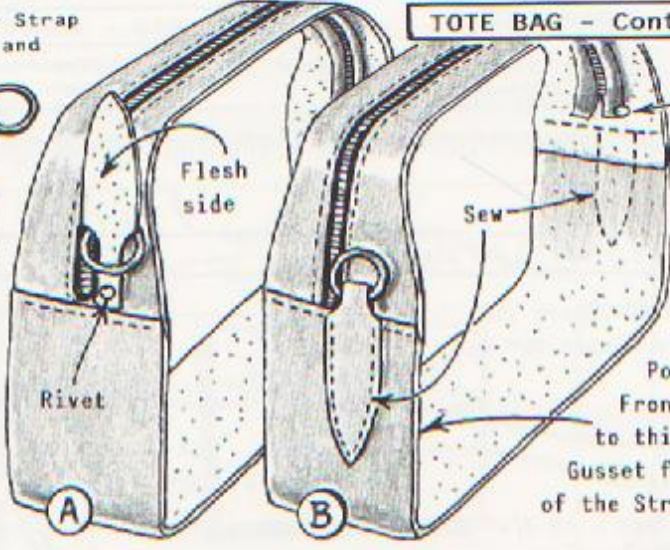


Cut out the parts for the bag from the patterns on page 20 and above. If you are going to carve the panels, do so before assembly. Make two Welts from 3/4oz. leather to go around the panels. Make them about 43" long. Skive the ends of the gussets as indicated on the patterns. Sew a zipper in the Top Gusset. Burnish the ends of the Bottom Gusset. Put center marks on both gussets and both panels, at edges.

Complete the Gusset Assembly by following the exact same instructions as steps 1, 2, 3. The Bottom Gusset overlaps the top and sews in place as shown above. (continued)

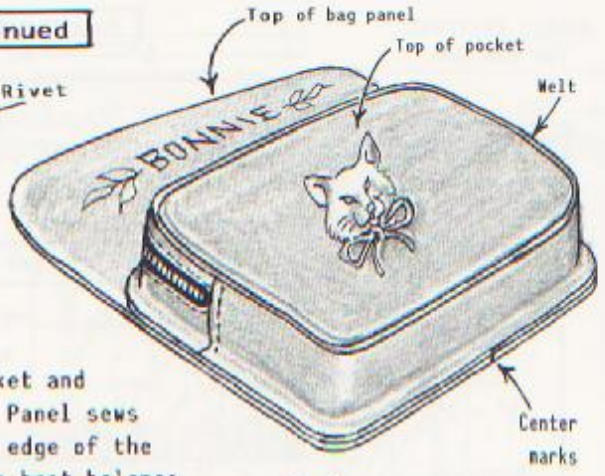
TOTE BAG - Continued

Shoulder Strap Carrier and ring



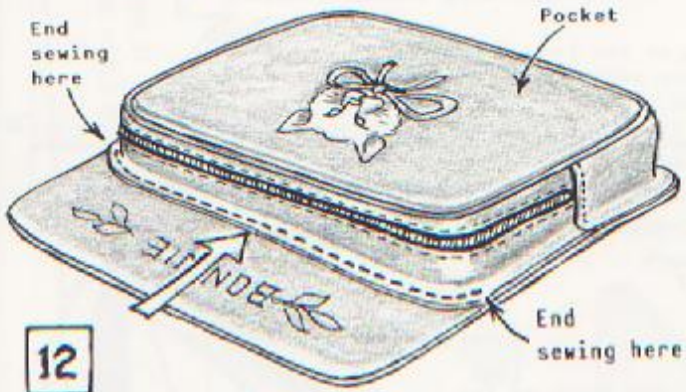
10

Now put the ring on the tab of the Strap Carrier and rivet it in place, flesh side out, as shown in sketch (A). Put the end of the tab against the end of the Bottom Gusset and next to the edge of the zipper slot so it does not interfere with the zipper pull. Fold strap down and sew as shown in (B).



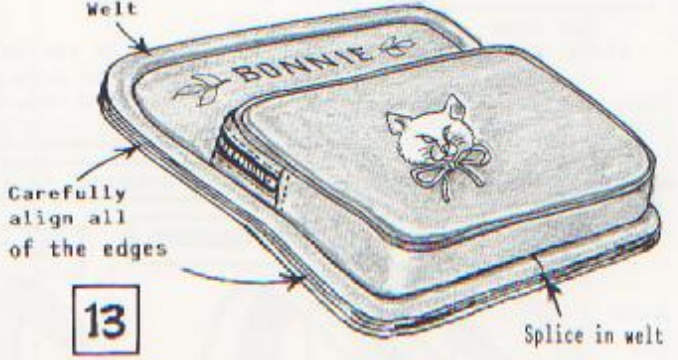
11

Cement the pocket to one of the bag panels. Carefully align the edges at sides and bottom. Use the center marks to aid.



12

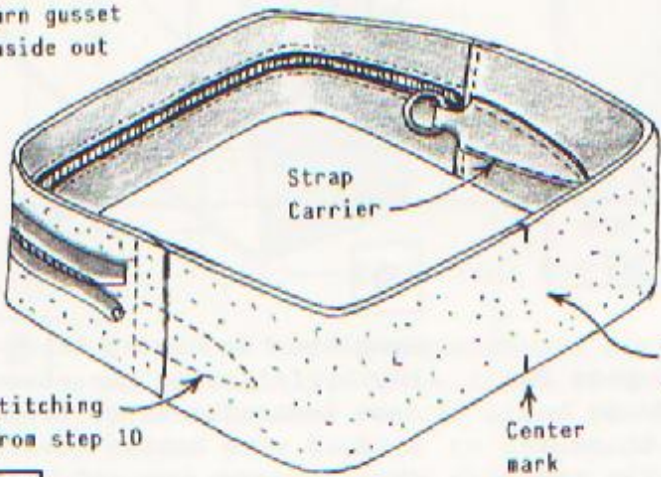
The top edge of the gusset cements to the bag panel (large arrow). Sew this edge to the panel. The position of this edge is shown on the pattern on page 20.



13

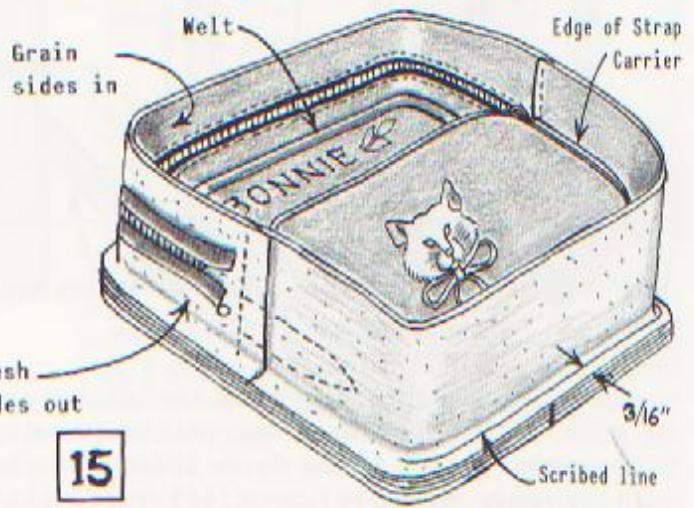
Now cement a welt completely around the panel. This cements over the edges of the pocket gusset at sides and bottom. You may have to force the gusset leathers in a bit where the welt adheres at these areas.

Turn gusset inside out



14

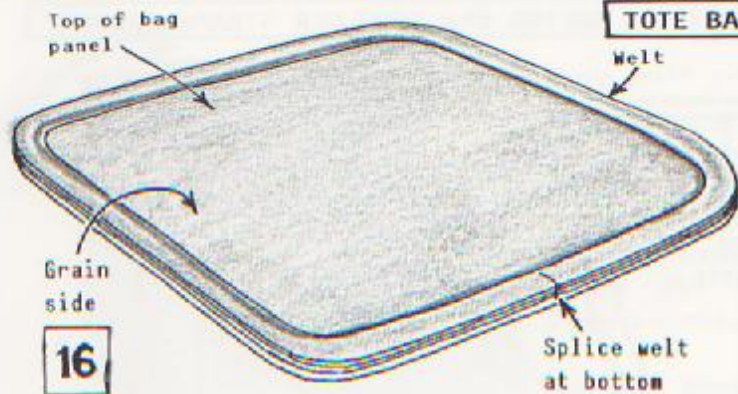
The gusset now cements to the pocket unit. Turn the gusset assembly inside out so Strap Carrier is at lower edge. This edge cements to the welt, step 15.



15

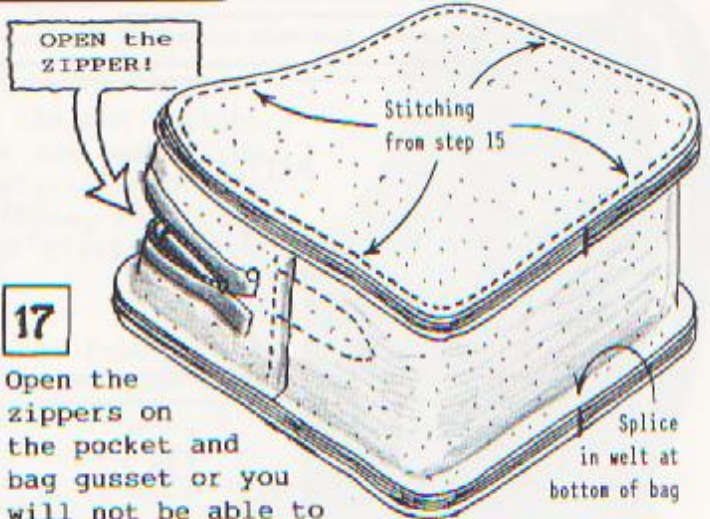
Cement the gusset edge to the welt on the pocket assembly. The pocket will be a tight fit within the gusset. Scribe guide lines as in step 6, page 19. Sew unit together.

TOTE BAG - Continued



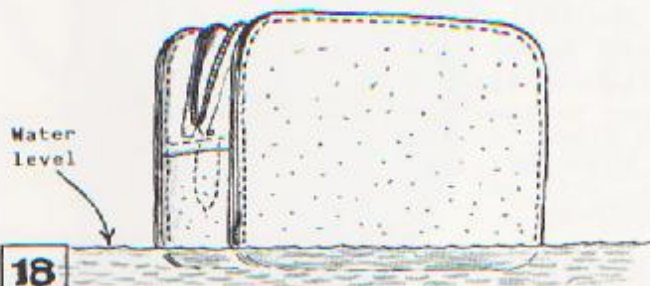
16

Cement the other welt to the other bag panel...the same as in step 4.



17

Open the zippers on the pocket and bag gusset or you will not be able to turn the bag right side out. Turn the project over (from step 15). Cement it to the welt on the other panel (step 16). When properly aligned tap all edges for better adhesion. Sew the edges together as in steps 6 & 15. Trim off the excess welt. The bag is now ready to be turned.



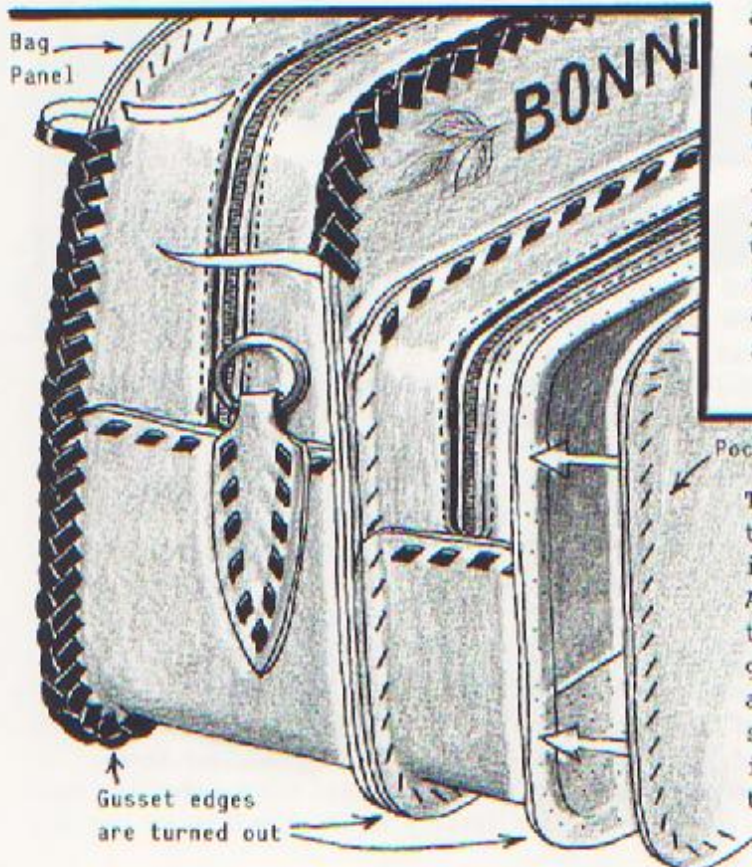
18

Submerge the project underwater until it is good and wet. Remove...and drain the water out of the bag. Now hold the bag in the water (as above) so only the welted seams remain submerged. Rotate the bag until all seams are thoroughly soaked. Remove from the water, drain out all water from the inside.

19

Now the bag must be turned right side out, through the zipper opening of the bag. Use care not to force or unduly stretch any of the panels or gussets. Take your time...the bag will come through the opening. Once turned you will have to reach inside the bag to tap the two bag welts as flat as possible. Being wet, it is easily accessible.

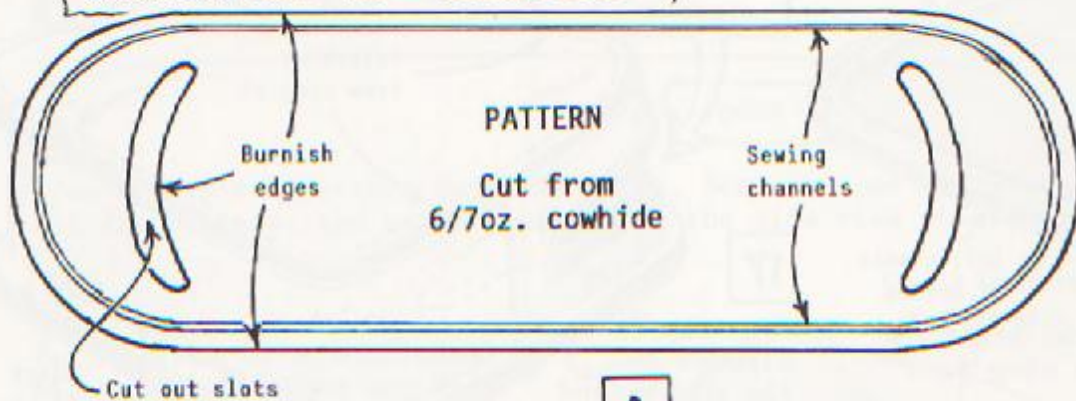
Now begin straightening the welted seams and shaping the bag. Smooth out any wrinkles that may appear in the panels or gussets. To aid in keeping its shape put towels, socks or other soft material inside. Allow the bag to dry. While drying, continue shaping as bag is drying. When dry, dyes and colors can be used.



ALTERNATE ASSEMBLY

The bag can be sewn or laced as shown here...by turning the edges of the gussets out instead of in, as for the welts. The same patterns are used. Also, the panels and gussets are gouged & skived the same as indicated on the patterns. Assemble gussets by sewing or lacing. Moisten the edges and fold them out as shown at left. Sew or buck-stitch the Pocket Gusset to the Bag Panel as in sketch. Cement units together a step at a time. Punch lacing slits and lace.

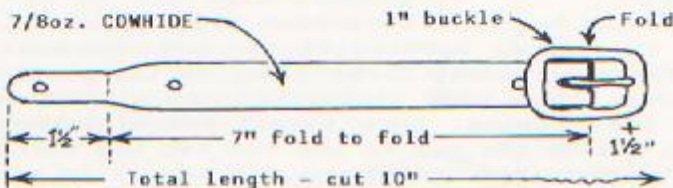
SHOULDER STRAP PAD - Actual Size



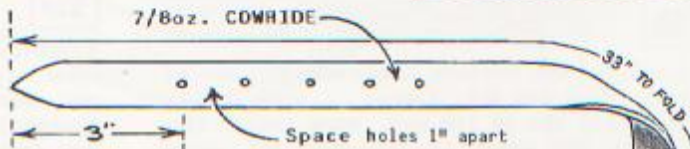
Apply cement only at shaded areas of suede and cowhide.

A

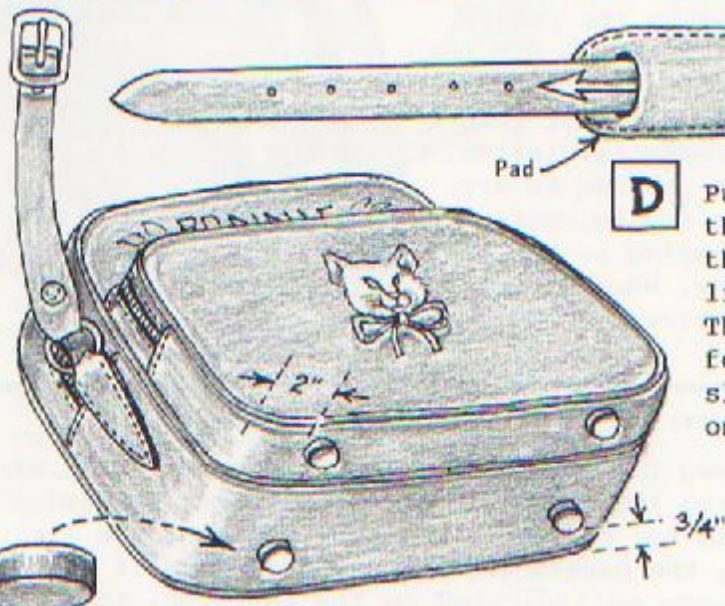
Prepare a Shoulder Strap Pad as indicated above. Cut another one (slightly larger) from 3/4oz. suede leather. Do not cut out the slots. Cement the two pieces together...sew around the edge. Trim off the excess suede leather.



B Cut a buckle strap 10" long from 7/8oz. cowhide. Shape both ends as per pattern (upper right). Burnish edges. Sew or rivet buckle to strap.



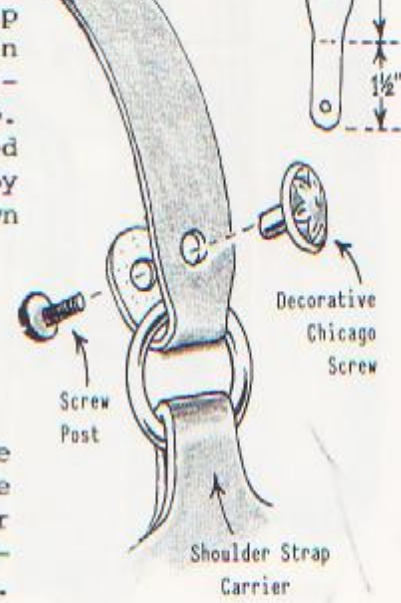
C Cut the shoulder strap 34 1/2" long from 7/8oz. cowhide. Shape ends as shown. Burnish edges. Punch the billet holes as indicated. NOTE: When making folds, always moisten the leather.



D

Push shoulder strap through the slots in the pad before buckling to other strap. The pad is adjusted for the shoulder by sliding up or down on the strap.

The Shoulder Strap unit



Leather Stud

If you want to put studs on the bottom of the bag, we suggest leather instead of metal. They serve the same purpose but will not mar the surface of furniture or other material. Punch out 1/2" circles from 12oz. cowhide. Glue them 3/4" from welts; 2" from ends of bag.

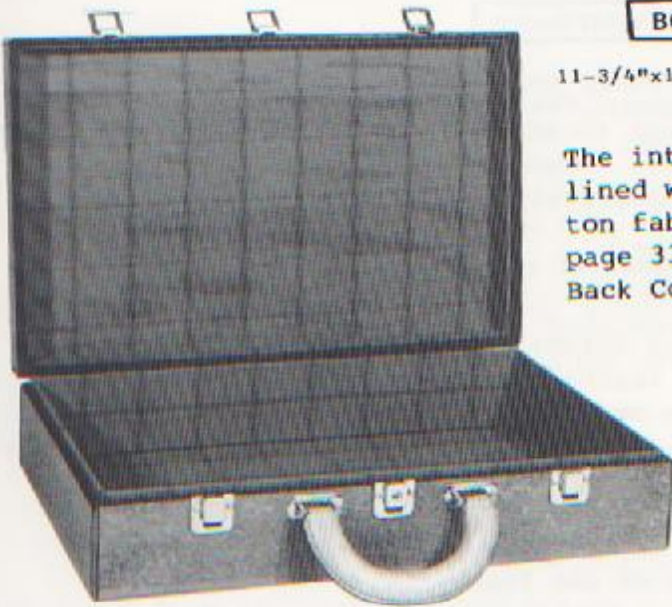
BOX CASES

11-3/4"x17-1/2"x4-3/4"

The interior is lined with cotton fabric. See page 33 and the Back Cover.



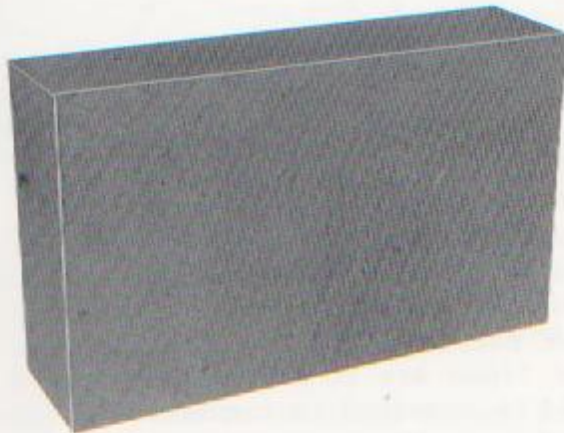
Carving Design*



This case is made by covering a wooden box with leather. The corners are sewn with the miter joints. For miter joint construction, the leather should be no lighter in weight than 7/8oz. The box for this case is made of 1/8" masonite (hardboard) with the same ma-

terial used inside as reinforcing. The reinforcing pieces can be left uncovered or covered with leather or cloth (as shown at left). The double wall wooden construction used here will add weight, but makes a very rigid and durable case.

NOTE: If a power saw is used in cutting off the lid...you must allow for the extra removal of wood by the saw cut when laying out your case dimensions.

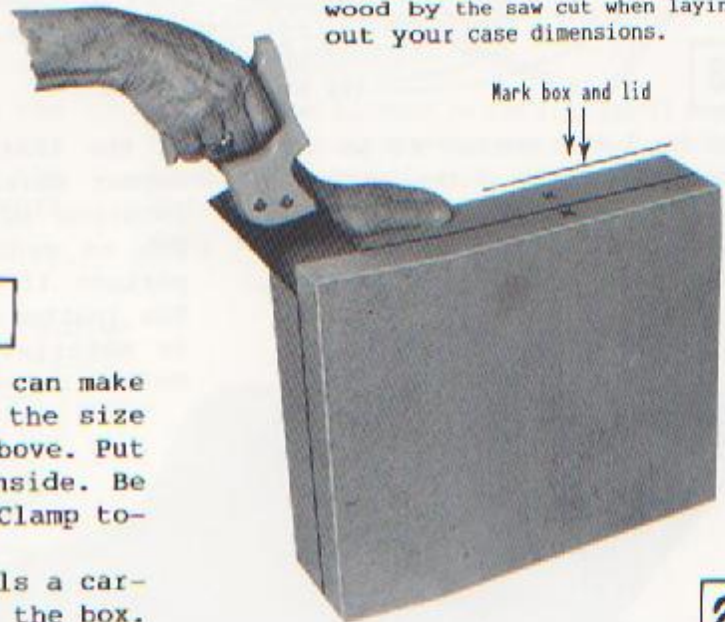


1

With these construction techniques you can make a case to any size desired. Determine the size of your case, and make a box as shown above. Put the smooth side of the wood on the inside. Be sure all joints are thoroughly glued. Clamp together until dry. Use white glue.

If you do not have the skills or tools a carpenter or cabinet maker can easily make the box. Our box was completely made with a hand saw. It is not as accurate as a power table saw but will produce satisfactory results by careful measuring and cutting. Observe photos at top of page.

The lid width is usually determined by the type of catches and handle assembly you use. All of the hinges and other hardware should be selected before proceeding. The size and shape of catches may influence carving, stamping, or border areas.

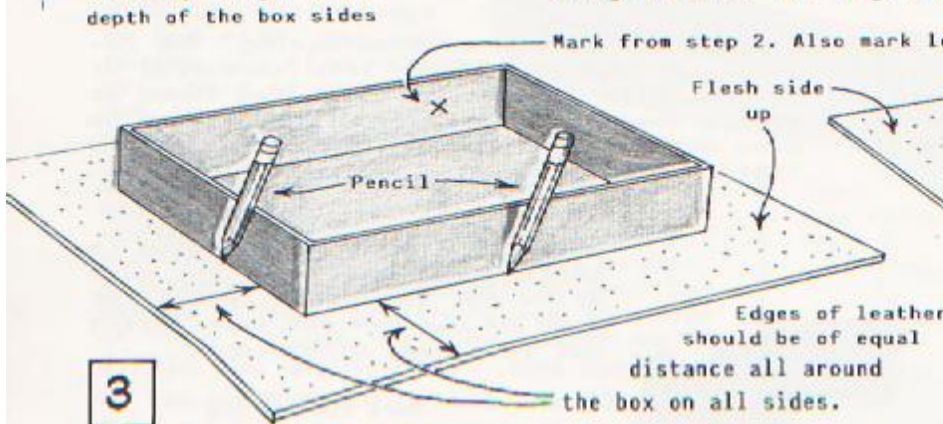
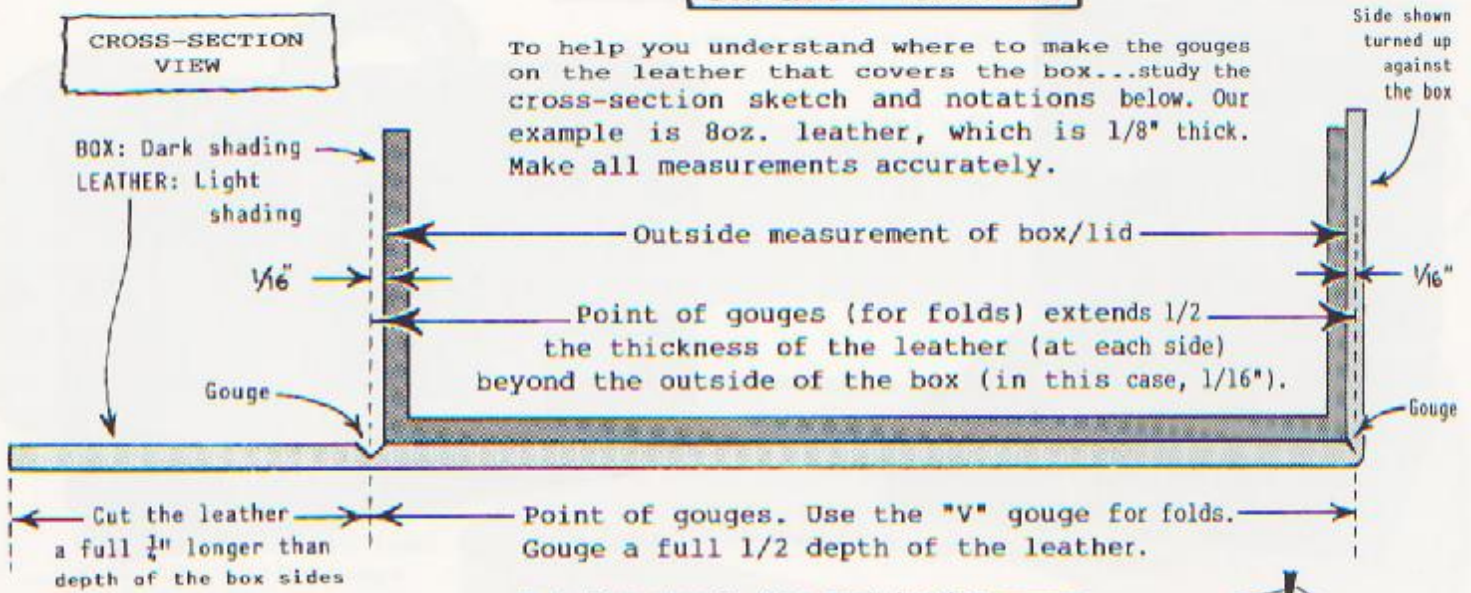


2

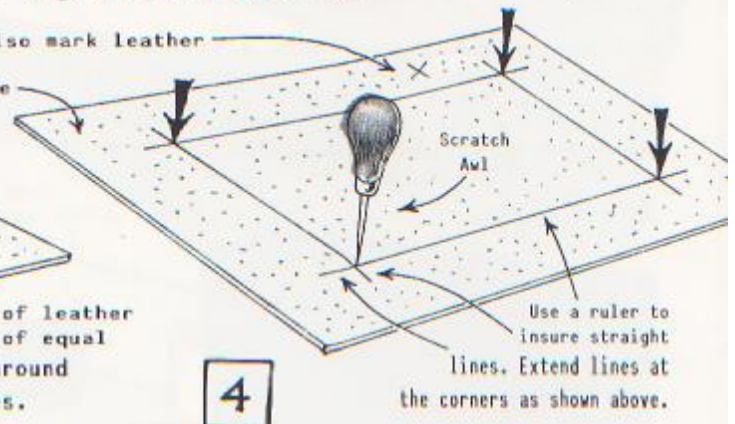
Draw a line for the lid evenly all around the box; cut off the lid. Put marks on the lid and box (above) so the lid can be fitted back on the box in the same position, during assembly. This is important for a good fit. Also put these marks on the inside of the box and the lid.

BOX CASES - Continued

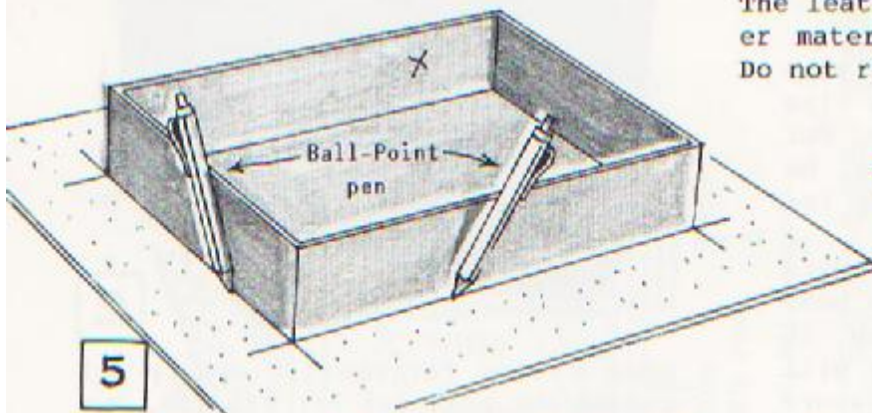
CROSS-SECTION VIEW



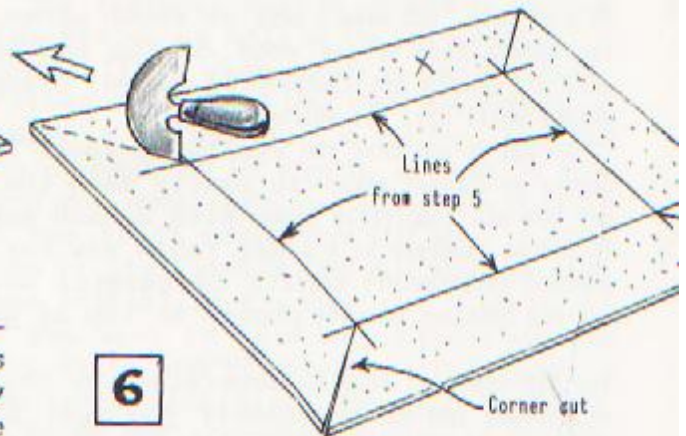
Cut the leather oversize to be sure of ample coverage at the sides of the box. Center the box (as shown) on the leather. Draw a line at each edge, close to the edge of the box.



If the leather is to be carved, stab holes at the corner marks through to the grain side. This gives location of folds on the opposite side...allowing you to center the pattern. This is especially important if border lines are to be cut and stamped. The leather should be cemented to cardboard or other material to prevent distortion while stamping. Do not remove leather until it is thoroughly dry!

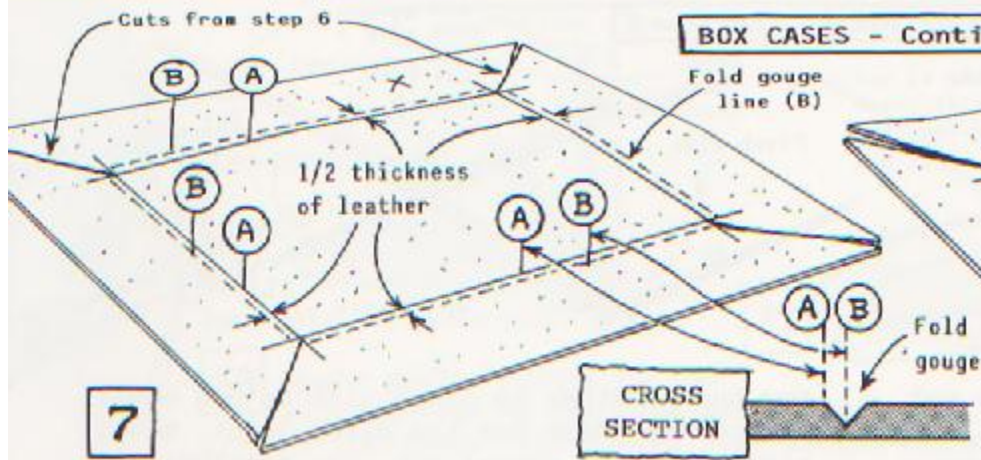


Turn the carved leather to flesh side up and again place the box in position. Check the lines and corner awl holes from steps 3 & 4. They may not be exactly in the same position as before due to stretch or shrinkage of the leather. Set the box as near to the awl holes as possible. Draw around the box again with ball-point pen to re-establish the lines.

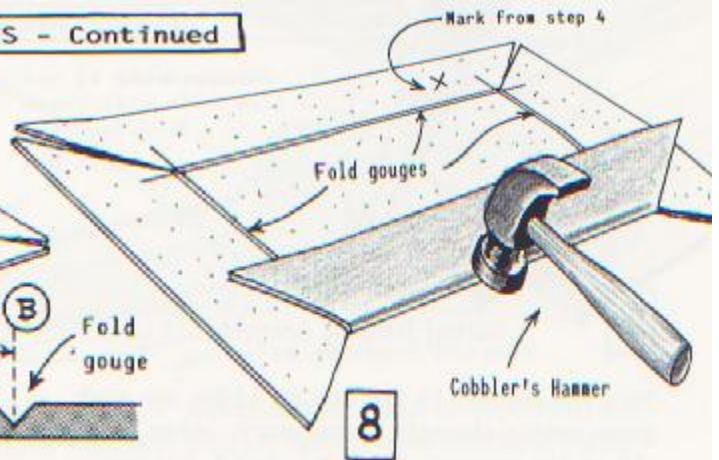


Remove the box. Now cut out from the last corner marks of the box (step 5) to the outside of the leather. Do not be concerned with the awl holes.

BOX CASES - Continued



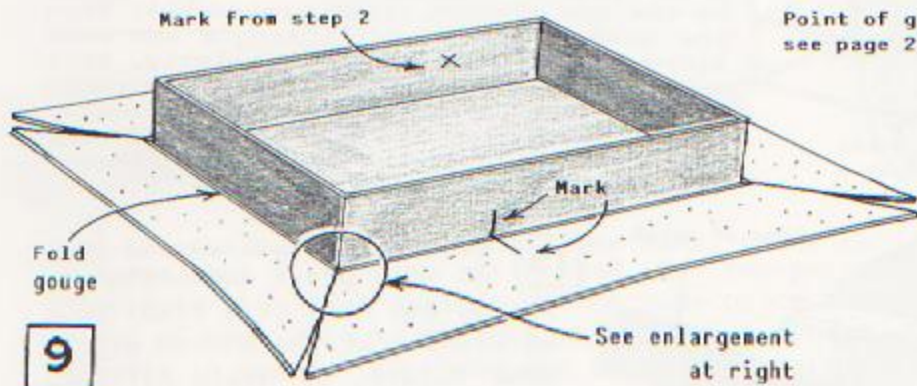
7



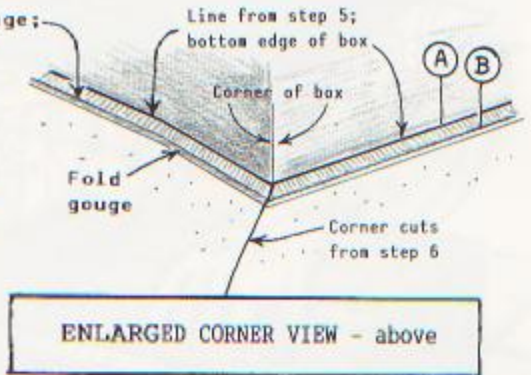
8

Lines (A) represent the edges of the box (step 5). The broken lines (B) are the point of the fold gouges, explained at the top of page 26. These are measured out from line (A)...equal to 1/2 of the leather thickness. Gouge lines (B) to a full 1/2 depth of the leather. The edge of beveled gouge should be right at line (A).

Now "wet" the gouges heavily on the flesh side, lightly on grain side. Taking one at a time, fold the sides in and tap firmly with a hammer to make clean folds. Lay back down to make next fold.

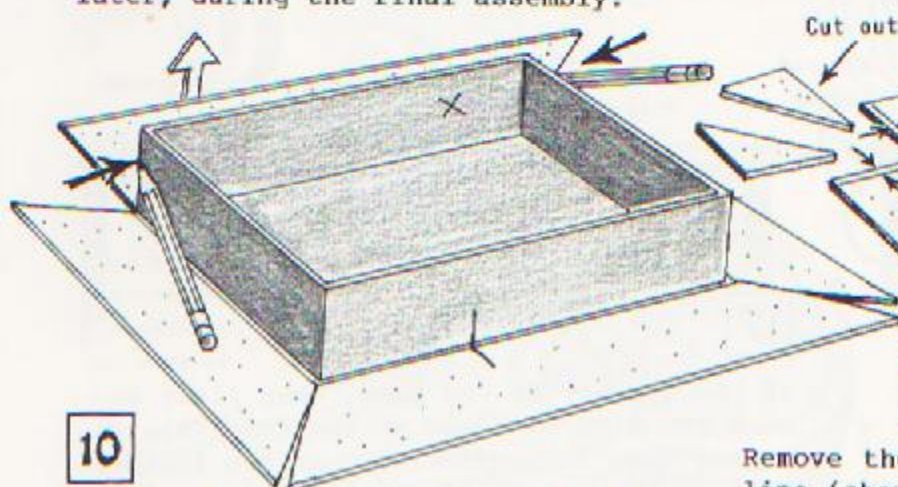


9



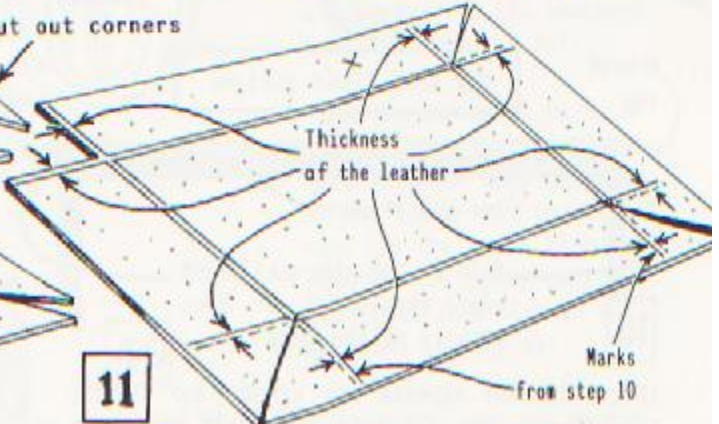
ENLARGED CORNER VIEW - above

Now lay the leather out flat again and replace the box. Be sure you have the marks from steps 2 & 4 in the same position as previous fittings. If all of your measurements and gougings have been accurate, the edges of the box should be right at the beveled edge of the gouges on line (A). See the enlarged view above. If all is in order, spot-glue the corners of the box to the leather. This is a temporary fitting. Place marks on the box and leather (above) so you can be sure box and leather can be returned to the same position later, during the final assembly.



10

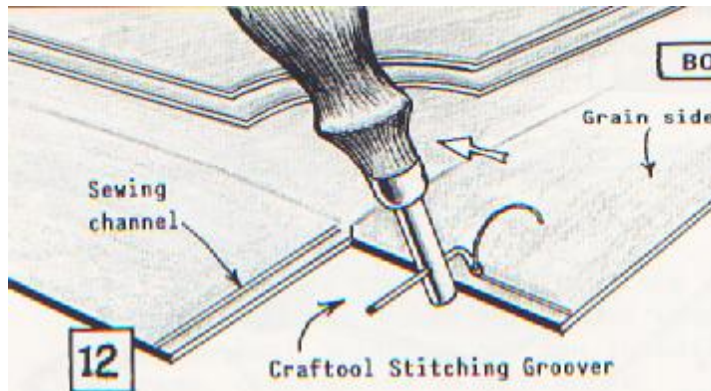
Fold sides up tightly against the box and draw a line flush with the corners. Repeat with each side.



11

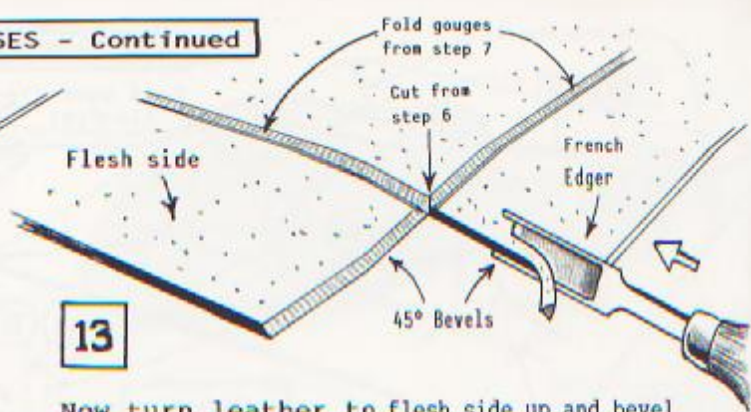
Remove the box. Lay leather flat. Draw a parallel line (shown broken) out from the marks in step 10, equal to the thickness of the leather. Cut out the corners on these lines. (continued)

BOX CASES - Continued



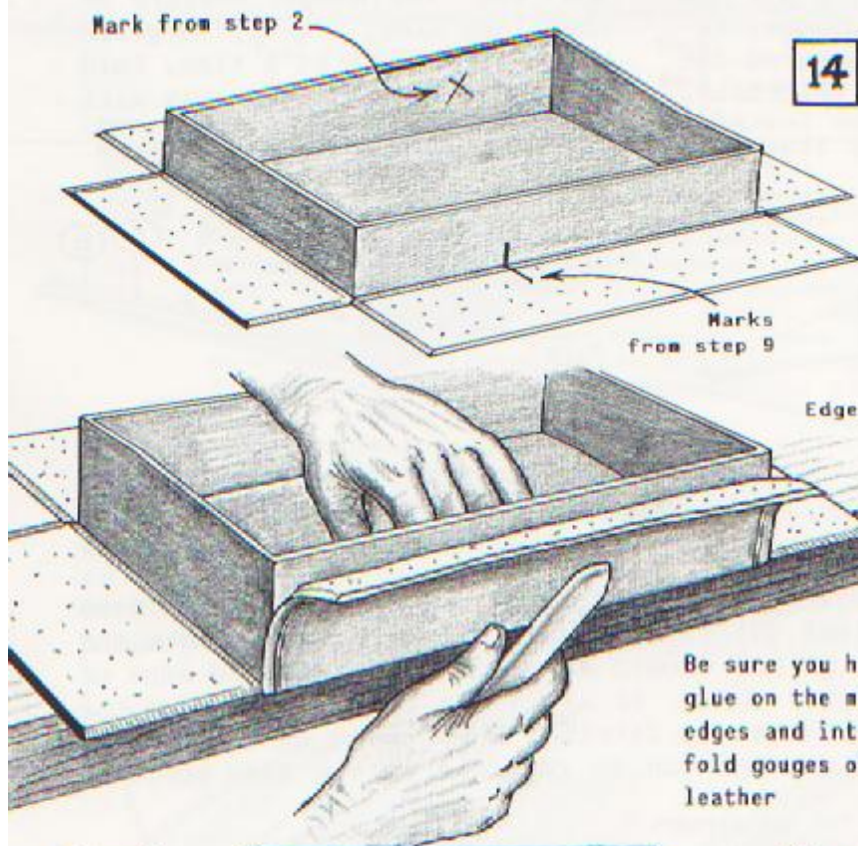
12

Turn the leather to the grain side up and gouge sewing channels along each edge, at all of the corners. Gouge to fold lines.



13

Now turn leather to flesh side up and bevel the corner edges for the miter joint. Bevel right into the corner cut. Use CAUTION!



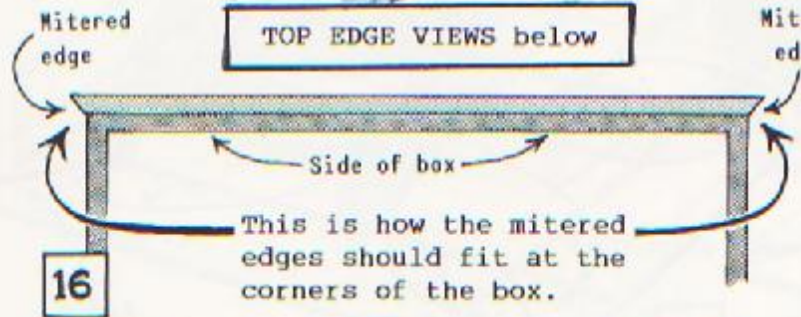
14

Now glue the box to the leather with contact cement. While the glue is still wet, fit the box in place and adjust it into the correct position. Allow glue to set. Since glue must hold the leather securely to the box, follow these procedures: Thin the glue to about 1/2 strength and coat sides of box and leather liberally. This makes a stronger bond, as the glue penetrates the fibers of both wood and leather. Allow to dry. Now apply a second coat (full strength) to the box and leather... allow to dry. Continue with step 15.

15

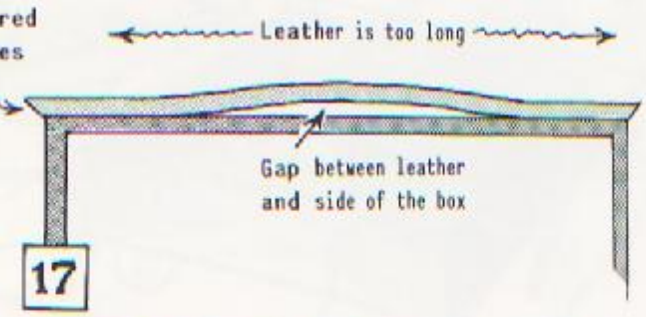
Put the project on the edge of your bench and begin adhering one side at a time. Push up tightly at the bottom with a Bone Folder, or Glass Slicker, and work it back and forth and upwards to adhere the leather to the box. Be sure the beveled edges of the miters are aligned with the corners of the box as you work the leather upwards. *Keep a close watch on this!*

Be sure you have put glue on the mitered edges and into the fold gouges of the leather



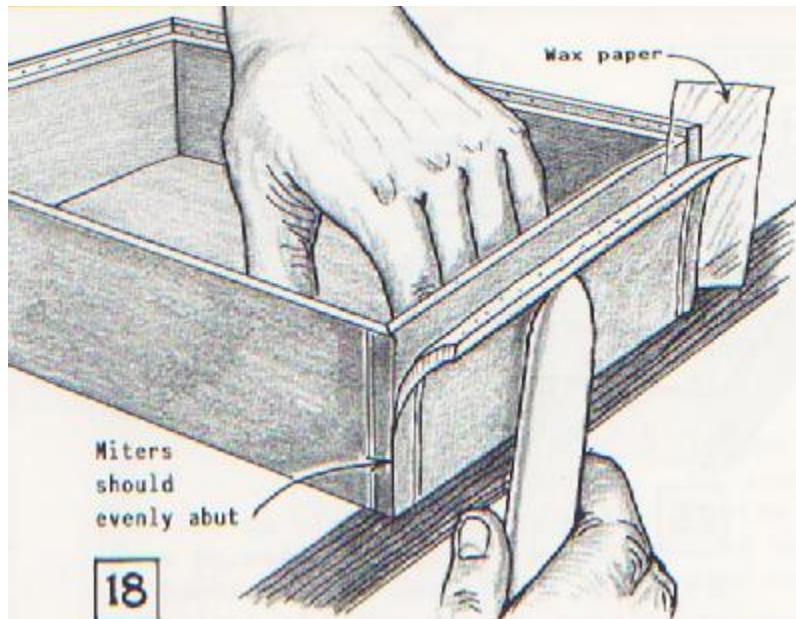
16

This is how the mitered edges should fit at the corners of the box.



17

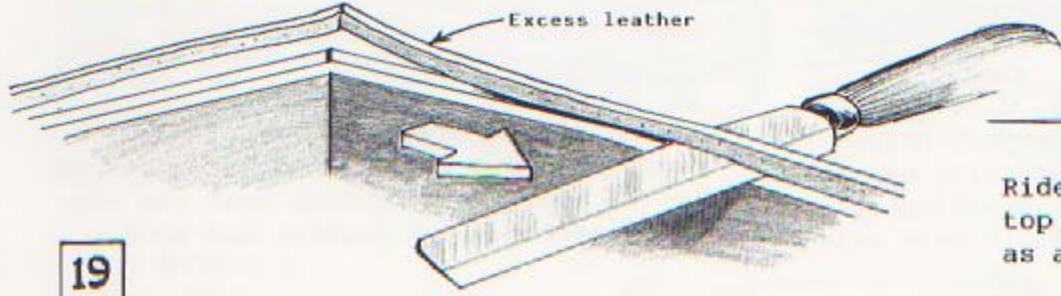
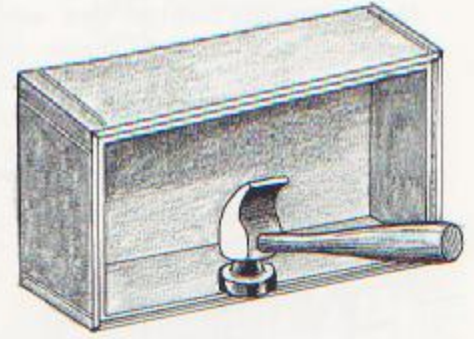
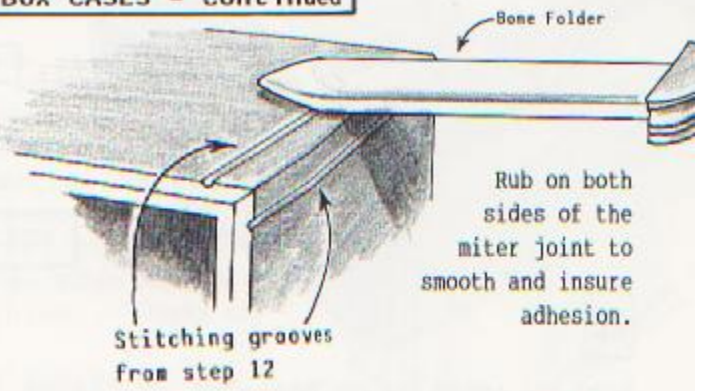
If the leather is too long, then first adhere the mitered edges at the corners...as above. Then force the rest of the leather against the box to adhere. It will compress without any difficulty...unless you were not careful enough with your measurements and cut it much too long. (continued)



18

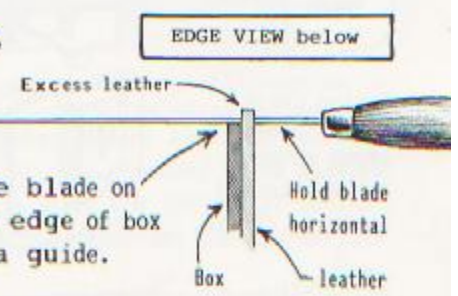
To prevent premature adhesion at the mitered corners, strips of wax paper can be inserted (above) while the side leathers are brought up. Watch the corners to be sure they will be fitting properly. The wax papers can be slowly withdrawn to insure proper alignment. Usually, the corners can be adhered first to insure proper alignment. After all sides have been glued, tap all around the edges and inside to insure bonding (right).

BOX CASES - Continued

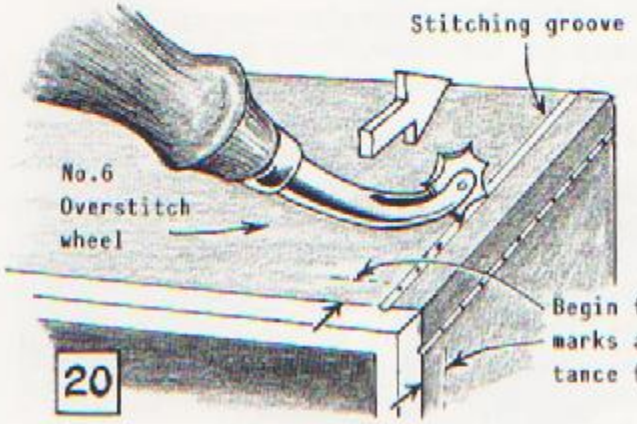


19

Now trim off the excess leather all around the box. Trim it flush with the box edge. Use a very sharp knife. Hold it firmly and horizontally.



If you have not done a smooth job of trimming, use a piece of broken glass; see page 25 "CASES Vol.II".

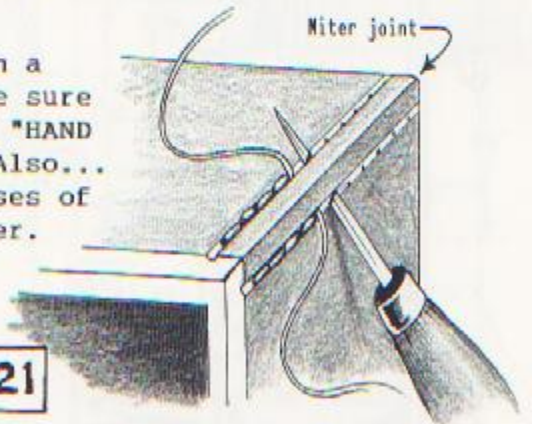


20

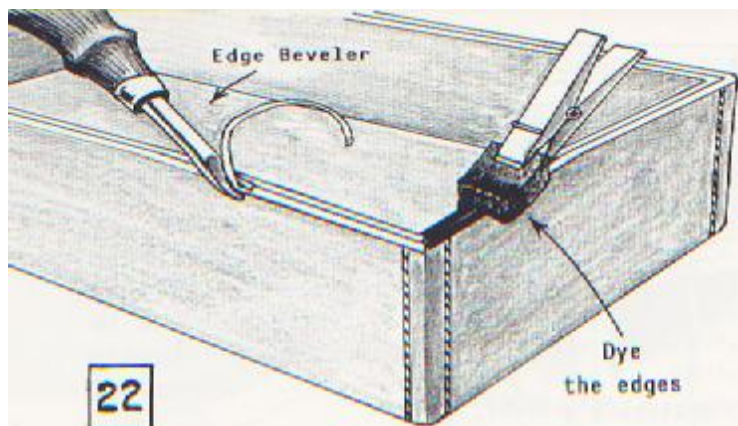
Now mark the sewing holes in all of the channels at the corners. Always begin at the top edge and wheel towards the bottom. Stitching holes must be opposite each other at each miter joint. The first marks should be about 1/8" from top edge.

When starting with a knotted thread, be sure to see page 24 of "HAND SEWING LEATHER". Also... for all other phases of Hand Sewing Leather.

21



Sew all of the miter joints as shown above. Tap the seams with a hammer. Round the miter joints with a large Edge Beveler; burnish. (continued)

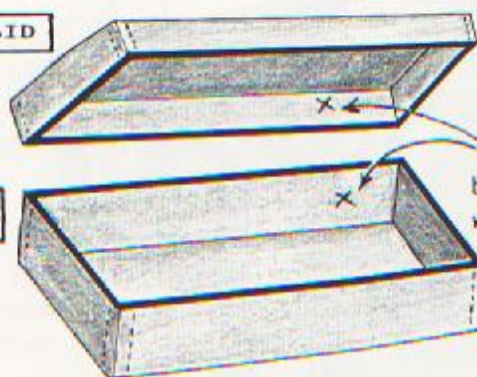


22

Bevel all around the top edges of the leather; moisten and burnish. Dye edges of leather and wood if desired. These can be finished with lacquer. Apply your favorite leather finish. Our case was stamped with irregular impressions of a Ribbed Shader and antiqued to create a mottled effect.

LID

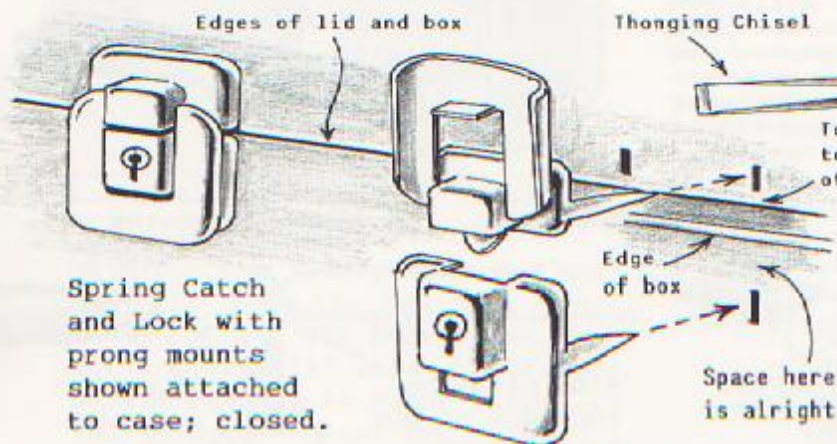
BOX



Did you remember to transfer the marks to the inside of the lid before covering it with leather? This is important if the lid is to fit properly.

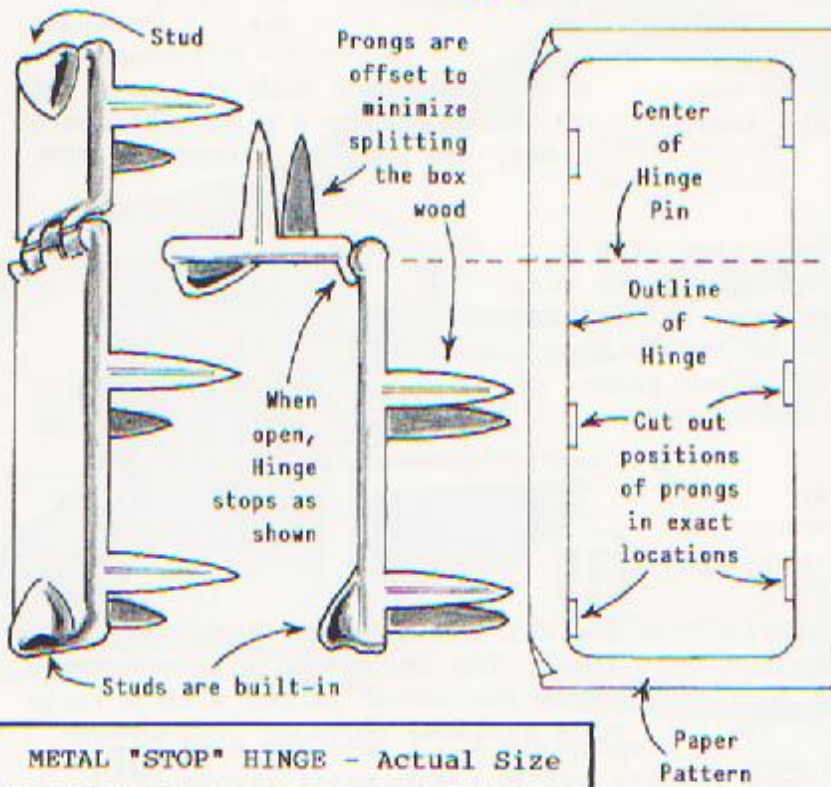
23

Cover the lid exactly as you have covered the box...following steps 3 through 22. If you have followed instructions, marks should be inside the lid and box as shown above.



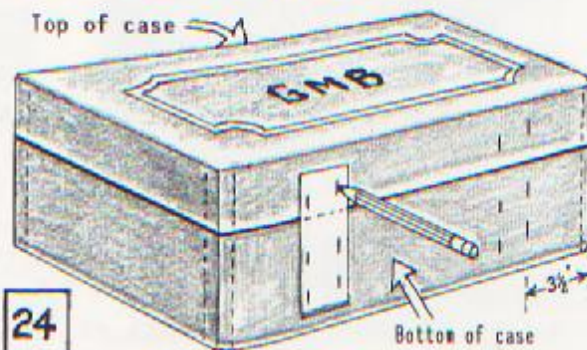
PRONG-TYPE CATCHES and FASTENERS

When using Prong-Type catches and hinges, use a Thonging Chisel to punch slits through the leather and wood. BEWARE! If the prongs are too close to the edge, the wood may split out. The example (left) shows them too close to the edge at the lid. This is not recommended unless the prongs will clinch to the leather only. Screws or escutcheon pin hardware would be better to use where they attach near the edge and penetrate both leather and wood.



METAL "STOP" HINGE - Actual Size

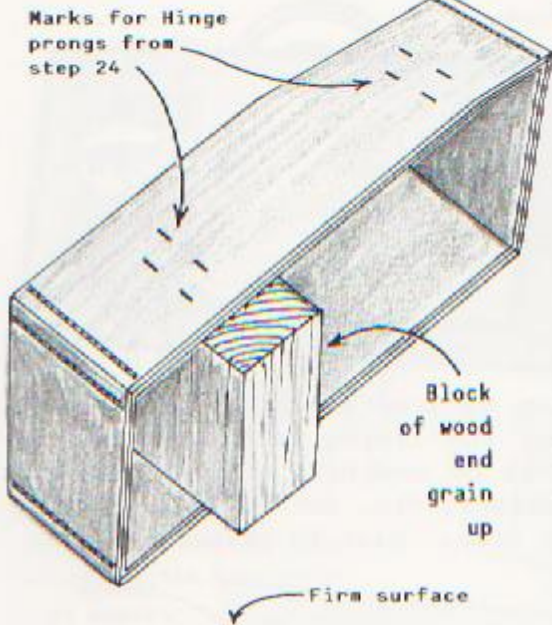
When pronged hardware is used, the slits will have to be punched in the case before handles or other hardware are installed. This is explained in step 25. To be sure of getting prongs in proper location on the case, make a pattern as shown at left...be accurate!



24

Place the lid on the box. Align all corners. If necessary have someone hold the lid firmly in place. Hold pattern firmly in place. Carefully mark prong positions with pencil. Measure an equal distance in from both sides. (continued)

BOX CASES - Continued

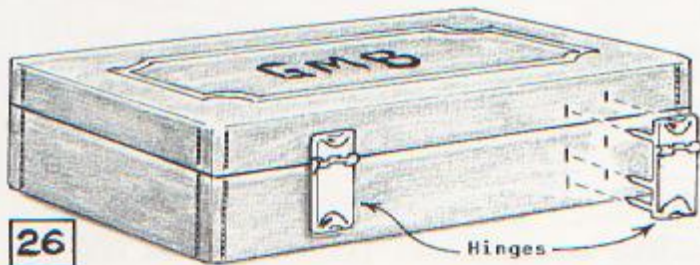
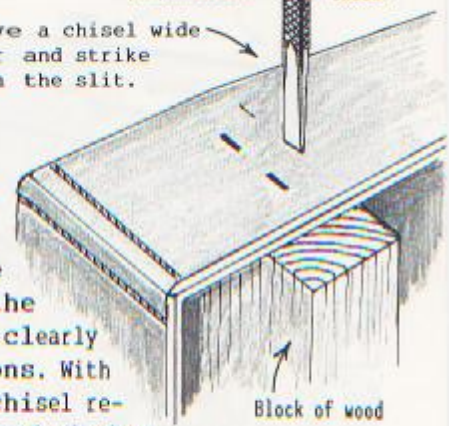


25

To punch the slits, you need a firm surface to pound against. Cut a block of wood that fits tightly inside the box (left). Place on a firm surface and tap the chisel lightly at first to clearly establish the prong positions. With greater force, strike the chisel repeatedly until it goes through the box and into the block. Punch all of the slits in the box... then put the support block of wood in the lid and punch the slits in it. Remove the block. You will notice that the wood inside the box and lid has been forced up around the chisel penetration. Remove these areas with a wood chisel so the wood is reduced to its normal thickness.

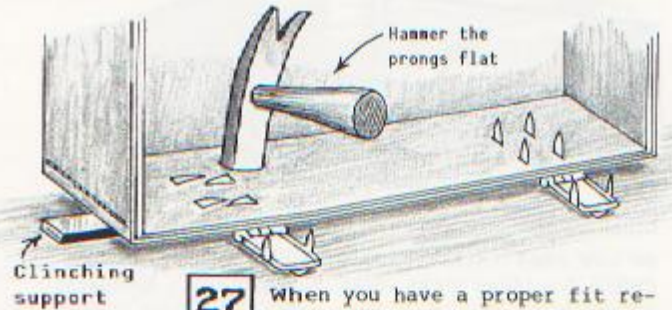
Hold the Chisel perpendicular

THONGING CHISEL



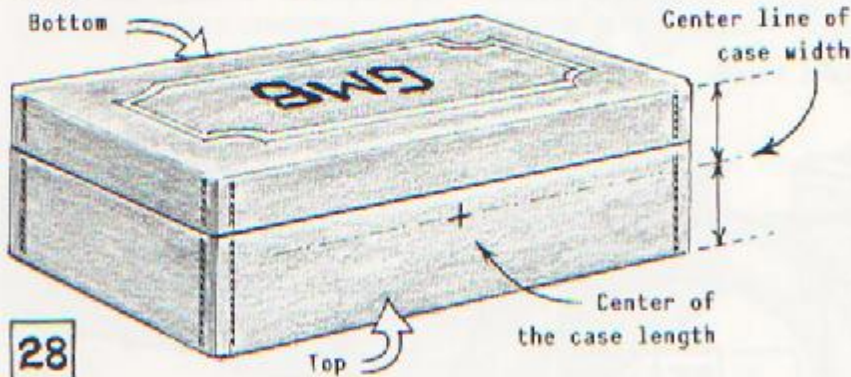
26

Now push the hinge prongs into their respective slits. You will probably have to tap them a bit with a mallet. Check to see if the lid fits snug on the box. If too loose or too tight you will have to lengthen the slits of whichever prongs are causing the problem.



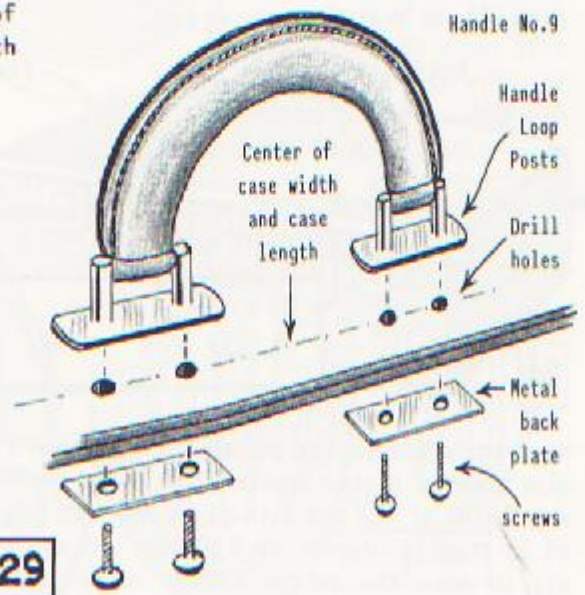
27

When you have a proper fit remove the lid and bend prongs inward inside the box. Use a support between hinge and stud so you do not damage them. This can be a narrow strip of wood, or metal.



28

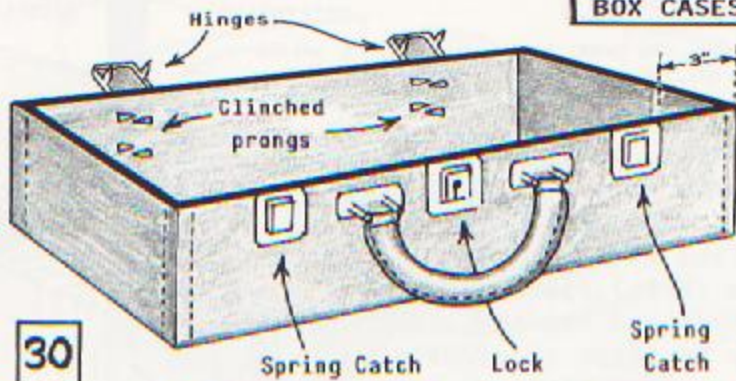
Fit the lid back on the box only to determine the distance from the box edge to the center line. The handle will install on this line... centered over the center of the case length. Since the center line is so close to the edge of the box (on this case) we used the handle loop post assembly (right) as it makes a very narrow installation. Measure the distance between the loop posts and drill corresponding holes through the case, as shown at right.



29

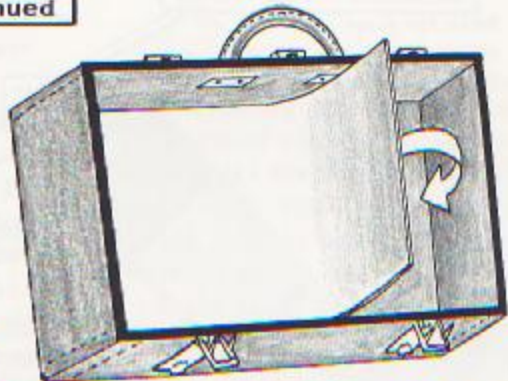
Put the screws through the metal plates, into the holes from inside the box, and screw into loop posts.

BOX CASES - Continued



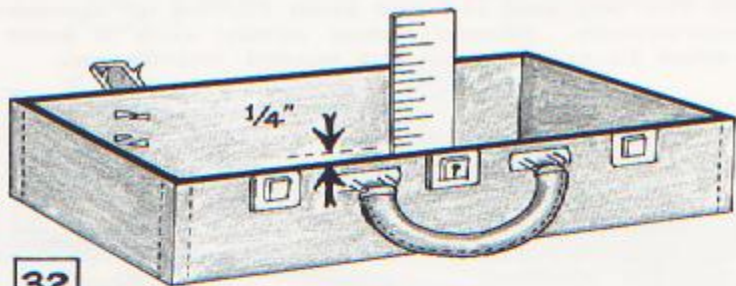
30

Now install the lower half of the Lock and the Spring Catches. Screw in place. If the catches are attached with escutcheon pins, they should be installed before the handle as it will make the riveting easier.



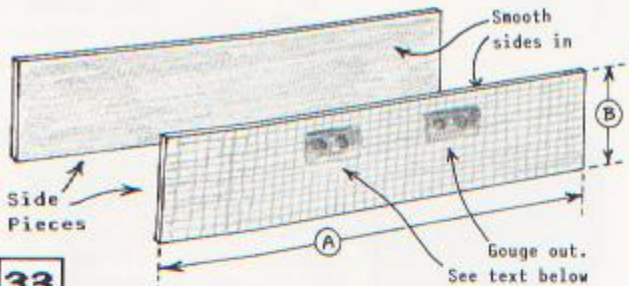
31

If you wish to line the case...now is the time to put the lining in the bottom. The material can be cowhide, pigskin, colored garment leather, etc. Cut it to fit snugly within the sides. Glue in place.



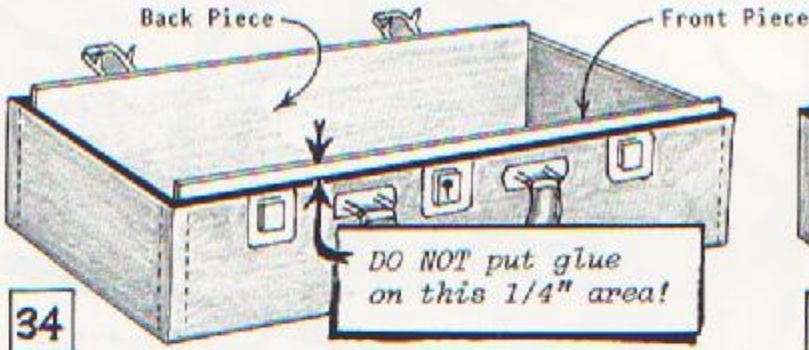
32

We now need reinforcing pieces for the inside. Cut them from 1/8" masonite. Length is cut to fit snugly between the ends. The height will be 1/4" above the edge (above). These pieces also act as a guide, insuring the alignment of the lid. If these pieces are going to be lined, then they will have to be cut shorter at all sides equal to the thickness of the lining material.



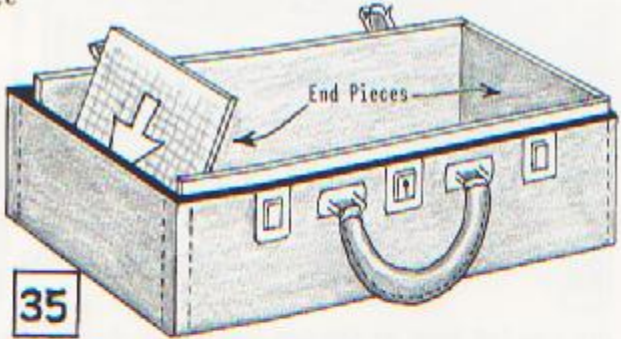
33

Cut the measurements (A) & (B) from the instructions at left. These pieces must fit flush against the inside of the box. They cover up the handle screws, hinge prongs, rivets, screws, etc. Therefore these areas must be gouged out to insure a flush fit. They can be roughly gouged. Use wood chisels. Fit pieces inside the box to be sure they are gouged in the proper areas.



34

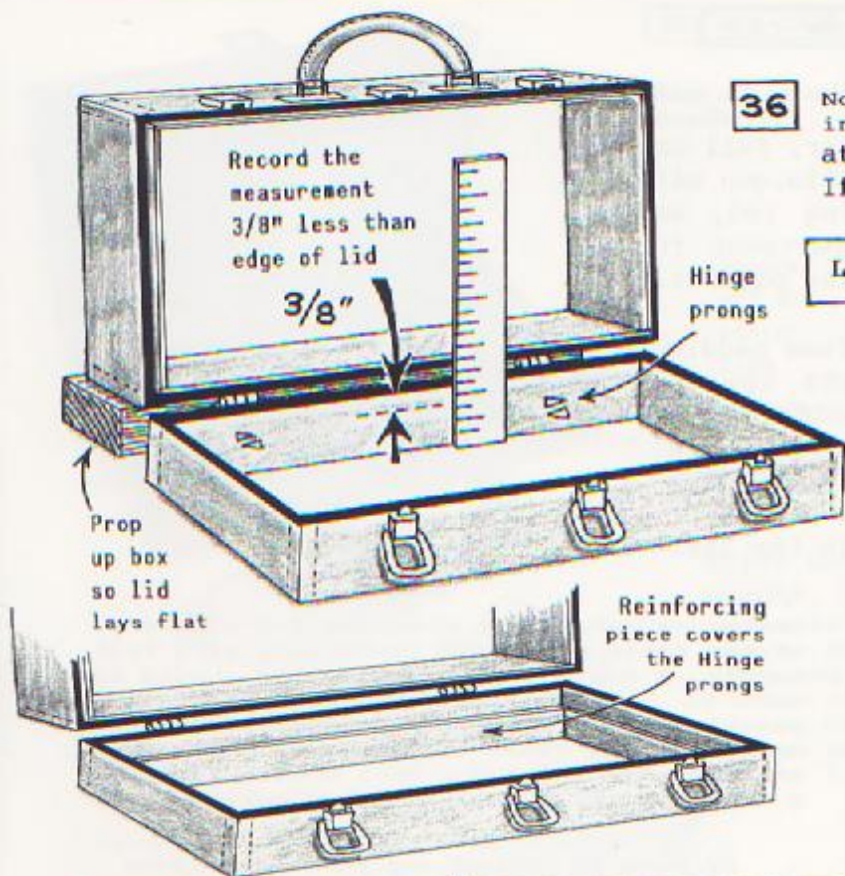
When you are sure the pieces fit properly, glue them in place. Double coat the pieces and inside of the box with glue as explained in step 14. Insert each piece at an angle so that the bottom edges make first contact. Tap with a hammer to insure bonding. A back-up hammer can be used inside of the case while you tap around catches, etc.



35

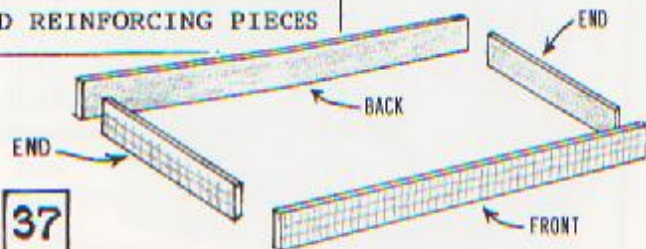
Cut the end pieces the same height as the side pieces. Cut the length for a snug fit between the sides. Again...if they are to be lined, reread instructions in step 32. The thickness of the lining material must always be taken into account. Glue the end pieces in place. (continued)

See LINING INSTRUCTIONS on OPPOSITE PAGE



36 Now attach the lid to the hinges. Bend prongs in as in step 27. Close the lid on the box and attach the upper part of the Lock and Catches. If the lid will be lined, follow step 31.

LID REINFORCING PIECES

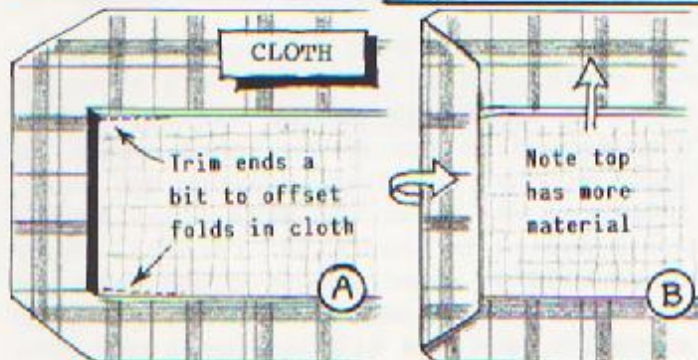


37

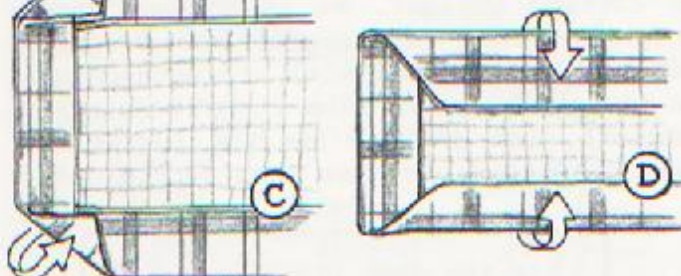
Now we need four pieces for the lid. Cut them from 1/8" masonite. The lengths of all pieces should be the same as for the box... only this time the pieces will be cut 3/8" less than the lid depth (left). The reason for this is to insure closure of the lid in case any measurements were cut wrong. Or, if you failed to account for the lining thicknesses these pieces might ride on top of those in the box, preventing lid closure.

Glue the panels in place, following steps 34 & 35. The case is complete; see page 25.

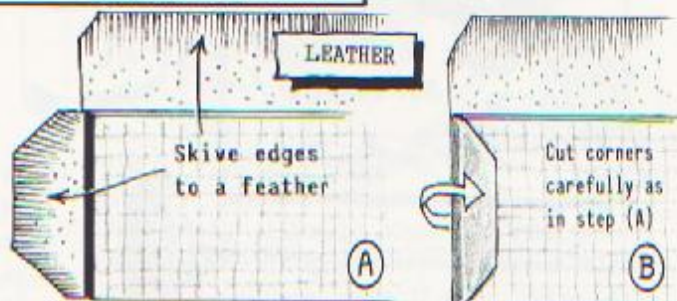
LINING the BOX and LID REINFORCING PIECES



Use rubber cement to adhere cloth to the wood. Brush lightly on cloth to adhere on the broad surface. Use liberally to adhere all folds. The end (B) is first fold then fold corners (C).



Final folds are (D). Pound with a hammer to insure bond. Our case had cloth covered 4/5oz. leather in bottom of box and top of lid. See opened case on page 25.



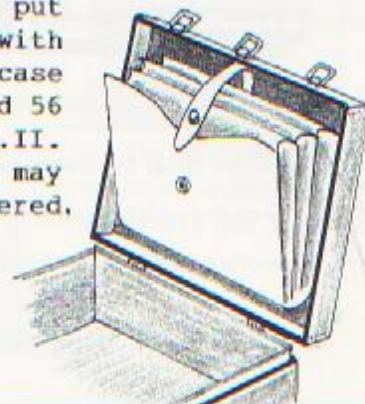
Leather is not required at bottom



Cut leather from very light material. Skive edges well. Cut oversize at bottom then trim flush with edge after gluing to panel. Glue folds (B)&(C). Pound with hammer.

Pockets can be put in the lid as with the attaché case on pages 55 and 56 of "CASES" Vol.II. The dimensions may have to be altered.

Also see pockets of brief case on page 114, "CASES Vol.II".





Carving Design*

PISTOL CASE

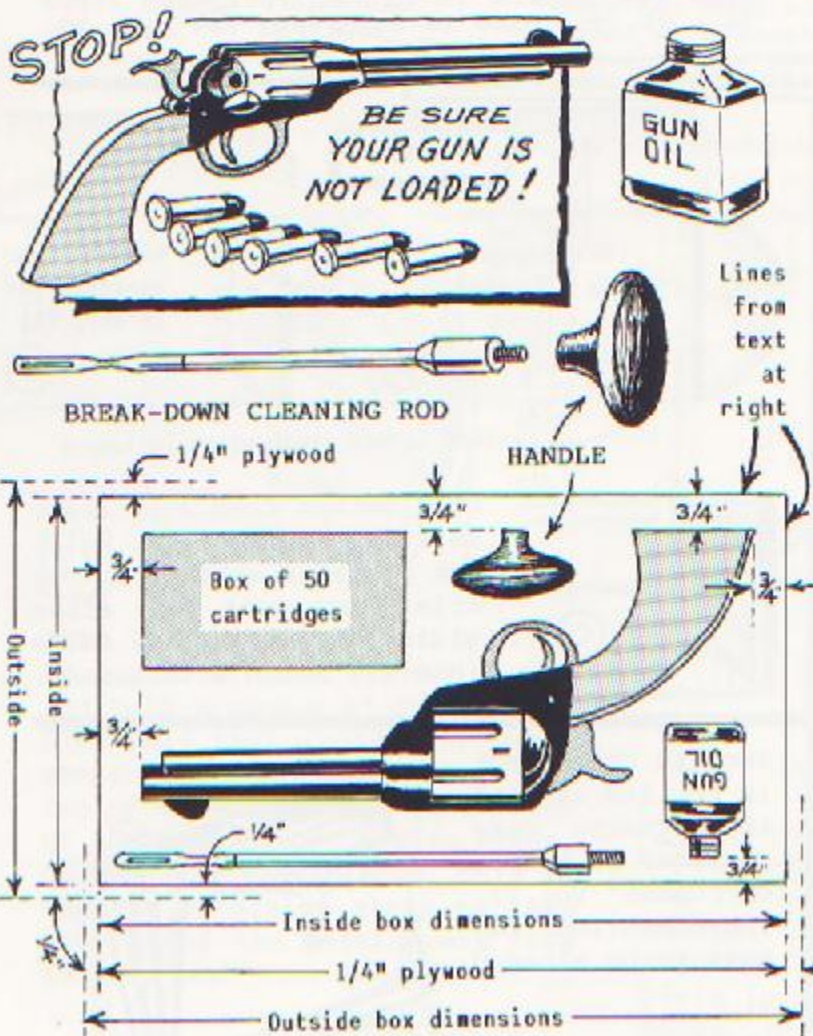
This case is made for a .357 Magnum revolver, full box of shells, gun oil, cleaning rod, and a compartment for cleaning patches.

Styrofoam padding protects the gun and holds all of the items securely in place. Styrofoam padding is also in the lid.



This case is made much like the one on page 25, with some variations. It begins with a wooden box. This box, however, is made from 1/4" plywood and does not need the inside reinforcing pieces since the extra thickness of the plywood makes it more rigid to begin with. The dimensions of the case are determined by assembling all of the items

to be included. The cleaning rod should be of the break-down type preferably with flat handle. A small gun-oil container should be used to best utilize space. If necessary, purchase a small bottle (regardless of the contents) and clean it out thoroughly. Then transfer the oil into this bottle and tape a label on it, as we have done here.



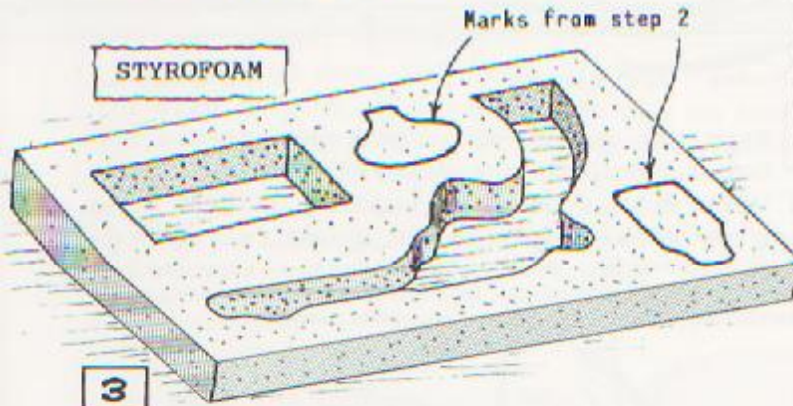
Be sure to unload any firearms before using them for pattern making, etc. ALWAYS ASSUME EVERY GUN TO BE LOADED!

1 The first step in making your case is to lay all of the items on a sheet of paper as suggested in the sketch. Juggle them around to use up the least amount of space without crowding. Measure out about 3/4" from the items and draw lines shown. Use a square to insure 90° corners. These lines will be your inside dimensions for the case. The cleaning rod has ample room above the gun and will be contained with a leather divider, glued in place, step 39. The handle fits easily beneath the trigger guard of the pistol. The reason items are shown upside down is that the handle of the case will be at the top of the gun and the top of the gun oil when the case is carried upright. We could have shown this the other way around, but we wanted you to identify this with the opened case in the photo above. From the illustration at left, you can see how the inside and outside dimensions have been determined.

Use the same procedures for Automatic, or other pistols

PISTOL CASE - Continued

These items are fitted into a sheet of Styrofoam 1" thick. This gives the gun maximum protection within the case. The same principals can be applied to make cases for a variety of other subjects. Follow the step-by-step instructions presented in the building of this case.



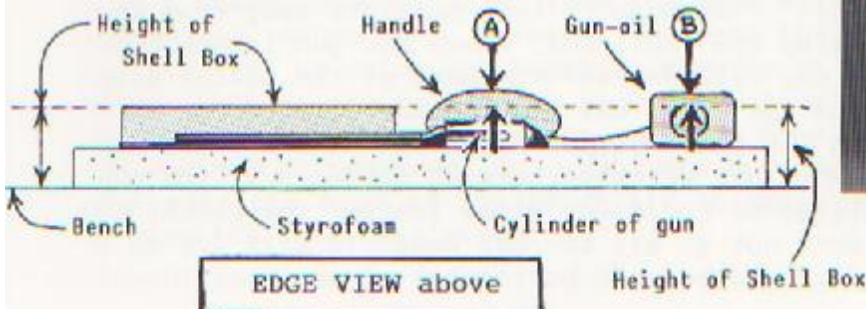
3

Now, with a sharp knife, cut out the gun and shell box areas. Hold the knife perpendicular, making successive cuts until all the way through. Remove the Styrofoam from these two areas.

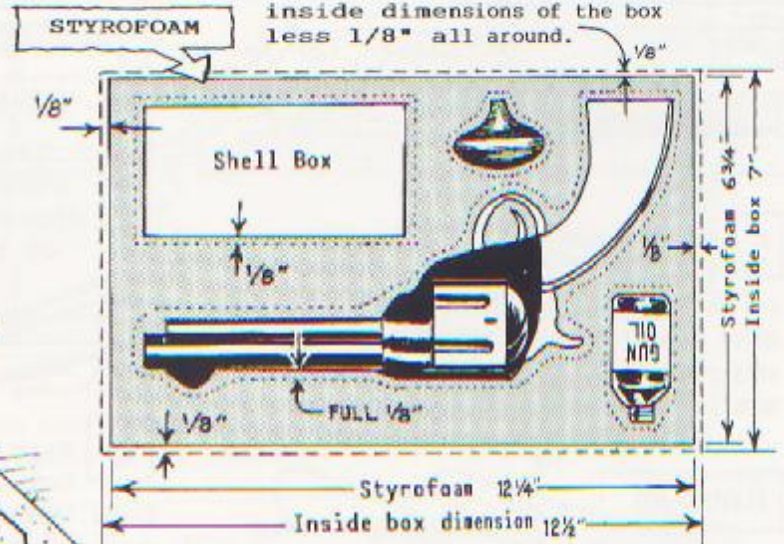
4

Lay the Styrofoam on the bench and place the pistol and shell box in their cut-outs. You will notice in the edgeview (below) that the shell box is higher than the gun. Next place the gun oil and handle in their positions. Now, they are higher than the shell box.

To make the case box as slim as possible these two items should be recessed into the Styrofoam to the height of the shell box, or slightly lower. For the handle, the depth measured at (A) must be taken out of the foam. Measure (B) for its recession depth. Remove all items. Following your marks in step 2, gouge out the foam to the depths and contours of the handle (A) and gun-oil bottle (B). Wood chisels make good tools for this work.

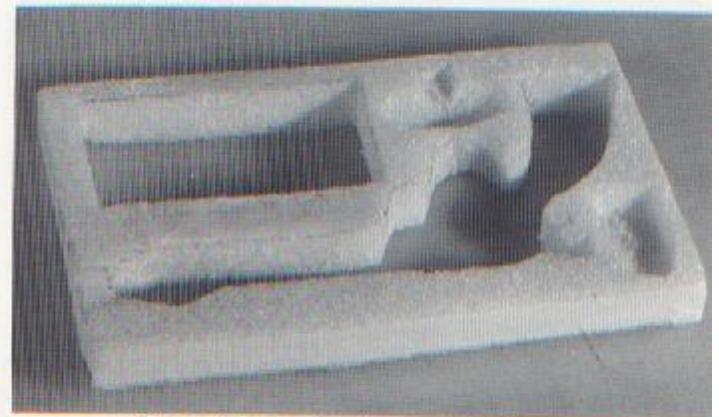
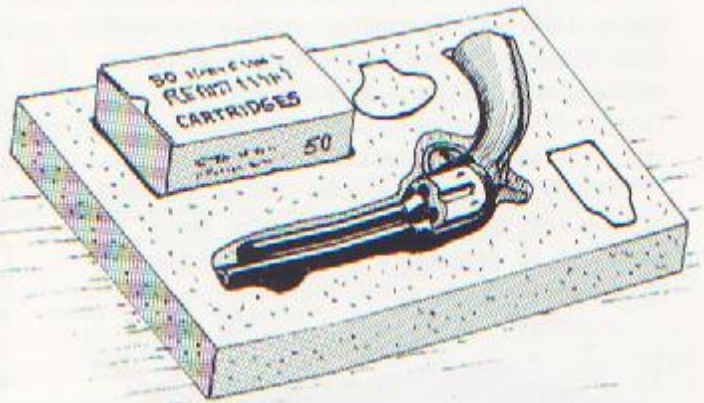


Cut the Styrofoam to the inside dimensions of the box less 1/8" all around.



2

Cut a piece of Styrofoam (of 1" thickness) as indicated above. If your box is 12 1/2" x 7"...then cut the foam 1/8" less all around: 12 1/4" x 6-3/4". Place the items on the foam in the same positions as before. Do not be concerned with the rod yet. Hold firmly in place and (with a felt pen marker) draw marks about 1/8" out from each item, as suggested by the dotted lines above. Use a straight edge to mark around the shell box. You do not have to follow the exact contours in some areas... as indicated around the trigger guard, etc.

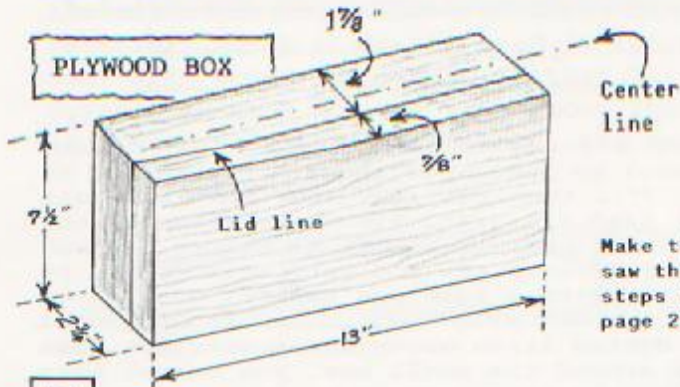


Styrofoam is shown ready for step 8.

PISTOL CASE - Continued

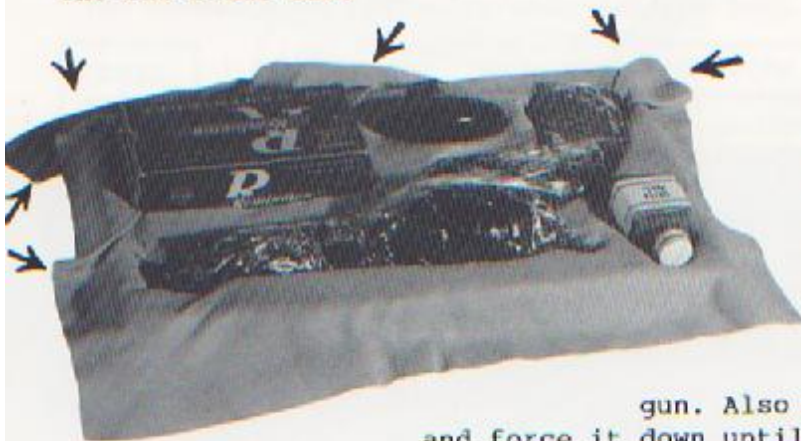


5 After gouging out the areas in step 4, place all items back on the foam and check points (A) and (B). The sketch above shows the handle and gun-oil properly positioned. From this we can determine the depth of the box...see step 6.

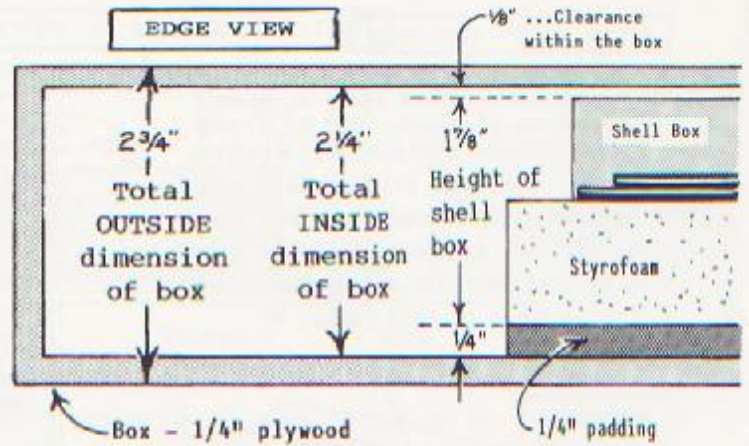


7 So...from steps 1 through 6 we have arrived at the size of the box. Our case came to the dimensions shown above. Yours may be different altogether. Now you must plan on the types and size of the hinges, catches, lock, etc. We have chosen the lid line at $7/8$ " to give us ample room to install the handle on the center line.

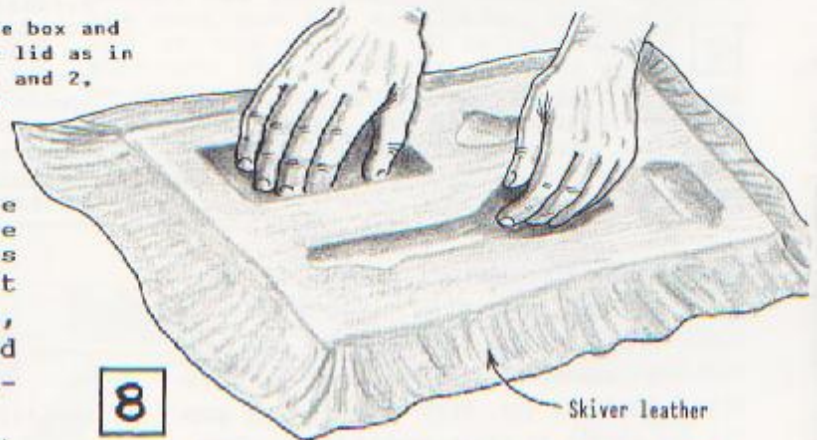
CAUTION: If using a power saw to cut off the lid, the depth of the box must be increased to compensate for the width of the saw blade cut!



and force it down until the cylinder and the butt of the pistol grip touches against the bench. Next, force the shell box all the way down. Folds will appear (arrows) that cannot be avoided due to the sheer-walled depth of the cut-outs. The handle and gun-oil will be less troublesome. Work out wrinkles between subjects if you can and press around edges to establish the outline of the foam. Allow leather (or cloth) to dry. The leather under the barrel does not go all the way down. It will act as a cradle for the barrel and should be on a horizontal plane. (continued)

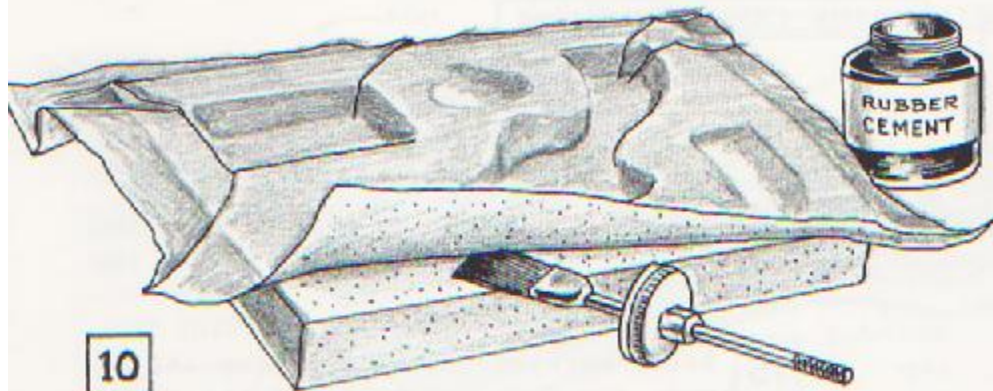


6 From the sketch above you can see how the box dimensions are determined. The Styrofoam unit will rest on a padding of $1/4$ " foam rubber or shearling that is glued to the bottom of the box. This adds further protection for the gun. At least $1/8$ " clearance should be allowed at the top (see sketch above).



8 Cut a piece of skiver considerably larger than the Styrofoam. This is because the deep cut-outs will pull the leather in from the edges. Soak the leather thoroughly. "Case" it if possible. Place it over the Styrofoam and begin pressing it into the depressions and cut-outs. Push it in as far as possible, especially in the shell box, gun handle and cylinder areas. Don't be too concerned about wrinkles at this time. NOTE: Cloth could also be used in place of the skiver leather.

9 Now cover the pistol tightly with Saran Wrap to keep moisture away from the gun. Also wrap the shell box. Place the gun in position and force it down until the cylinder and the butt of the pistol grip touches against the bench. Next, force the shell box all the way down. Folds will appear (arrows) that cannot be avoided due to the sheer-walled depth of the cut-outs. The handle and gun-oil will be less troublesome. Work out wrinkles between subjects if you can and press around edges to establish the outline of the foam. Allow leather (or cloth) to dry. The leather under the barrel does not go all the way down. It will act as a cradle for the barrel and should be on a horizontal plane. (continued)



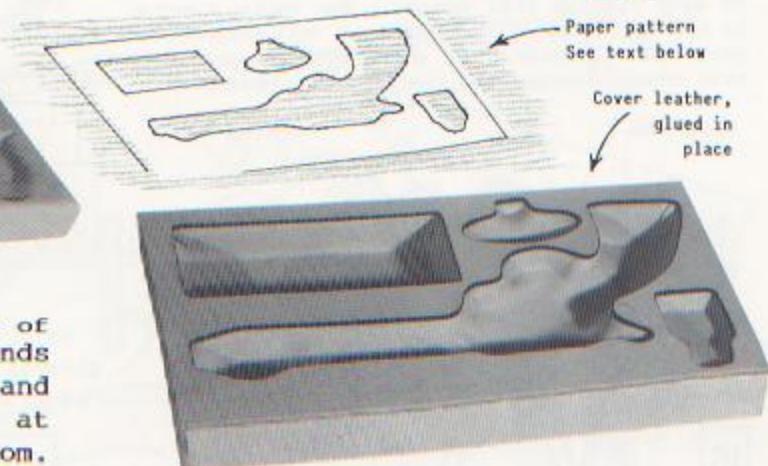
10

When the leather has dried, lift up around the edges and apply cement to the foam and the leather. Lay the leather back down and rub with a Bone Folder to remove as many wrinkles as possible. Pull towards the edges. Work completely around the project in this manner.



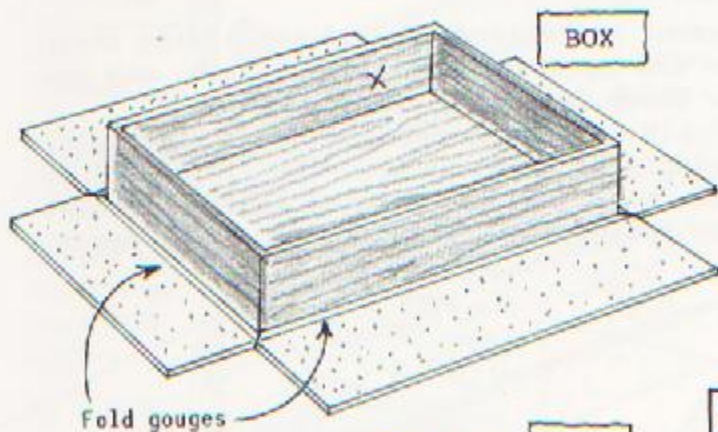
Bottom View

With the project turned upside down, you can see how the skiver leather has been forced down into the cut-out areas.



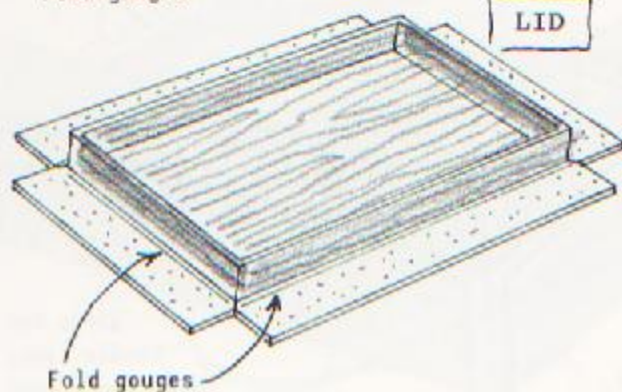
11 Now apply cement to the underside of the leather and to the sides and ends of the Styrofoam. When dry, pull down and adhere. Split and trim leather flush at the corners. Trim off flush at the bottom.

12 If you are dissatisfied with the folds and wrinkles, make a pattern on heavy paper of all of the item areas (above). Keep fitting and trimming until all openings are properly cut. Transfer this to 6/7oz. leather and cut out the openings. Cut the outside dimensions oversize; trim to size later. Burnish all edges in the openings. Apply leather finish to the surface and all edges. Glue in place. Trim outside edges to proper size.

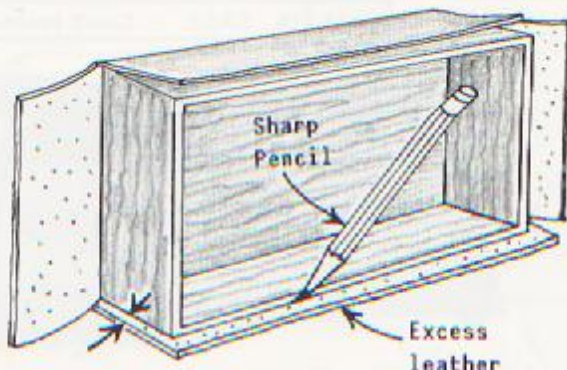


BOX

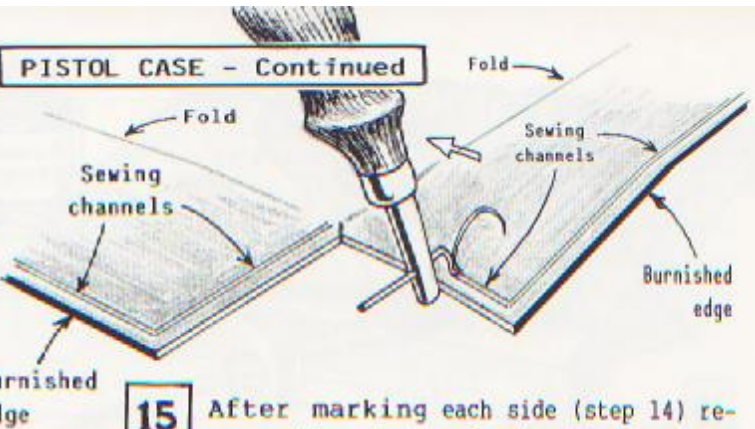
13 After sawing the lid off the box prepare the leather for both parts. Cut from 7/8oz. cowhide. This case will be miter jointed at the corners. Follow the same instructions exactly as on pages 26 & 27, steps 3 through 11. Be sure to put the marks inside the box and lid so these edges will go together during assembly. Now spot-glue the box and lid to their leathers (left). We are ready to turn the sides up for more fitting. (continued)



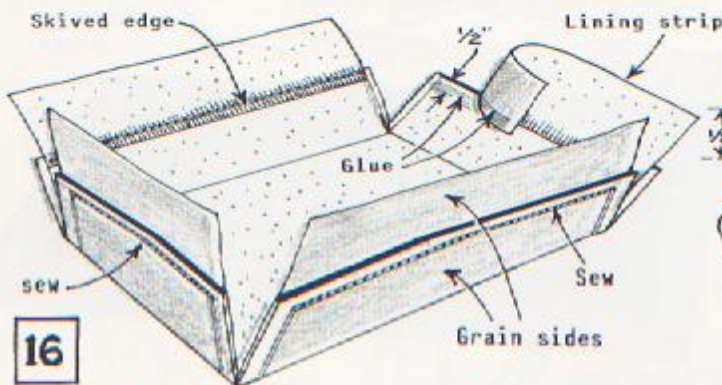
LID



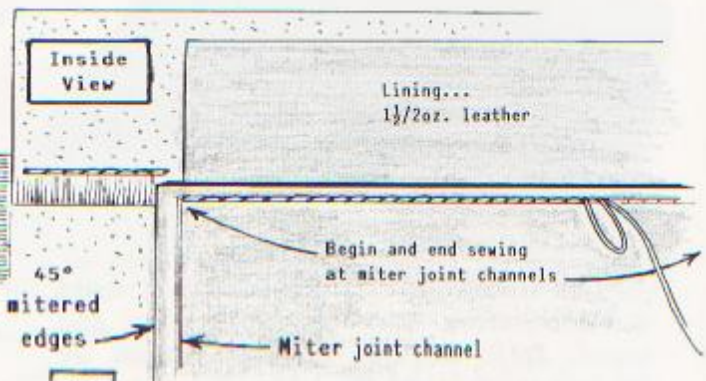
14 Moisten gouges and fold sides up (one at a time) tightly against the box and place this side on the bench. Hold it down firmly. Mark the leather close to the edge of the box. This will be trimmed off later. Do each side in this manner. Be sure there is the thickness of the leather extended at each side (indicated by arrows). You must have enough leather for the miter joints.



15 After marking each side (step 14) remove the box and trim off the excess leather on your marks. Turn to grain side and burnish the edges you have just trimmed and gouge sewing channels along this edge; also at the corners for the miter joint. Turn to flesh side and bevel the corners for the miter joint. This is exactly as in step 13, page 28.

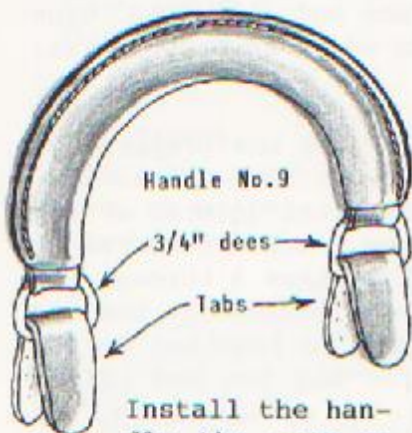


16 Now cut lining strips for each panel from 1 1/2 oz. leather. Skive one side. Cut them 1-3/4" wide, for the box, and lengthwise to fit right at the beveled edge of the miter joints. Their purpose is to cover the edges of the plywood and form a lining inside the case. We used Silver Kid for our lining.



17 Cement the skived edge of the lining strip to the burnished edge, 1/2" down, and sew as shown. Repeat with each panel.

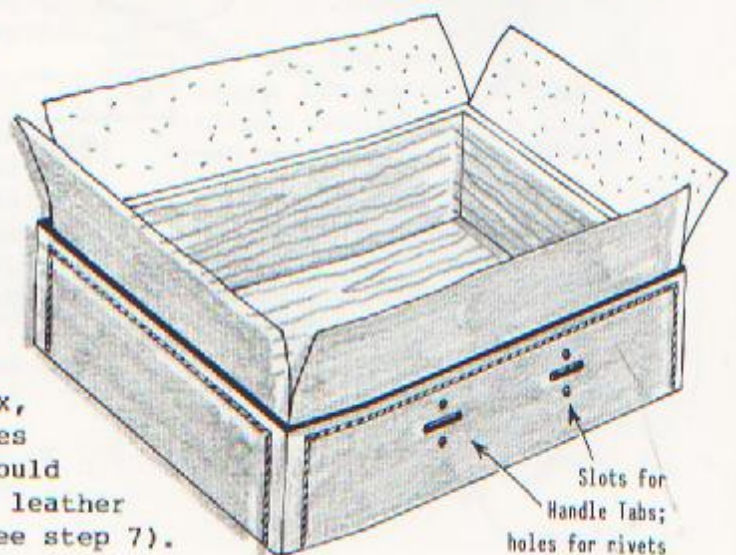
LID: Complete the lid up to this point exactly as with the box. The lining strips for the lid should be wide enough to cover the inside of the lid. 1 1/2" to 2" is ample.



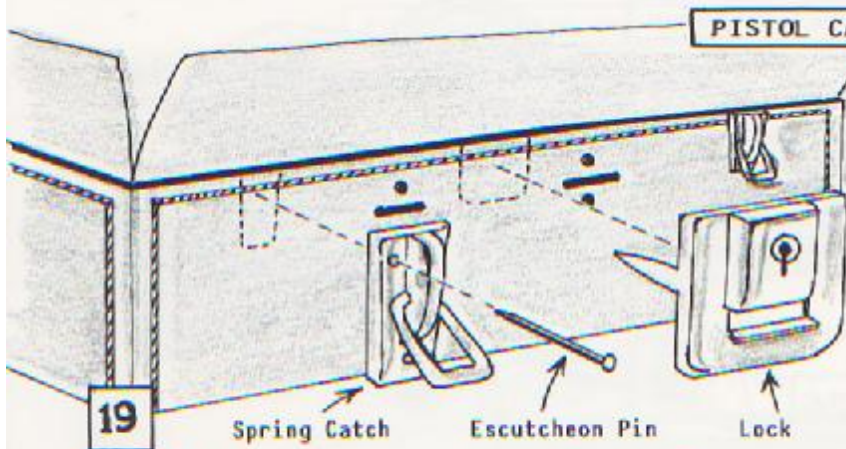
Install the handle the same as with the attaché case on page 53, "CASES, Vol. II".

18 Now continue the assembly following steps 14 through 21 on pages 28 and 29. Your case should look like sketch at right.

SPECIAL NOTE: Before gluing the leather to the box, the slots and holes for the handle should be punched in the leather on center line (see step 7).



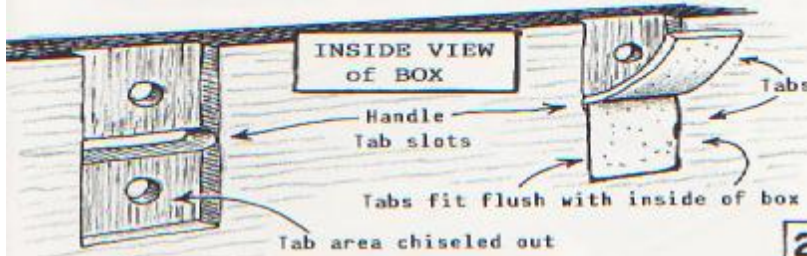
PISTOL CASE - Continued



19

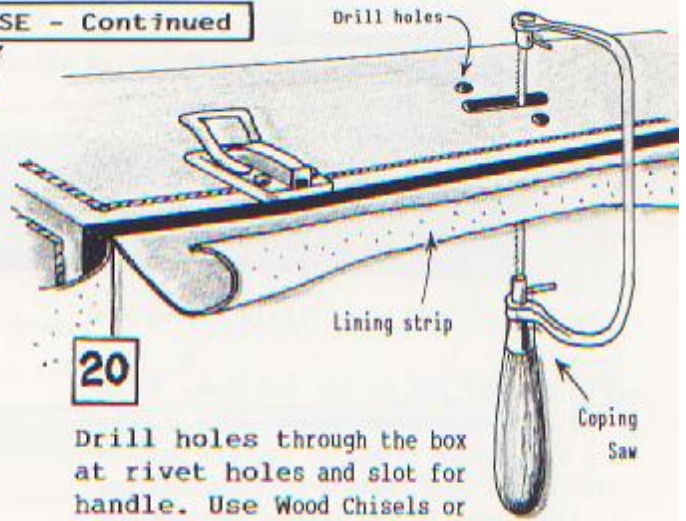
Spring Catch Escutcheon Pin Lock

Install the Catches and the Lock. The prongs go through the box (see step 25, page 31) and clinch on the inside. Drive the escutcheon pins, of catches, through the box and clinch on the inside. Be sure to use a metal surface when clinching pins or prongs.



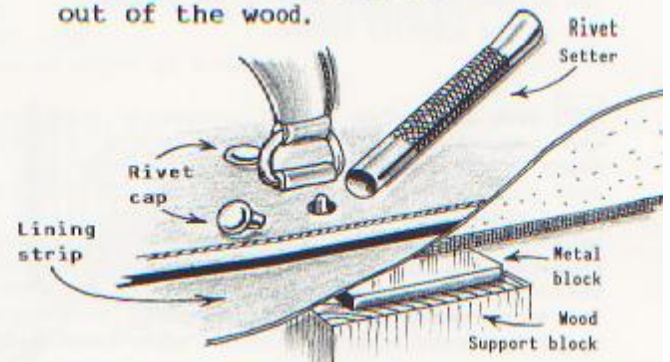
21

Now the wood inside the box must be recessed so the handle tabs will lay flush with the inside of the box at each side of the slot. Chisel the depth out to the thickness of the leather. This case had the rivets set close to the edge, so the wood had to be chiseled out to the edge to accommodate the tabs (see sketch above).



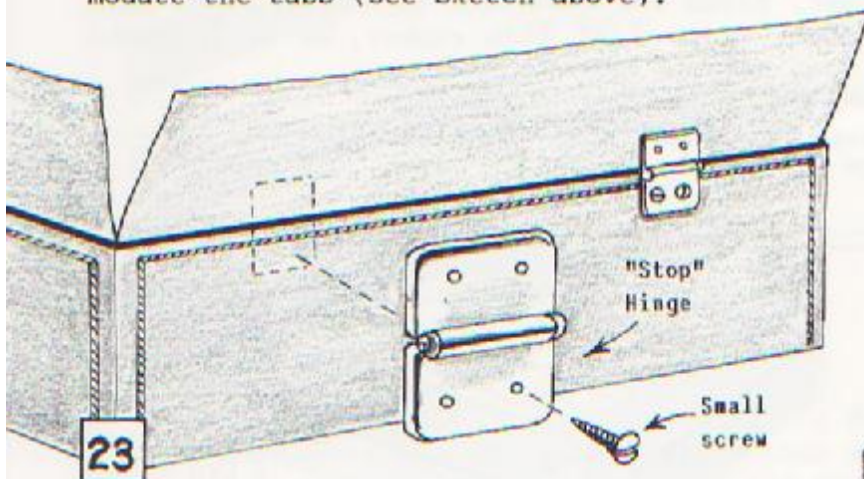
20

Drill holes through the box at rivet holes and slot for handle. Use Wood Chisels or Coping Saw to cut the slot out of the wood.



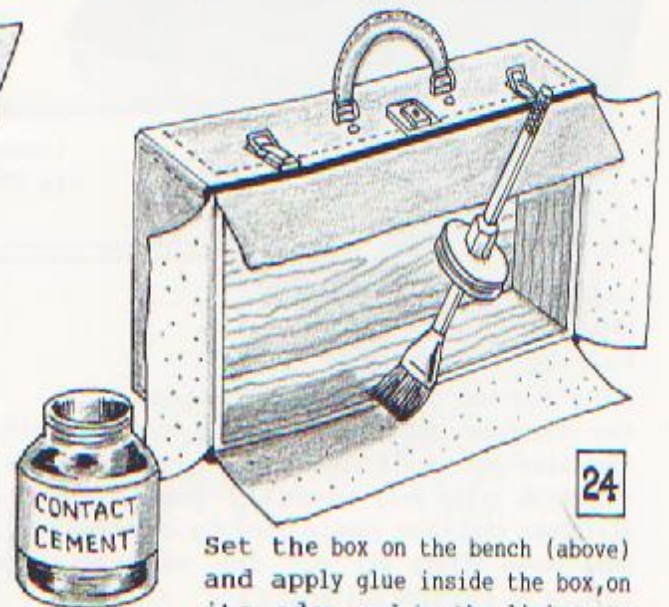
22

Install the handle. Moisten the tabs and push them through the slots. Pull down tightly with pliers. Spread out into recesses and mark the hole locations from outside of case. Punch holes and cut off tabs to fit recesses. Push posts of rapid rivets through holes. "Set" the rivets as above, or use the flat end of an anvil protruding over the edge of the bench to rivet against.



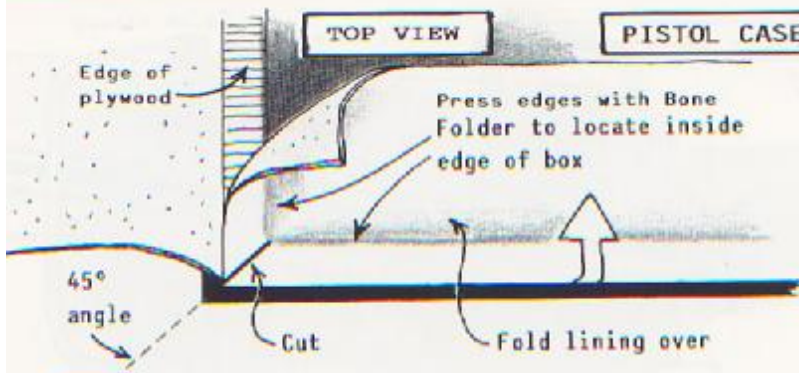
23

Turn the box around and install the hinges. The lid will be added later. If screws are required, use short ones. If they come out inside the box, remove them and cut off the excess. Now screw them back in place.



24

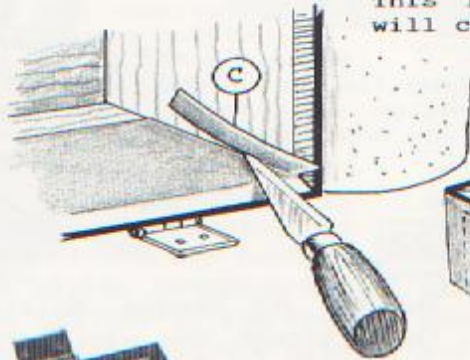
Set the box on the bench (above) and apply glue inside the box, on its edge, and to the lining. Do one side only; go to step 25.



25 Set the box on its bottom. Fold the lining tightly over the edge. Rub with a Bone Folder to insure adhesion on the edge. Make a 45 degree cut in the lining to the inside corner of the plywood box. Also make a 45 degree cut at the opposite corner.

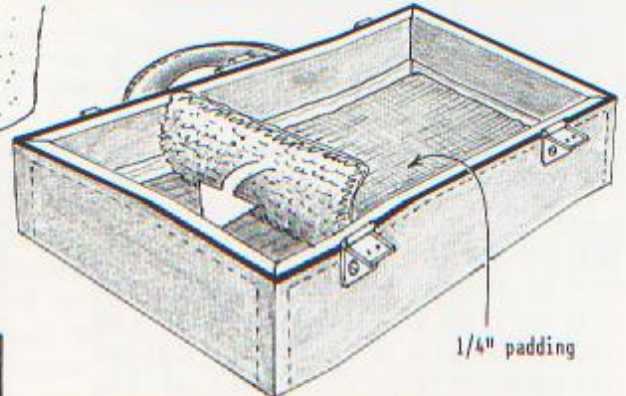
27 Trim off the excess lining (C) right in the corners.

Now...taking one side at a time, repeat the steps 24, 25, 26, 27. This will complete the box...except for the interior.



26

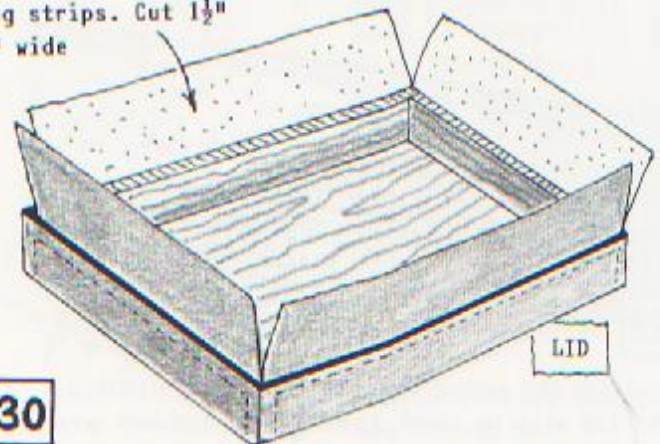
Lay the box back on its side and fold the lining in. Use a Bone Folder (A) to adhere lining inside the box. Work the Folder tightly in the corner (B). The turned up lining (C) will trim off in the corner. Notice the edge of the lining (D) does not go all the way to the bottom. This is not necessary as the Styrofoam unit will cover this area plus a bit of the lining.



28

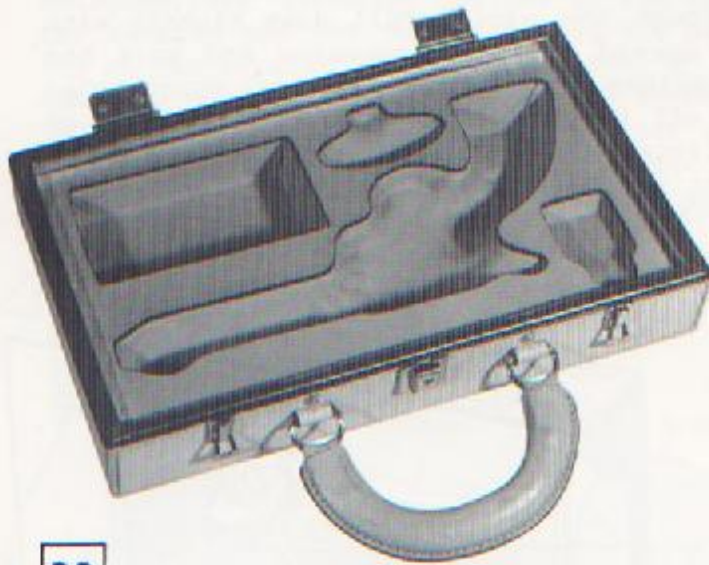
Cut a piece of 1/4" shearling to fit inside of the box. Apply contact cement liberally to the bottom of the box. While the cement is still wet, press the shearling in place...wool-side down. NOTE: 1/4" foam rubber, or felt, could also be used for the padding.

Lining strips. Cut 1 1/2" to 2" wide



30

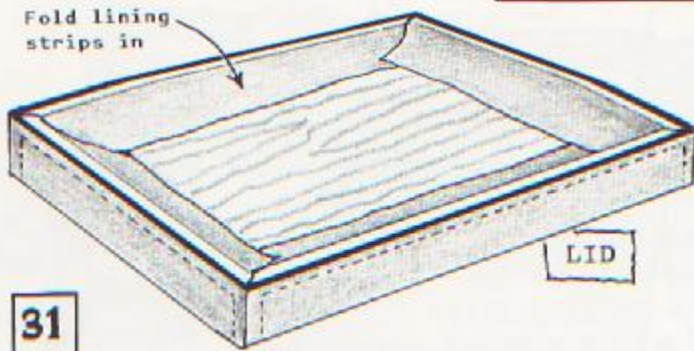
Complete the lid to the point shown above. Use the exact same instructions as for making the box. Use the same material for lining strips.



29

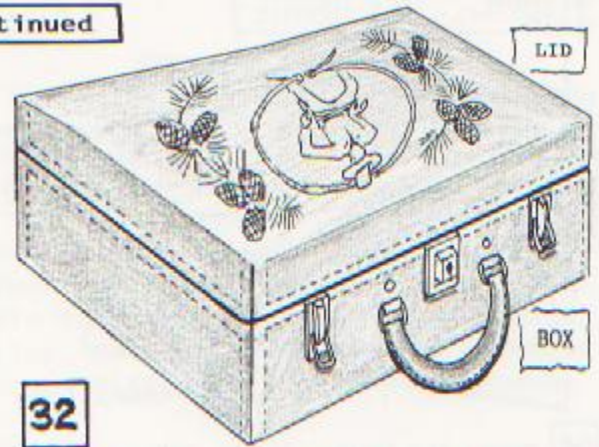
Apply contact cement to the bottom of the Styrofoam unit and liberally to the shearling leather in the box. While the cement is still wet, carefully push the Styrofoam unit down evenly inside of the box. Press firmly all over the unit to be sure of adhering all areas.

PISTOL CASE - Continued



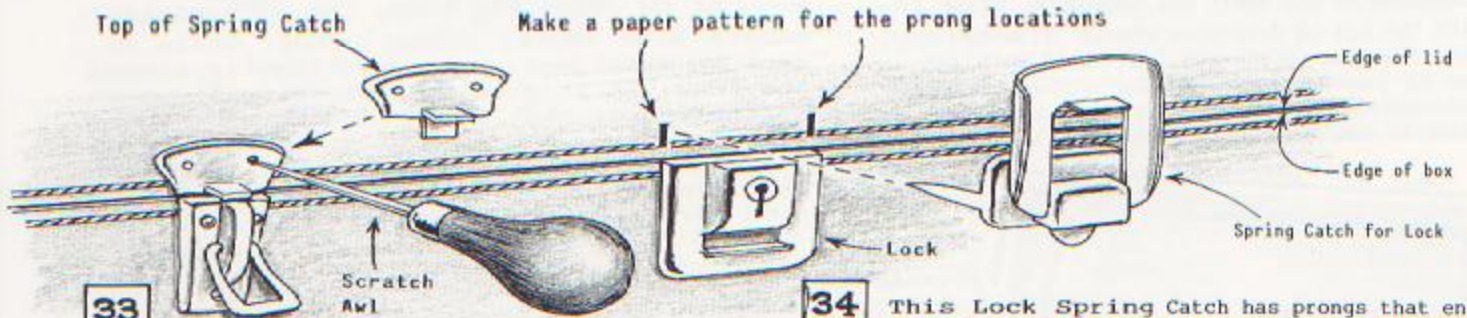
31

From step 30, fold the lining strips in, to the top of the lid as shown above. *DO NOT cement them yet!*



32

Now place the lid (with lining folded in) on the box, as shown above.



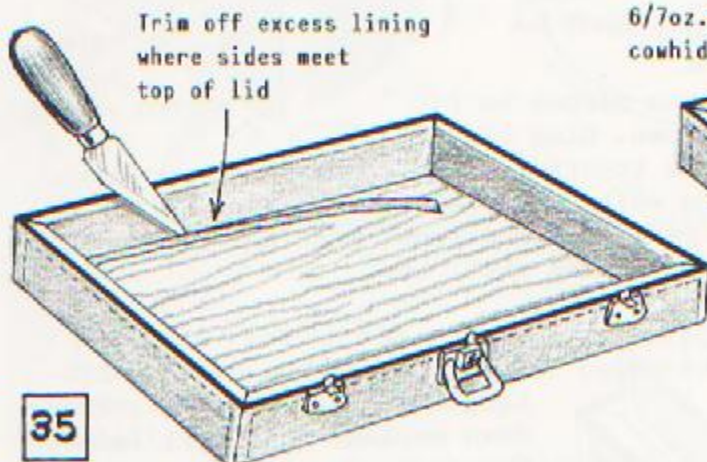
33

Be sure the lid is properly positioned on the box. Put the top of the catches in place and mark locations for the escutcheon pins. These are installed as with the catches in step 19.

Make a paper pattern for the prong locations

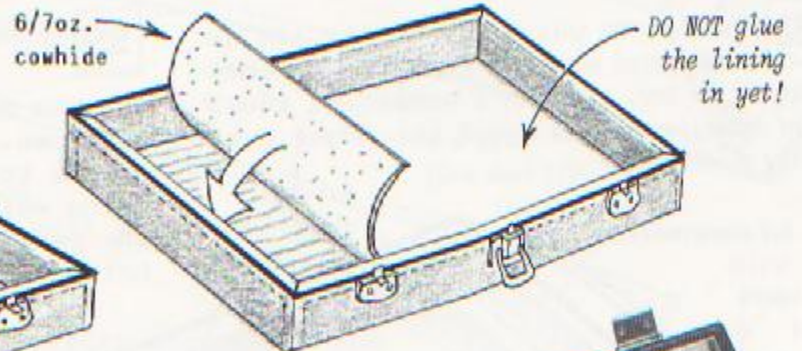
34

This Lock Spring Catch has prongs that enter near the stitching. A paper pattern is advisable to insure the proper locations (review page 30). Since these are so close to the edge, your chisel should be ground down very thin to minimize splitting. The leather, being glued to the wood, will help prevent splitting.

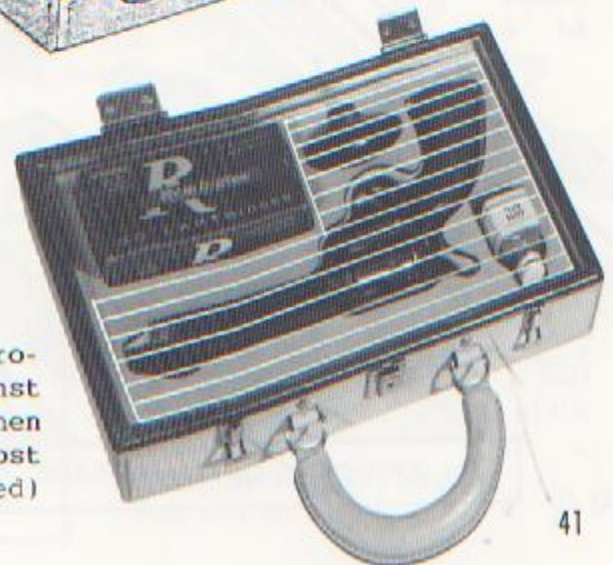


35

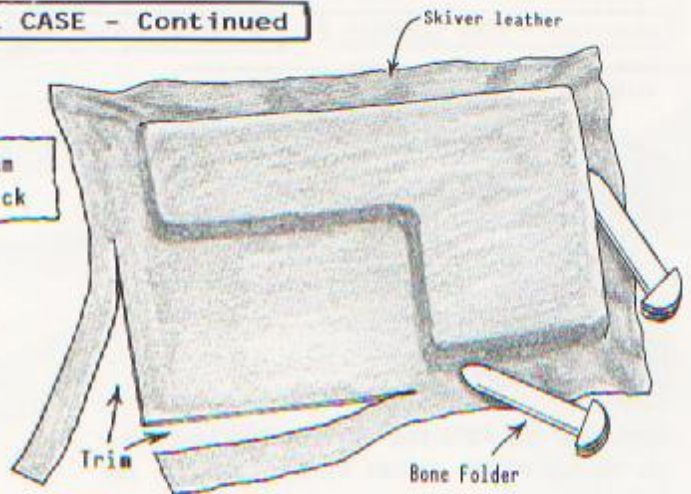
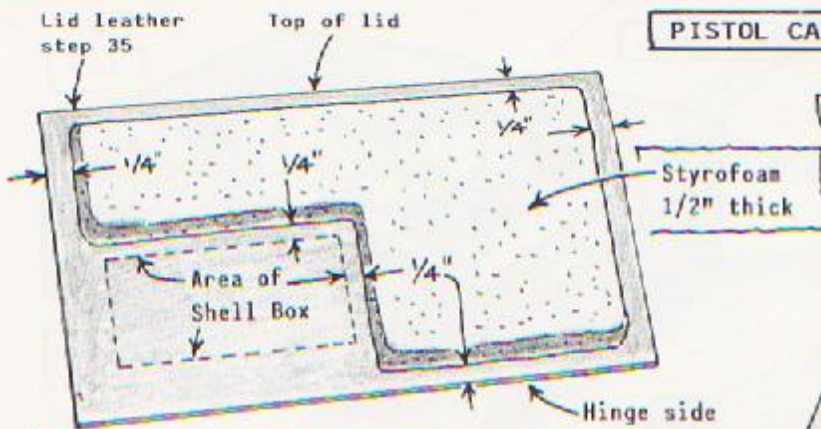
After installing the catches, follow steps 24 through 27 to complete the lid. Here the lining covers the sides. Trim excess as shown. Now cut a piece of 6/7oz. cowhide to fit snugly in lid.



The lined area in photo at right shows where Styrofoam will be put in the lid. This will press against the gun, handle, etc., to hold them in place when the lid is closed. Since the shell box will almost touch the lid, foam is not required here. (continued)

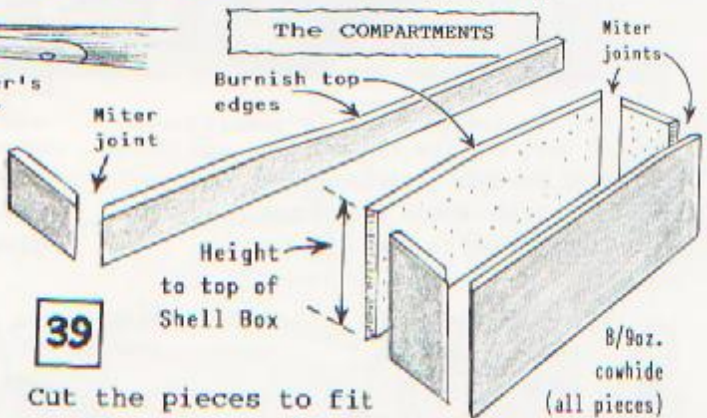
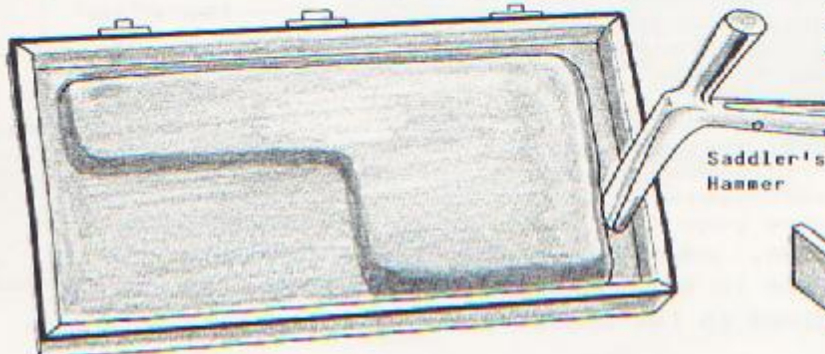


PISTOL CASE - Continued



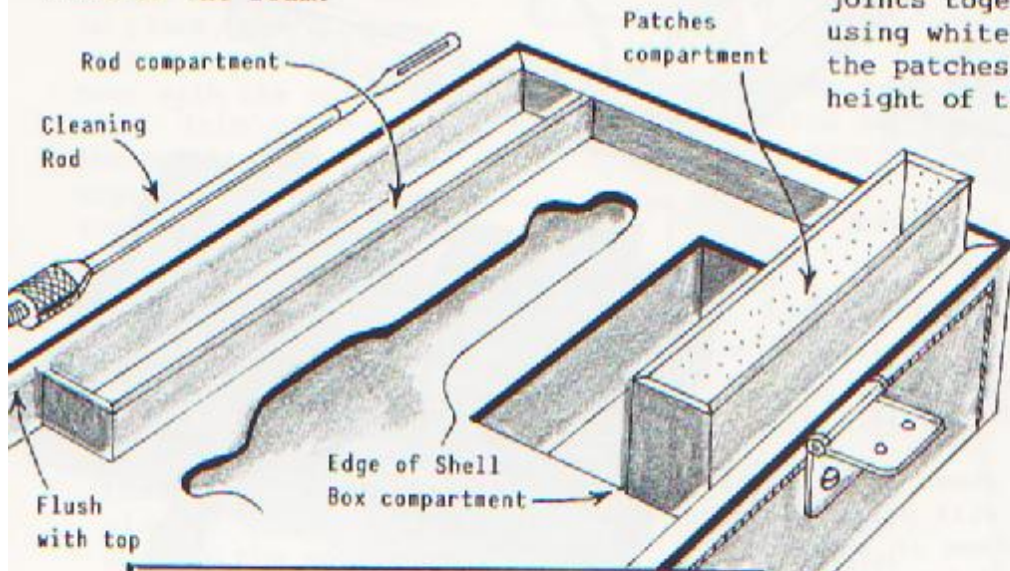
36 Remove the leather (step 35) from the lid. Cut a piece of Styrofoam to fit on the lid leather as shown above. Note the clearance at the shell box. Measure from inside the box to determine these dimensions. Glue the foam to the lid leather. The edges can be rounded a bit so the cover leather goes on easier. Foam rubber can be used in place of the Styrofoam if available.

37 Use skiver or equal lightweight leather to cover the foam. Cut it oversize; adhere with rubber cement. Cover while cement is still wet. Work down tightly around the foam. If it does not adhere well around the edges, peel loose (edges) and adhere with contact cement. Trim excess skiver at the edge of the lid leather. The shell box area can be left open to be personalized as with our case (see photo, page 34).



38 Now glue the unit inside of the lid as illustrated above. Be sure the catches are at the top. A Saddler's hammer is ideal for insuring adhesion around the edges outside of the foam.

39 Cut the pieces to fit as shown. Glue the miter joints together. Glue compartments in place using white glue for all bonding. Height of the patches compartment must not exceed the height of the shell box.



The COMPARTMENTS GLUED IN PLACE

40 Complete the case by fitting the lid on the box. Push down on lid. This will indent the foam where it presses against the gun cylinder, oil bottle and handle (see photo).

Align all corners and screw hinges to the lid. From step 23 you will know how long the screws must be to keep from coming out inside the case.

The case is complete.

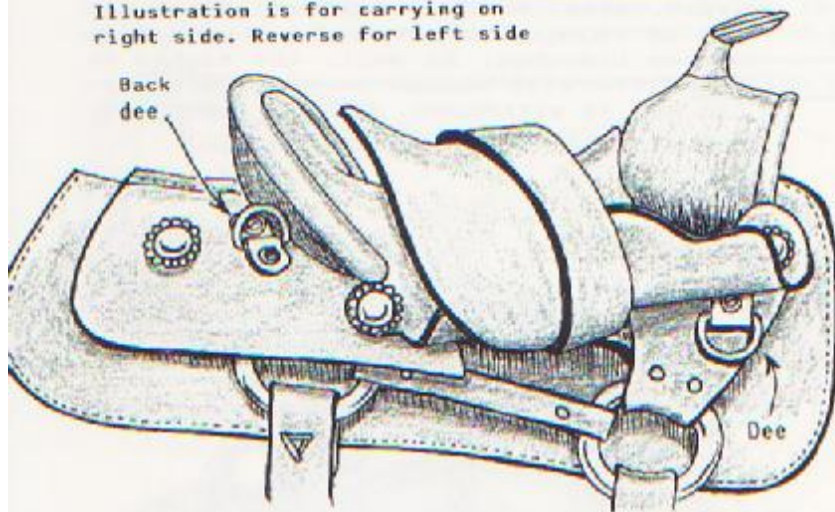
SADDLE SCABBARDS - for RIFLES

Rifle scabbards can be made from a variety of leathers depending on the useful purposes for them. The main purpose of the scabbard is for maximum protection and easier transportation of the gun on horseback. Our instructions (in this section of the book) are for scabbards to be carried on the saddle. These are made of heavy leather with special dees, straps, etc., for saddle attachment. For those simply wanting gun protection (not horseback transportation) the leather used can be lighter in weight and many of the dees, slots, and straps can be eliminated. See pages 64 through 77.

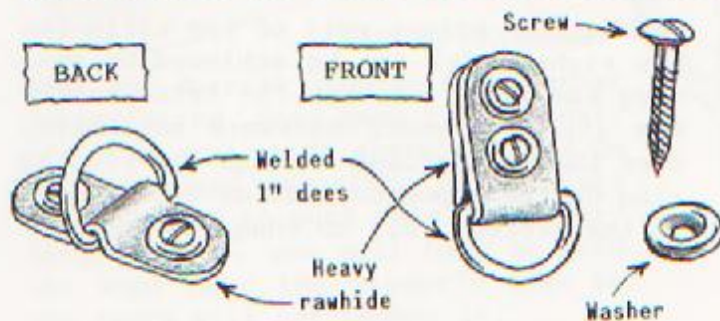
There are many ways of attaching the scabbard to the saddle. Several methods are shown. The modern saddles usually have double riggings. The scabbard straps are usually tied into the rigging rings. On our saddles, we often add extra dees especially suited to placing the scabbard in the most optimum position for the horse and rider (see below).

EXTRA DEES FOR ATTACHING THE SCABBARD

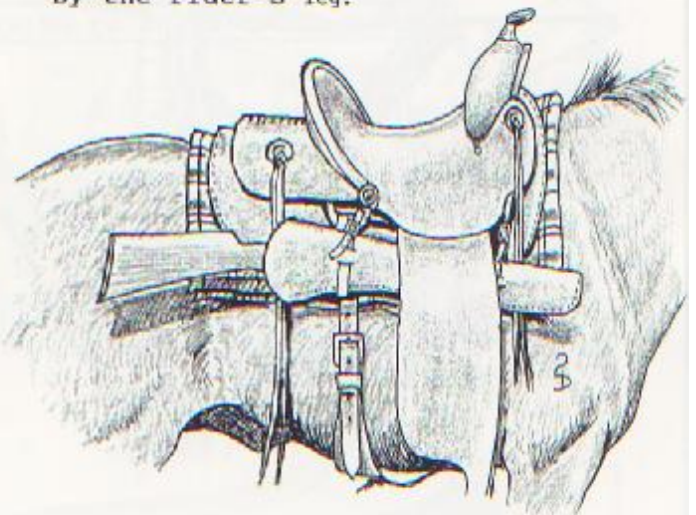
Illustration is for carrying on right side. Reverse for left side



Scabbards can ride higher and in better position by attaching dees as shown above. Use heavy rawhide strips to anchor the dees by screwing through the leather and into the wood of the saddle tree. Use the countersunk washers with the screws for more strength.



When carrying the rifle on the right side with the butt to the rear, the rider can withdraw it as he dismounts. The butt of the rifle has less chance of snagging on bushes and branches and is also protected by the rider's leg.



With the lever-action rifles the scabbard can be carried high without too much discomfort to the rider's leg. This is the ideal way to carry the gun...as high as possible. It not only makes it easier for the rider to reach while in the saddle, but also helps to offset the pull of some of the extra weight of the rifle on the right side. Lever-action rifles can easily be carried on either side of the saddle. The short-barreled lever-action carbine is the ideal saddle gun!

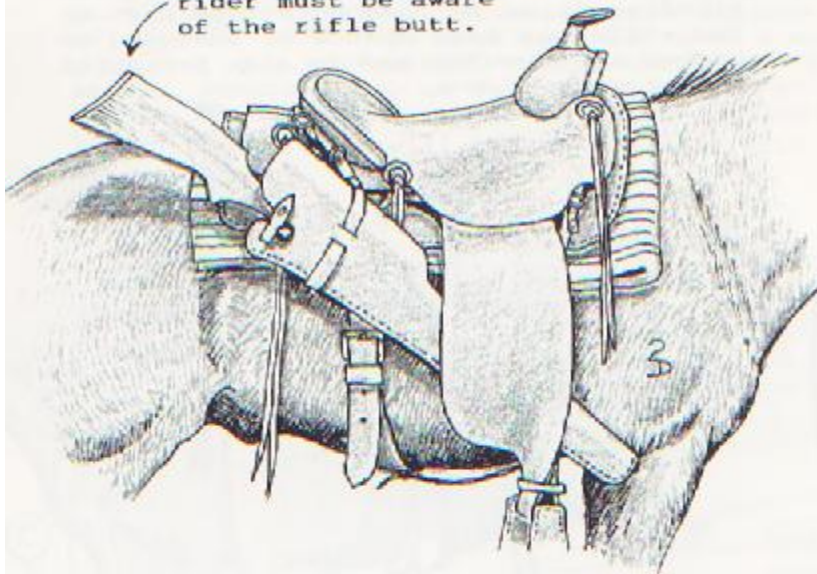
SADDLE SCABBARDS - Continued

The bolt-action rifles (especially with telescopes) are much more difficult to carry. The stocks are usually bulkier than the lever-action guns and the protrusion of the bolt limits positions in which it can be carried.

The bolt should not be placed against the horse. And...the scope should not be carried upside down where it rides against the scabbard. This could easily throw it out of adjustment. Some people carry their guns with the butt forward but this is not recommended as explained in the copy at right.

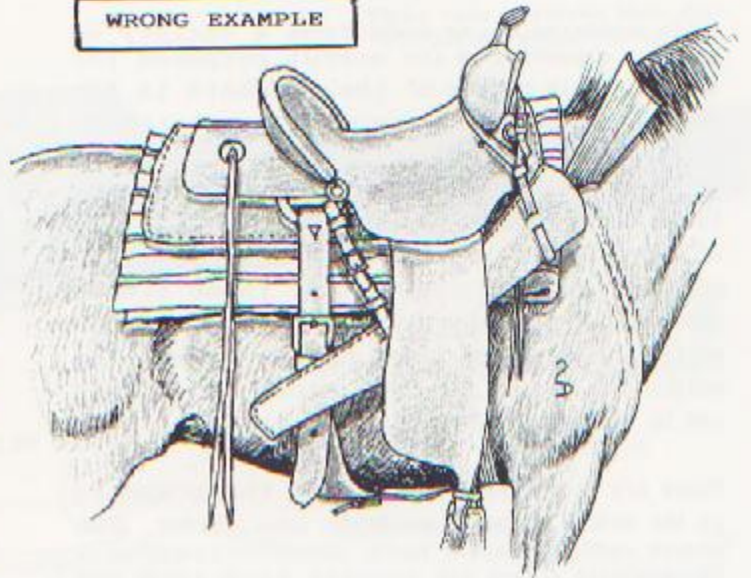
SPECIAL NOTE: We have designed a scabbard where the telescope can be carried upside down by installing a special security strap. This appears on page 48.

When dismounting, the rider must be aware of the rifle butt.



With the extra bulk of the bolt-action telescope rifle, the barrel end of the scabbard must often be lowered to minimize discomfort to the rider's leg. The extra weight also adds to the pull on the saddle to this side (see suggestion at right). The rider can compensate for this by putting a little more weight in the left stirrup, if it is required.

WRONG EXAMPLE



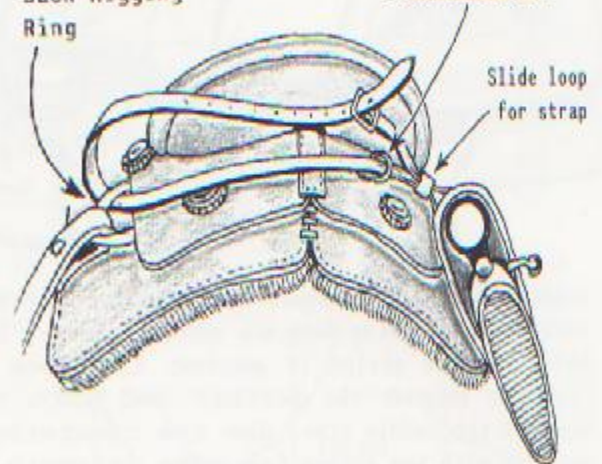
Too often we see pictures with rifles carried in this manner. Although the gun is easily withdrawn while the rider is in the saddle, there are some objectionable features:

The rifle butt is subjected to snagging on low hanging branches, and heavy brush. Also, the open scabbard allows entry of rain, snow, leaves and sticks from broken branches. As well, the sights of the rifle will scrape on the leather as the gun is withdrawn. This is especially undesirable for telescope sights!

Back Rigging Ring

Extra Cattle dee

Slide loop for strap



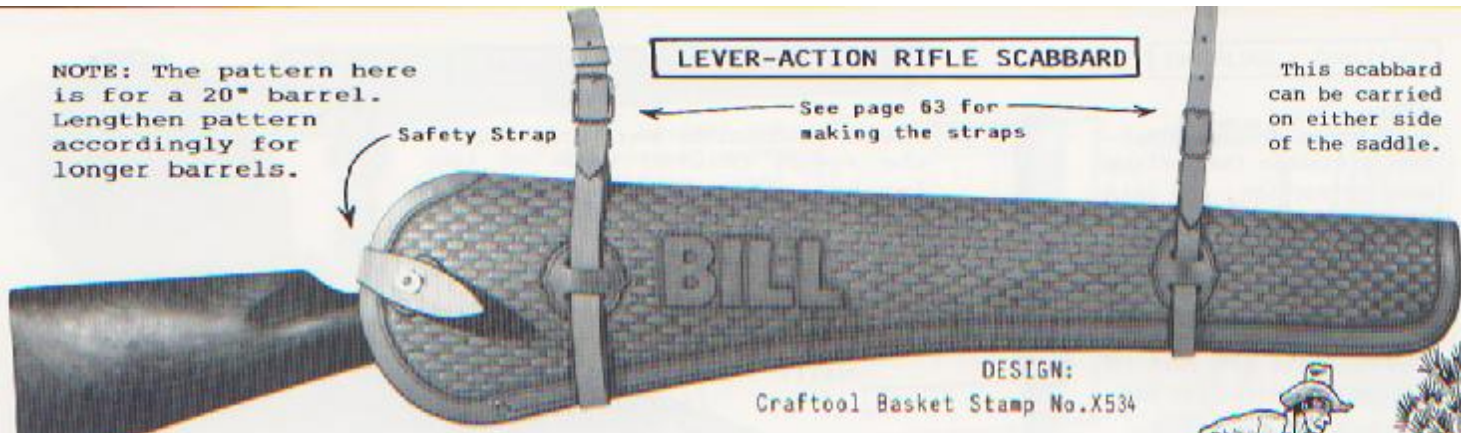
Some of the offset pull of the rifle (to the right side) can be achieved by running the strap through the extra cattle dee (this prevents backward movement), over the jockeys, and through the rigging ring on the opposite side as shown above in the sketch. Pull up snug and buckle.

NOTE: The pattern here is for a 20" barrel. Lengthen pattern accordingly for longer barrels.

LEVER-ACTION RIFLE SCABBARD

See page 63 for making the straps

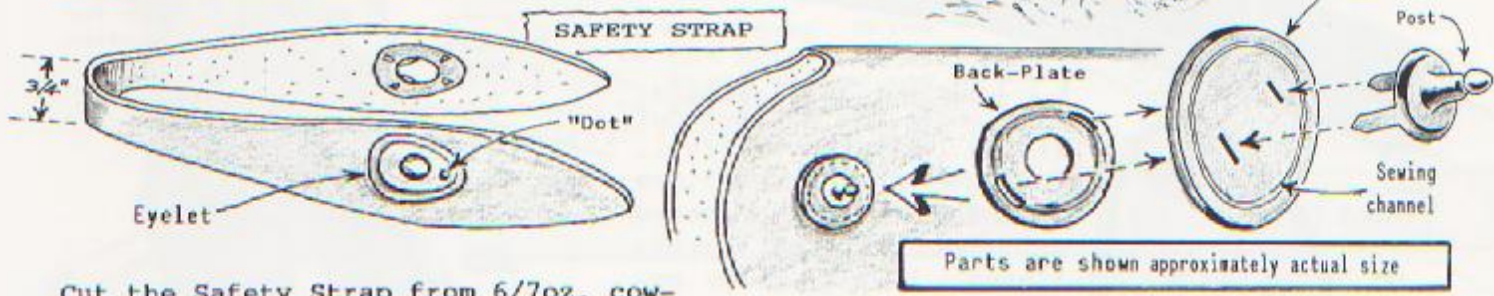
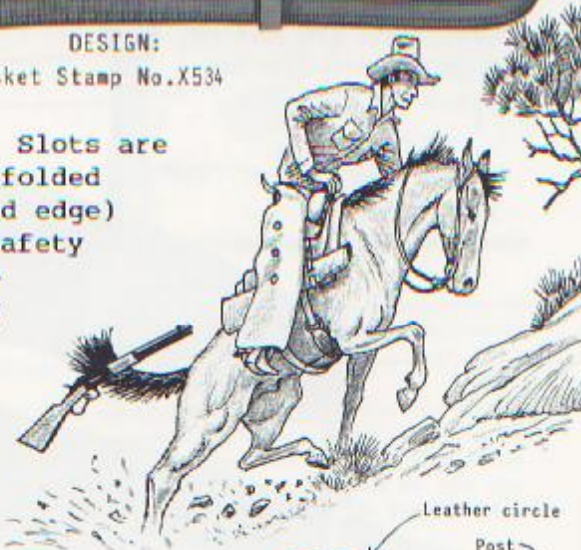
This scabbard can be carried on either side of the saddle.



DESIGN:
Craftool Basket Stamp No.X534

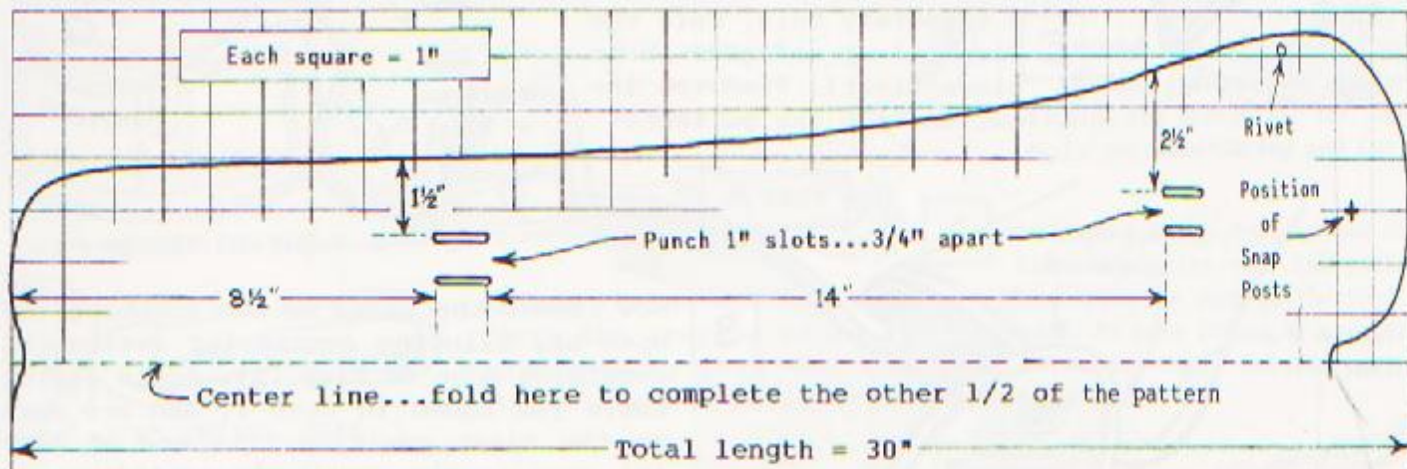
This is the simplest of all rifle scabbards to make. Slots are punched in the sides for the straps. The leather is folded over and sewn together. A filler leather (at stitched edge) was not used. Many of the old-timers did not use a safety strap. However, without one, the rifle is subject to slipping out of the scabbard when a horse is jumping a log or lunging up a steep bank.

Cut the scabbard from 10oz. to 14oz. cowhide. If it is to be lined, then cut it from 7/8oz. leather. An end plug should be used (see page 70 for examples). Cement the edges together, install the end plug and sew. Burnish the edge. Install a No.9 copper rivet where the stitching begins. This secures stitching.



Cut the Safety Strap from 6/7oz. cowhide. You cannot determine the length until the posts have been installed on the scabbard. Install Lift-the-Dot eyelets on each end of the strap. Be sure you have the "DOT" in the proper place...towards the end of the strap.

Since the prongs of the Lift-the-Dot posts aren't long enough to properly clinch in thick leather, they have to be mounted on about 6/7oz. leather. This is glued to the scabbard and sewn. By attaching a post on each side, the Safety Strap is easily released when gun is on either side of saddle.



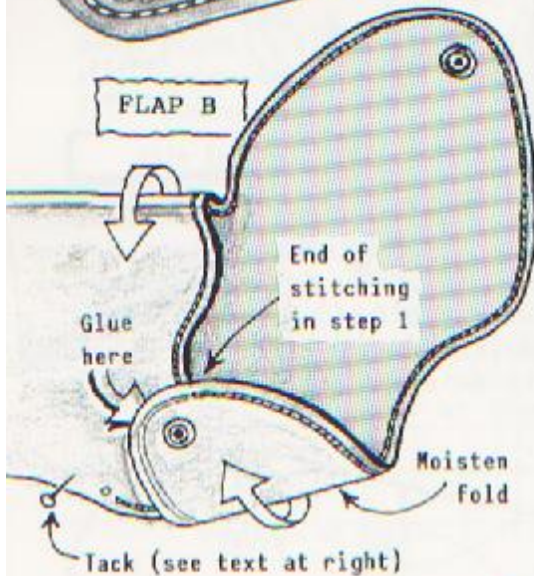
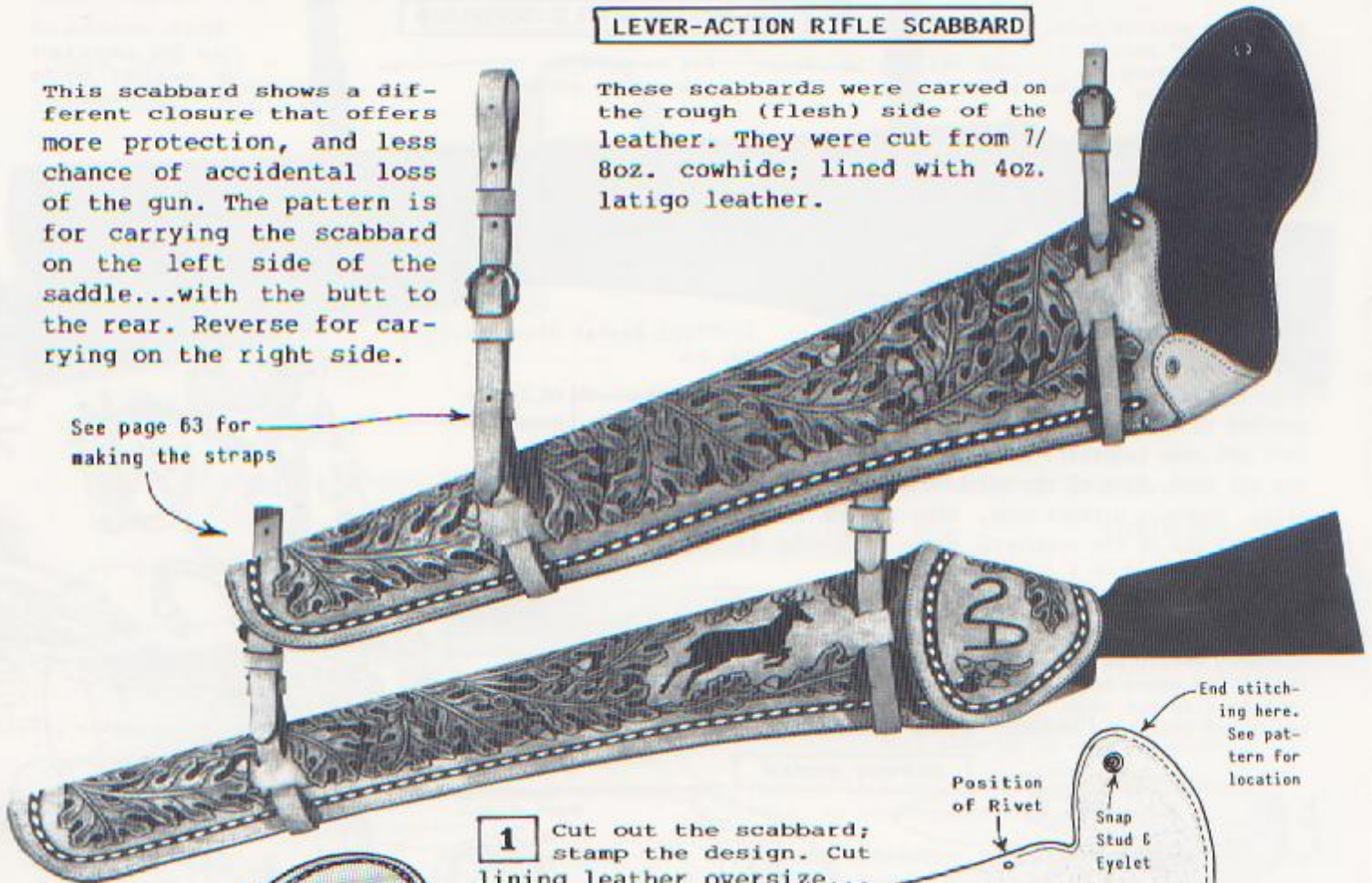
1/2 PATTERN for 30-30 Winchester CARBINE. LEVER-ACTION. 20" barrel

LEVER-ACTION RIFLE SCABBARD

This scabbard shows a different closure that offers more protection, and less chance of accidental loss of the gun. The pattern is for carrying the scabbard on the left side of the saddle...with the butt to the rear. Reverse for carrying on the right side.

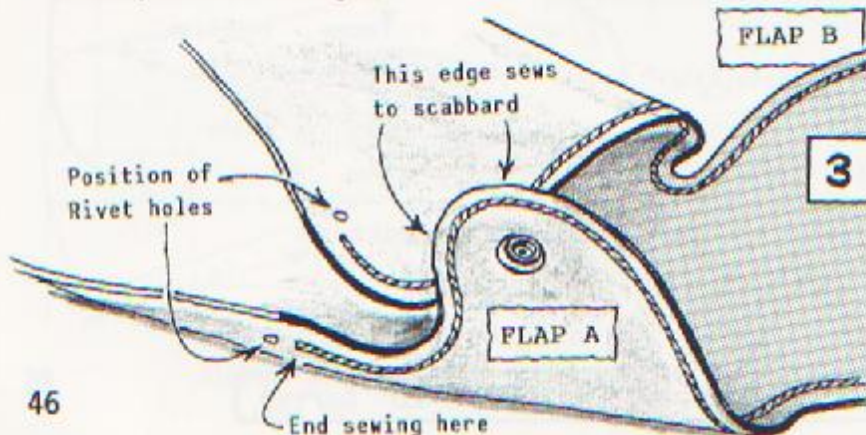
These scabbards were carved on the rough (flesh) side of the leather. They were cut from 7/8oz. cowhide; lined with 4oz. latigo leather.

See page 63 for making the straps

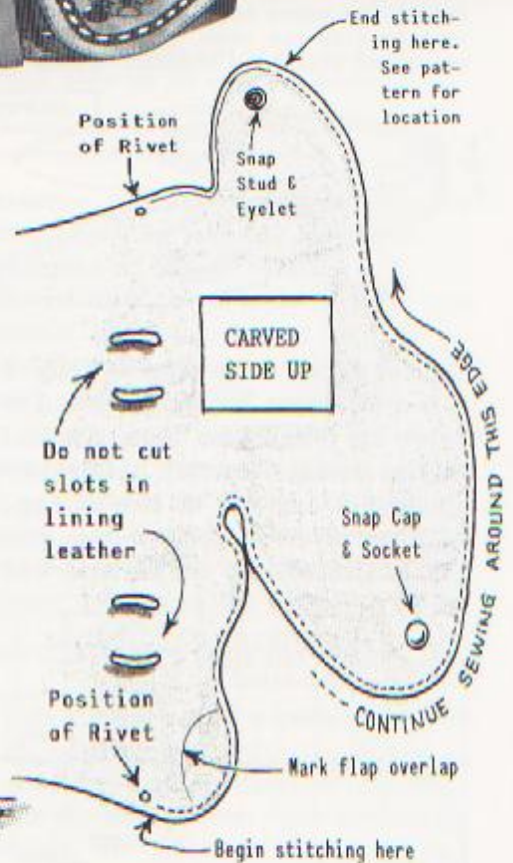


1 Cut out the scabbard; stamp the design. Cut lining leather oversize... and cement in place. Sew around the edge, indicated at right. Trim off excess lining...burnish edge between the rivet holes. Install Durable Dot Snaps in their proper positions.

2 Fold the scabbard together and tack the bottom edges together for a temporary hold. Fold the Flap (A) up and glue it in place (left). Find the location from the pattern.



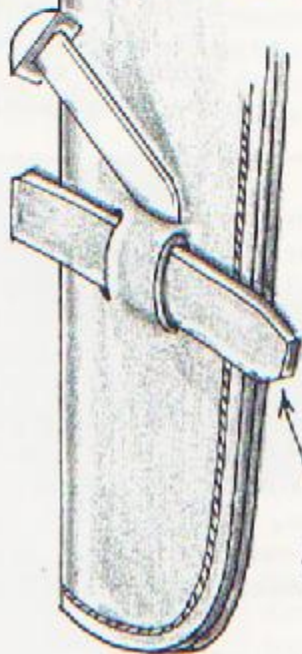
3 Now remove the tacks so the scabbard can open up, allowing access for sewing the remaining edge of Flap (A). Begin sewing where you ended in step 1, and sew down to the rivet position. The end of Flap (A) sews to the scabbard, as indicated. You will have to reach one hand inside the scabbard to accomplish the sewing.



End Plug

4

Fold the scabbard back together and glue the edges. Include the end plug (see page 70 for instructions). Set a No.9 copper rivet in place. Gouge sewing channels on both sides; sew. Burnish the edges.

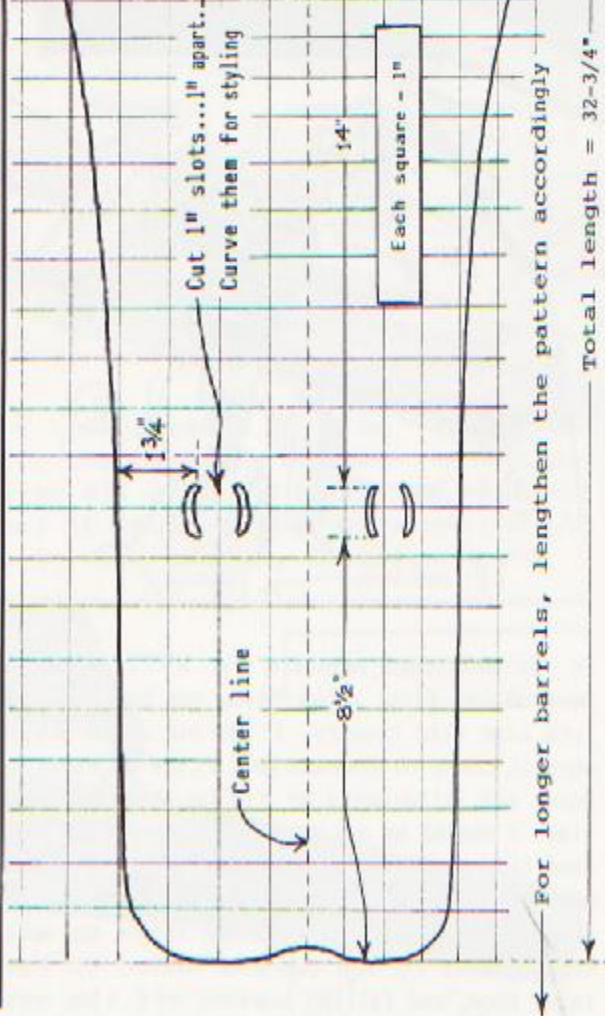


7/8oz. cowhide - 3/4" wide

5

Thoroughly moisten the strap loops and force a wooden loop-stick in the slots, or scrap of leather as shown at left. Press the sides down and allow to dry before removing the form. With no slots in the lining ...this makes a very smooth interior for the rifle.

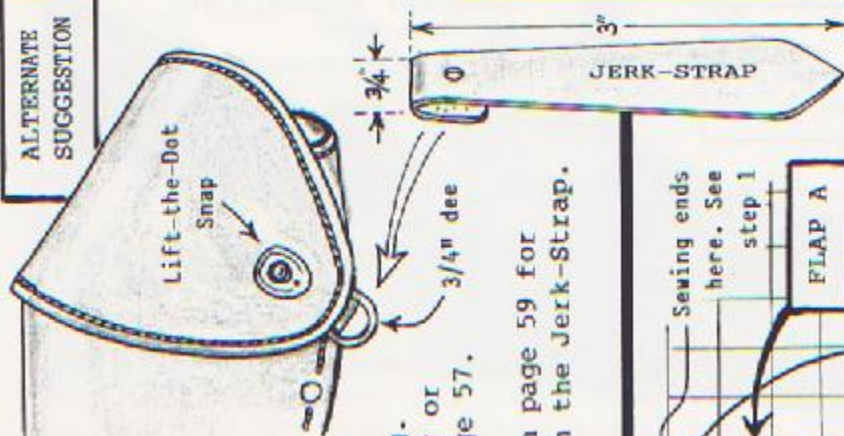
PATTERN FOR 30-30 LEVER-ACTION WINCHESTER CARBINE - 20" barrel



NOTE:

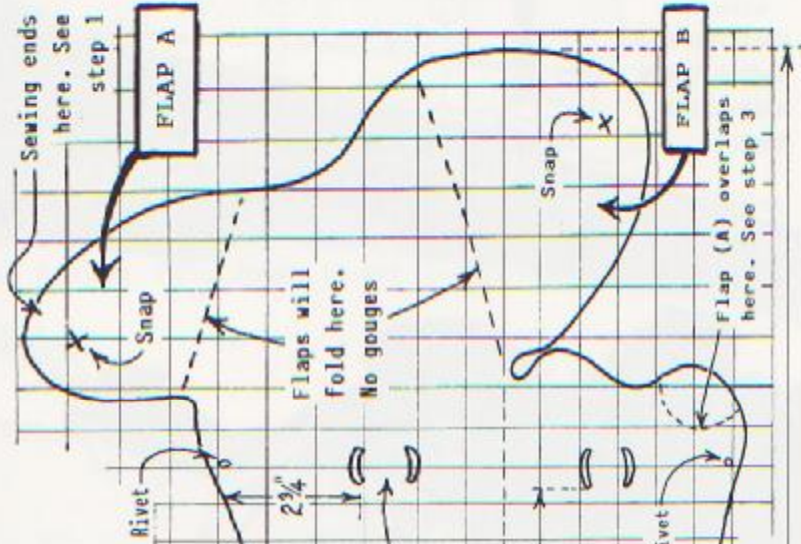
A Lift-the-Dot Fastener can be used if desired. A Jerk-Strap then is recommended for faster opening of the flap. The tabs of the dee are sewn between the flap and its lining. Tabs can be leather or rawhide...as on page 57.

ALTERNATE SUGGESTION



See the scabbard on page 59 for more information on the Jerk-Strap.

The pattern below is shown with the carving (finished) side up. It is for carrying on the left side of the saddle. Reverse pattern for right side.



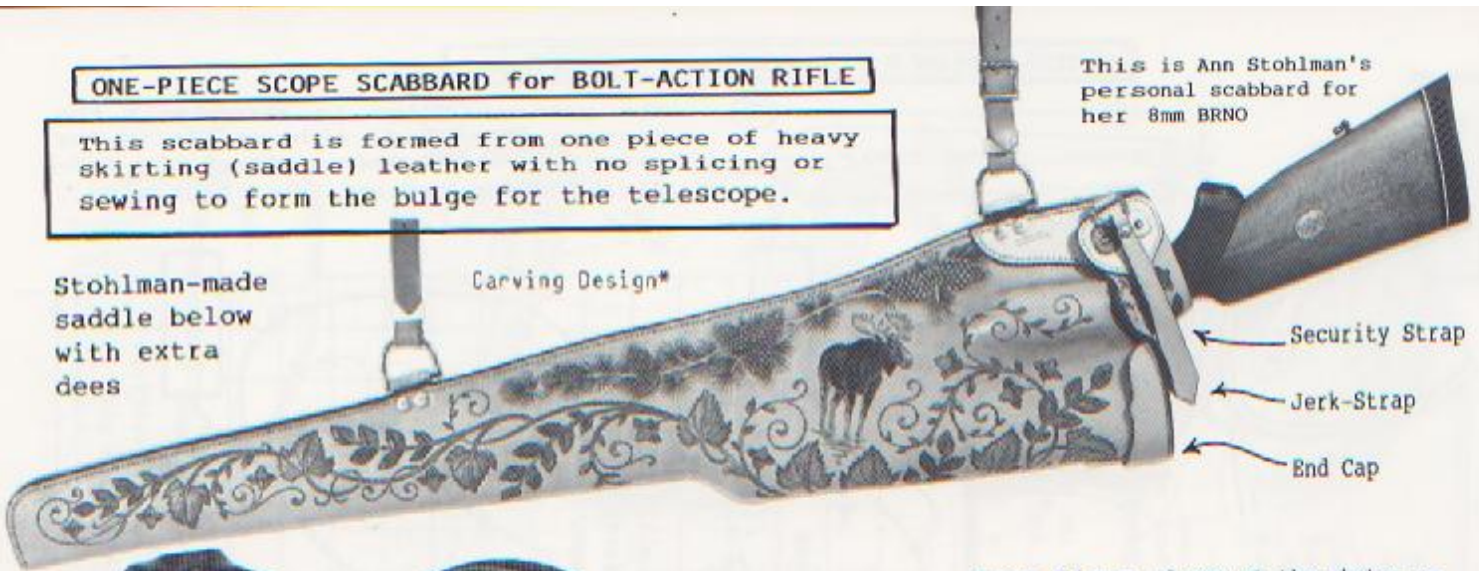
ONE-PIECE SCOPE SCABBARD for BOLT-ACTION RIFLE

This scabbard is formed from one piece of heavy skirting (saddle) leather with no splicing or sewing to form the bulge for the telescope.

This is Ann Stohlman's personal scabbard for her 8mm BRNO

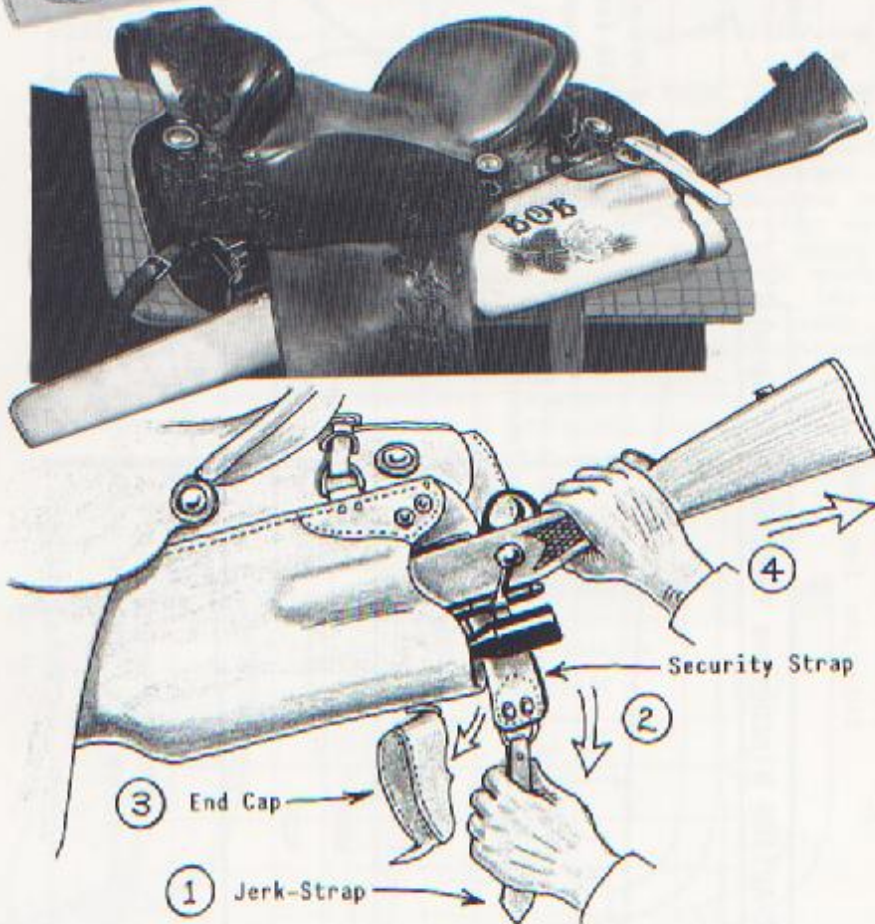
Stohlman-made saddle below with extra dees

Carving Design*



Your first glance at the photos above, and at left, will have you thinking this is not a proper way to carry the rifle, as the scope is riding against the leather below it. *NOT SO!* The Security Strap tightly holds the rifle stock up so the scope is clear, not touching the leather. This scabbard allows the hunter to carry his bolt-action scope-mounted rifle on the same side of the horse where he, or she, usually dismounts.

This makes for quick action...as seen in the sketch at left. When you are free of the stirrup, your left hand pulls down on the Jerk-Strap (1) which releases the Security Strap (2). At the same time, the End Cap (3) falls down out of the way as you are simultaneously withdrawing the rifle (4). It all happens in one fluid motion. Your horse may continue to move...as is often the case when you are hurrying, and he will actually pull the scabbard off of the rifle, making the withdrawal even faster!

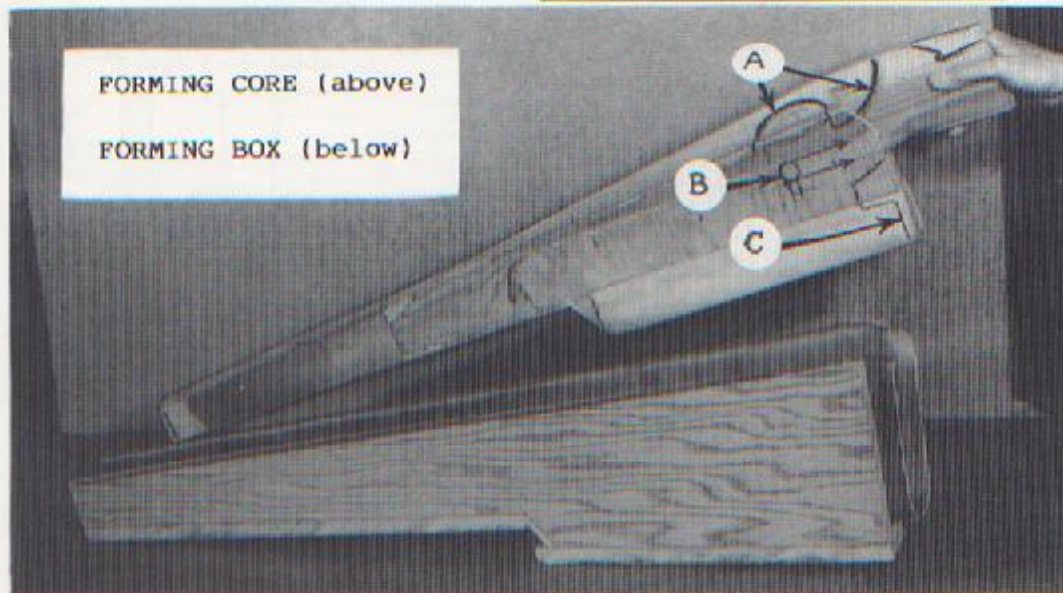


We designed this scabbard in 1972 when we went on our first moose hunt on horseback, into some wild country. I am no John Wayne when it comes to dismounting from a running horse and withdrawing my rifle at the same time. I wanted my gun on the near side (the same side where you dismount). If the scope was up, then the bolt would be rubbing on the horse; not practical! So we came up with this design. The End Cap was added to keep rain, snow, and falling leaves off the eyepiece of the scope. When riding under snow-

laden trees, it worked beautifully. We had a very successful trip. Hunting for moose in wilderness country without pack horses is not desirable, unless you are young and strong. Since our first design we have custom-made many more of these scabbards for hunter friends and ranchers. They have withstood the test very well in spite of all of the rough use and inclement weather.

So, we offer this scabbard to you. It is not easy to make, but we feel you can be successful if you follow our instructions.

SCOPE SCABBARD - Continued



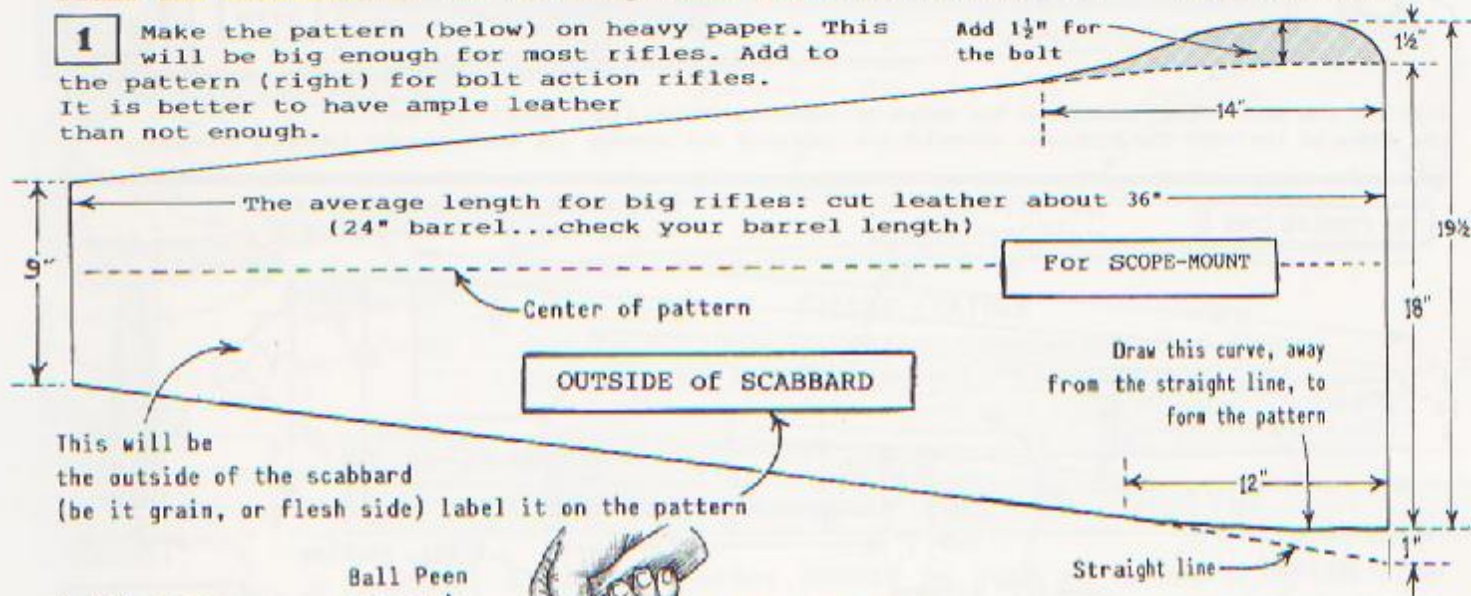
FORMING CORE (above)
FORMING BOX (below)

The first things you will need to mold the scope area...are the parts shown at left.

Place the gun on the core piece and mark around it as shown at left. (A) Is outline of trigger guard and stock. (B) Position of bolt. (C) The end of scope. NOTE: These marks will vary with different rifles. Our core & box are crudely built, but served the purpose. We have made many scabbards with these forms.

Plans and instructions for building these units are on page 50.

1 Make the pattern (below) on heavy paper. This will be big enough for most rifles. Add to the pattern (right) for bolt action rifles. It is better to have ample leather than not enough.

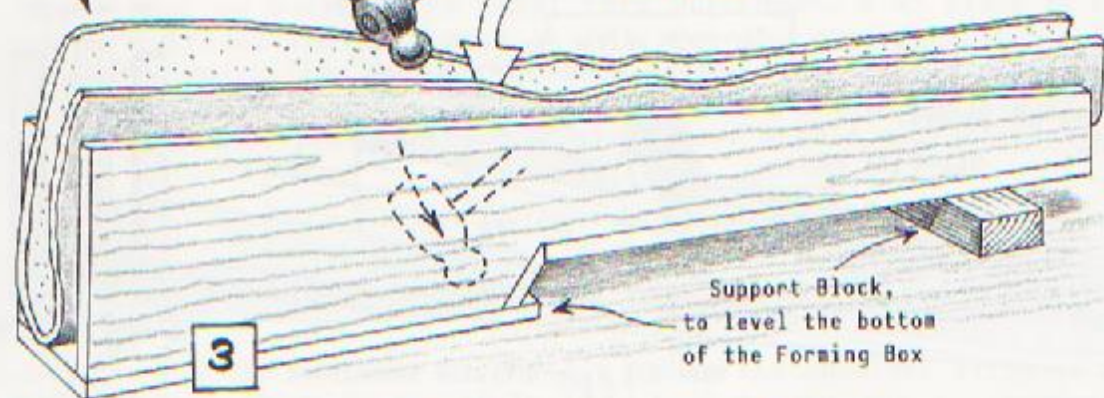


This will be the outside of the scabbard (be it grain, or flesh side) label it on the pattern

Bolt leather extended here

Ball Peen Hammer

Drive the hammer forcefully in the area shown



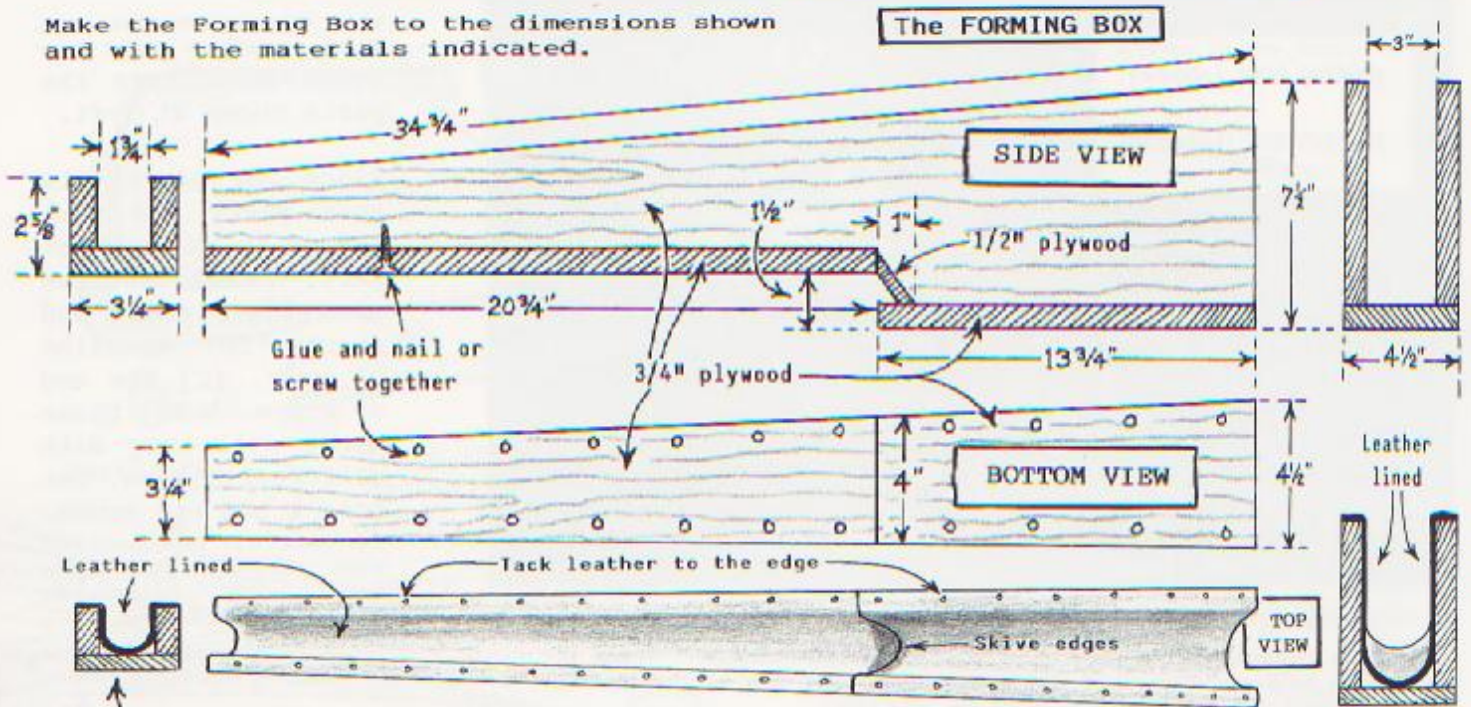
Support Block, to level the bottom of the Forming Box

2 Cut the pattern from 12 to 16oz. skirting leather and soak it thoroughly in water. "Case" it overnight. Casing is very important for better forming results. Fold the leather and place it in the box. Make sure you fold it in the center. The bolt leather should be extended, as in sketch.

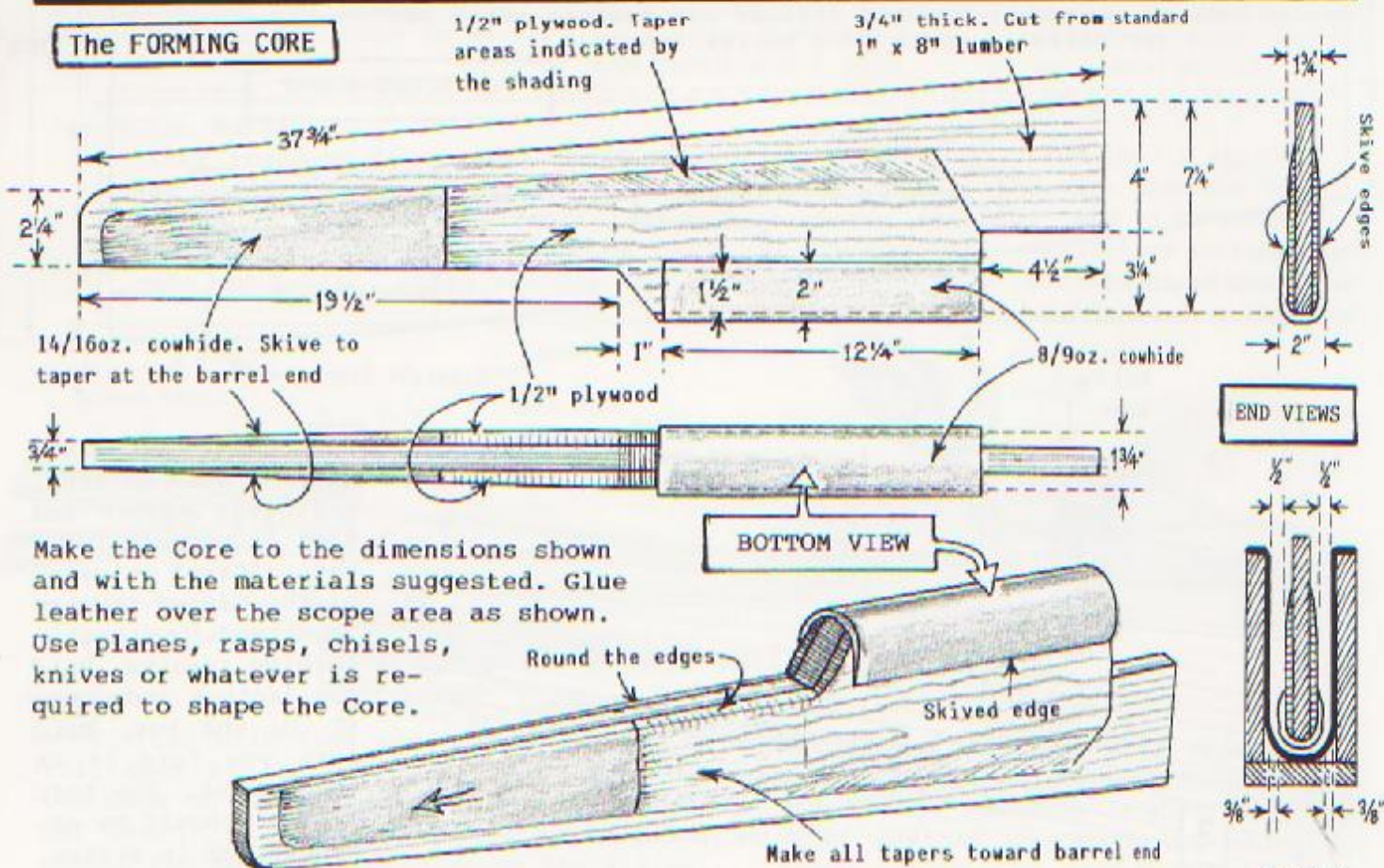
Force the leather down into the scope area as far as you can with your hands. Then hammer the area at the scope end to stretch it as much as possible. Tap along the barrel length to set the leather down. (continued)

MAKING the FORMING BOX and the FORMING CORE - for SCOPE SCABBARDS

Make the Forming Box to the dimensions shown and with the materials indicated.



Line the Box with $\frac{7}{8}$ oz. cowhide to make a smooth interior. Nail it to the edges of the Box. The bottom should be curved as shown in end views (solid black).

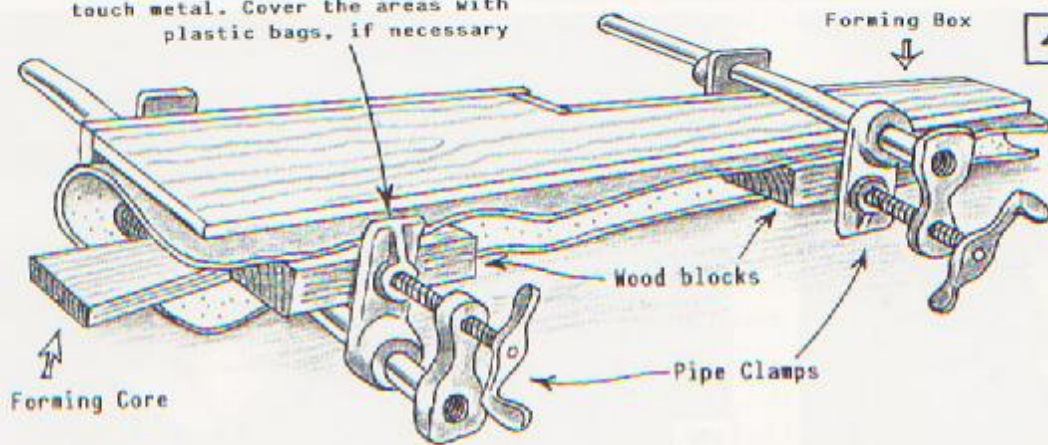


Make the Core to the dimensions shown and with the materials suggested. Glue leather over the scope area as shown. Use planes, rasps, chisels, knives or whatever is required to shape the Core.

It doesn't matter how rough the Core is shaped or what fill-in materials are used, as long as they match the suggested dimensions.

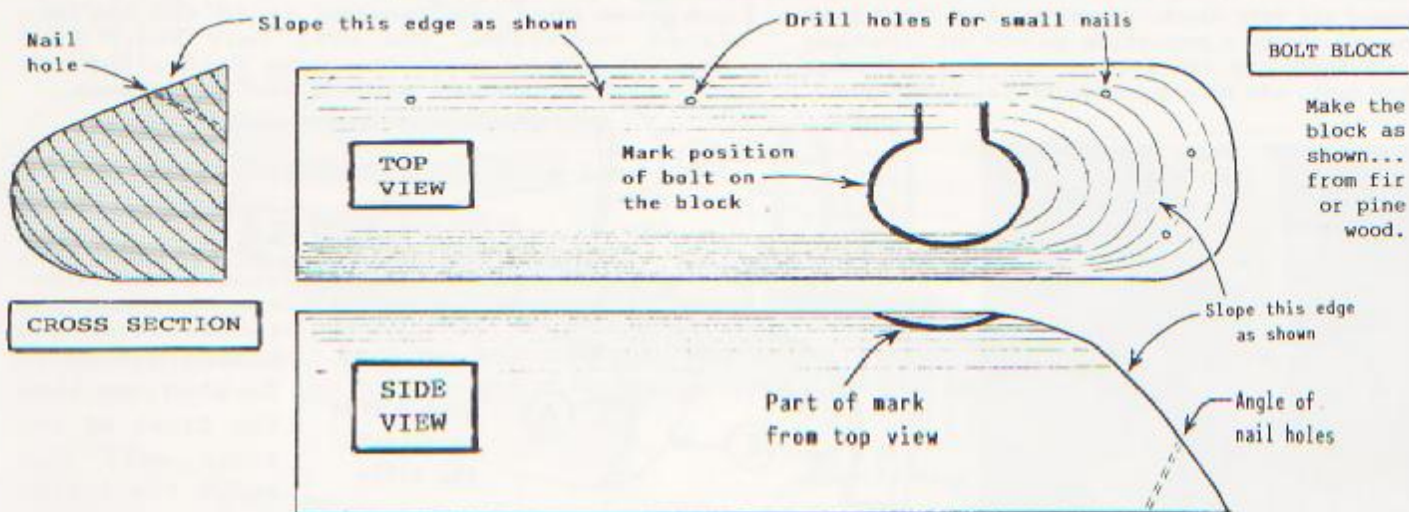
Suggested clearance within the box (above)

DO NOT allow any wet leather to touch metal. Cover the areas with plastic bags, if necessary

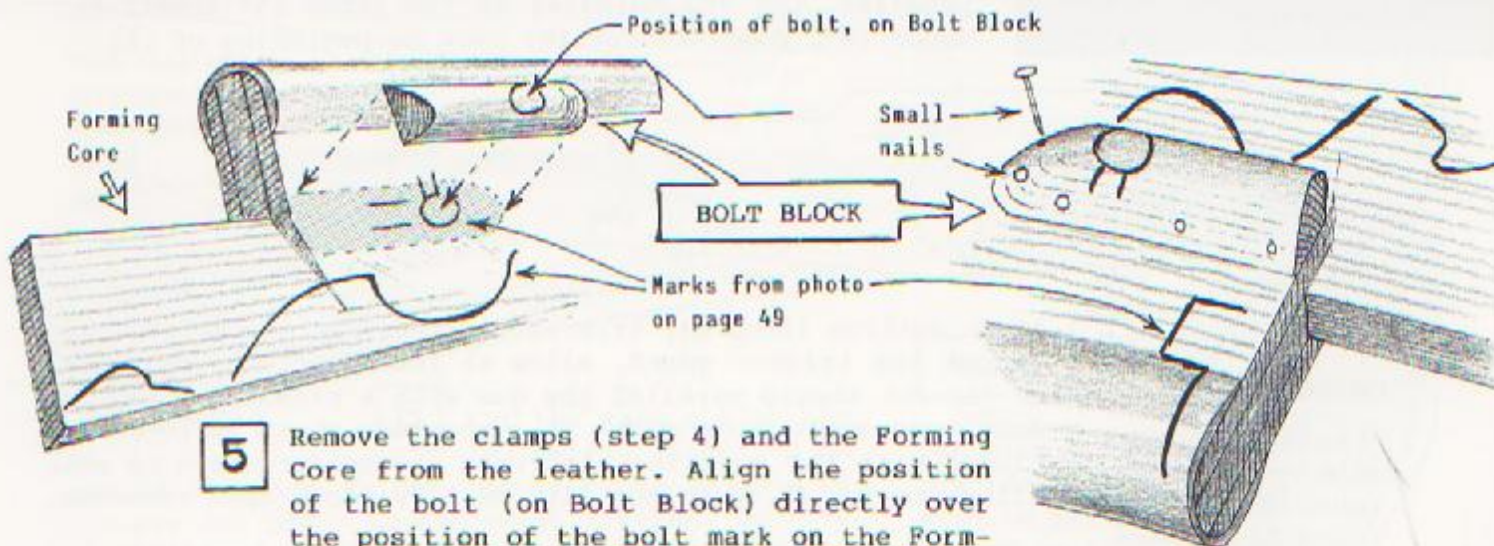


4 Now put the Forming Core inside the leather. Push it up against the scope end...that was hammered down in step 3. Lay the unit on your bench and clamp it together as illustrated at left. Turn the screws in as far as you can. Leave the project until the next day, as it will take a while for it to begin drying.

MAKING the BOLT BLOCK - Shown Actual Size

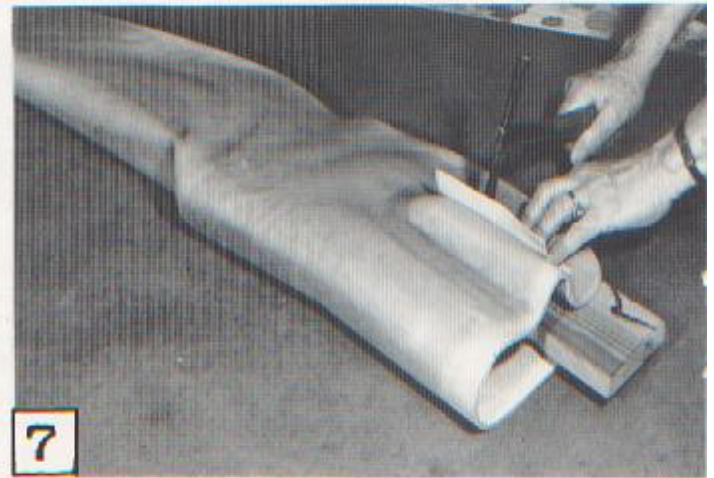


This Block is necessary to form the leather for the bolt. It will be used in different positions for different rifles.



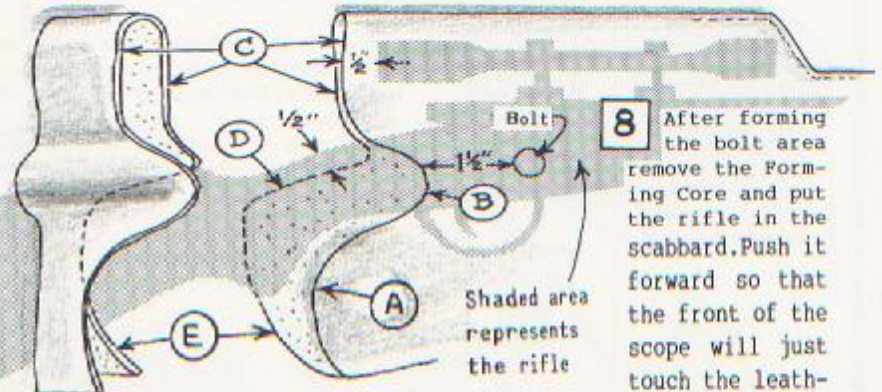
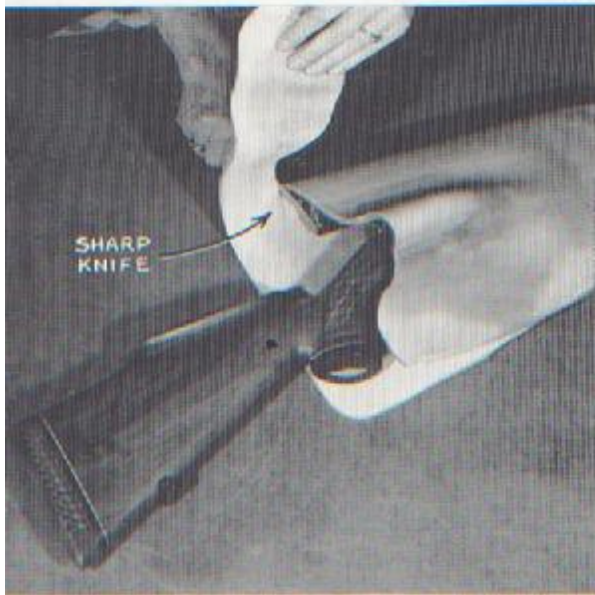
5 Remove the clamps (step 4) and the Forming Core from the leather. Align the position of the bolt (on Bolt Block) directly over the position of the bolt mark on the Forming Core and nail in place as shown above.

(continued)



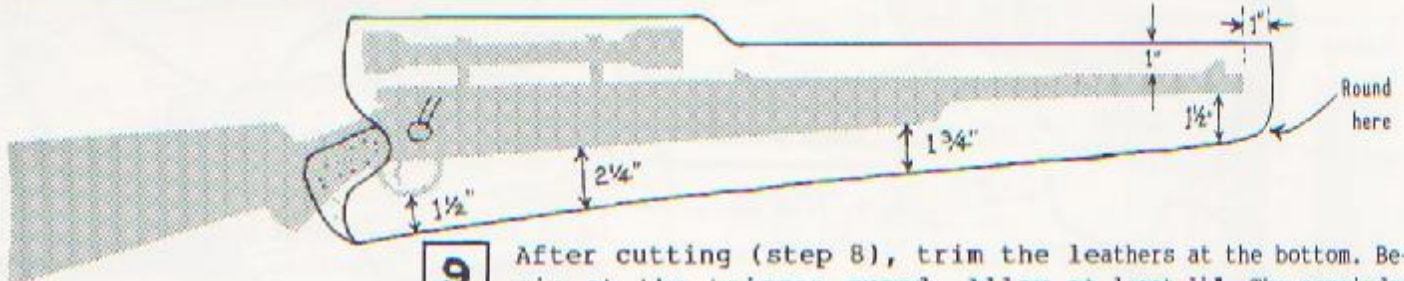
6 Remove the leather from the Forming Box and replace the Forming Core. Begin shaping around the Bolt Block. Start with a Cobbler's hammer, using a protective piece of leather underneath. If the leather is drying much too fast, add more moisture with a sponge.

7 Use the same procedure with the Saddler's hammer at the sharp fold. Best results are achieved when the leather is in the optimum cased condition. You will only learn this through experience. The Bone Folder can also be used to form around the Bolt Block.



8 After forming the bolt area remove the Forming Core and put the rifle in the scabbard. Push it forward so that the front of the scope will just touch the leather at the bulge.

Begin cut (A) following the contour of the stock. Curve in at bolt (B) then back out to make cut (C). See photo. Continue cutting down the back side. Cuts (C) should be parallel. Cut (D) parallel to the stock ($\frac{1}{2}$ " lower) for about $2\frac{1}{2}$ ". Complete cut (E) back to beginning of (A).



9 After cutting (step 8), trim the leathers at the bottom. Begin at the trigger guard. Allow at least $1\frac{1}{2}$ ". The remainder of the cut should parallel the gun with a pleasing line, but must have ample clearance. If a shoulder strap is to be included with the gun, then increase the measurements to make allowance for it. Wipe gun with an oily cloth upon removing.

CARVING a DESIGN?

If you are going to carve a design, check the moisture content. Add moisture where required. Put the scabbard in a plastic bag until you are ready to carve and stamp. Once the leather has dried out it will be difficult to get moisture properly back in. Cutting & stamping may not be as deep as desired.

Be sure to monitor your moisture content at all times. When you see areas drying out, continually add moisture.

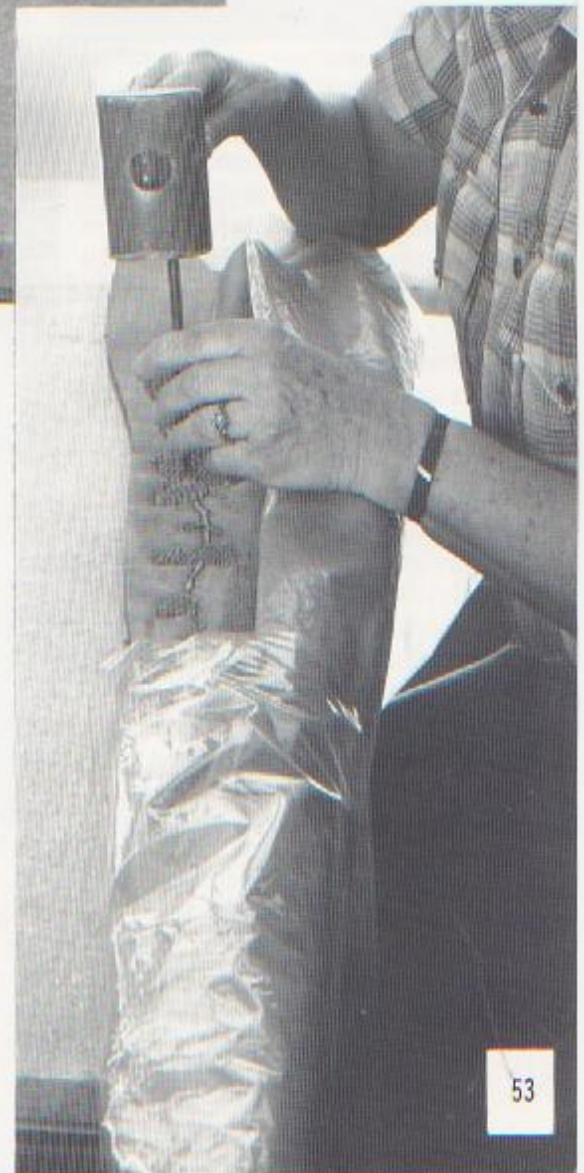


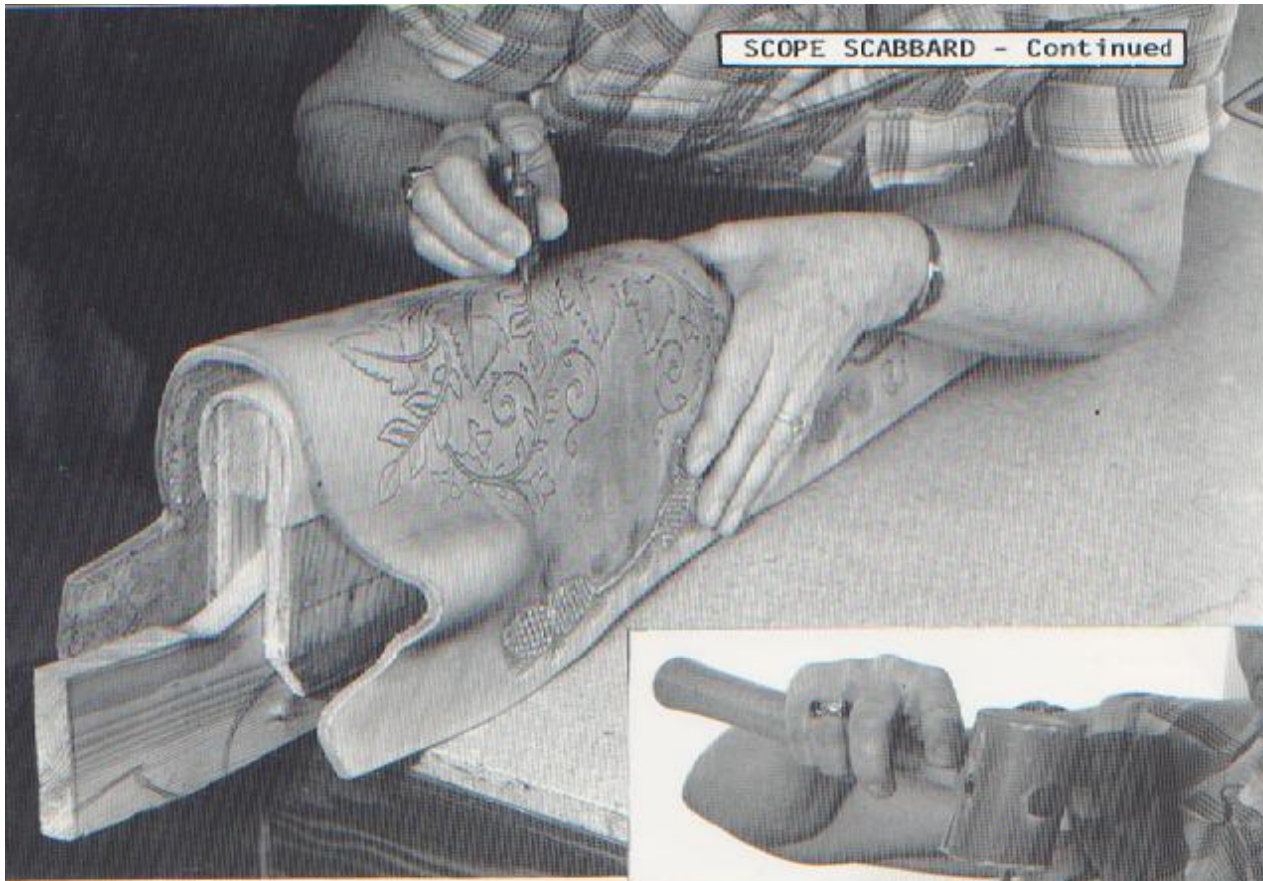
TRACING the DESIGN

Make the Tracing Pattern on a large sheet of paper and cut it to the same size as the leather cuts in steps 8 and 9. If you want a full carving you will have to make the pattern as in the photo...to fit over the scope and barrel areas. Hold the pattern firmly in place while you trace the design.

10 The pattern for this design was created from segments of the patterns shown in our book: "Inverted Leather Carving". First, draw in the scroll lines then add the leaves and berries. The moose was stamped inverted. See "Figure Carving Finesse" for details on carving hundreds of animals, birds, etc. The photo above shows the Forming Core in place while the tracing transformation is taking place. While the Core is in place, cut the flat side of the scabbard pattern. We will get to the curved areas at the top of the scope bulge and the barrel, later.

11 After cutting the pattern on the side of the scabbard, remove the Forming Core and spread the scabbard apart. Put the side to be stamped on the edge of your marble as shown at right and begin stamping the pattern. Stamp a section at a time, keeping the remaining leather wrapped in plastic to prevent moisture loss. (continued)

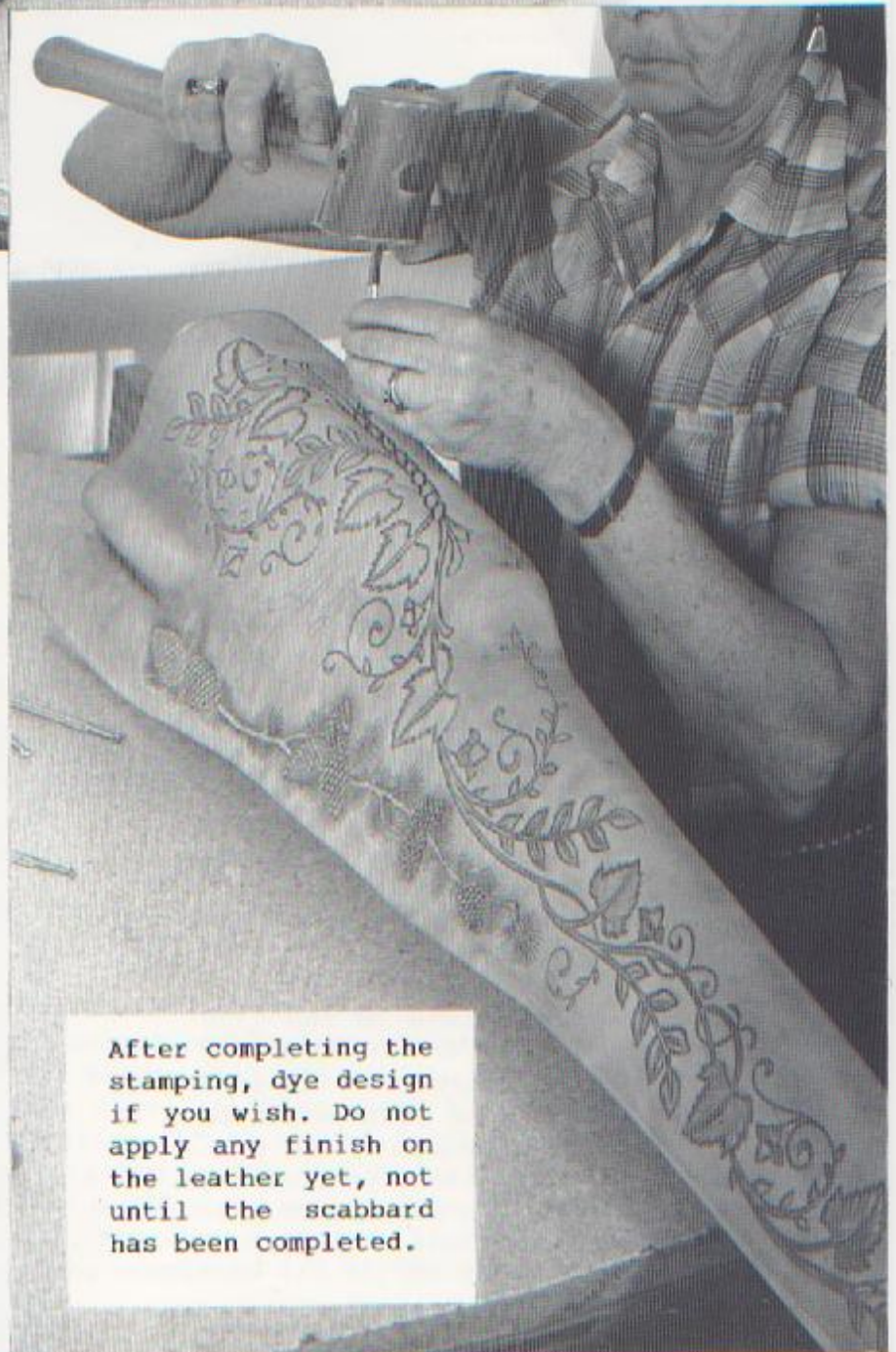




Cutting and stamping over rounded surfaces is not so difficult, but it requires the concentration and patience to achieve the desired results.

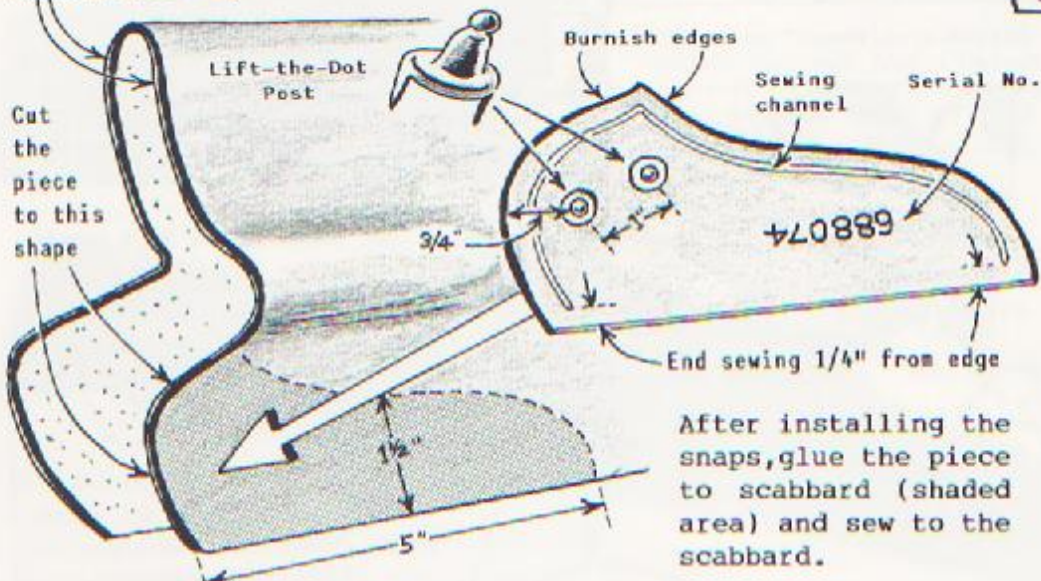
12 To cut the rounded areas over the barrel and scope, replace the Forming Core in the scabbard and stand it on your bench as shown above. The photo clearly shows the thickness of the leather (16oz.).

13 The Forming Core is also necessary to stamp rounded barrel and scope areas (right). Some areas will require your stamping hand (holding tool) to simultaneously press against the leather to steady the unit. You may want to enlist the aid of a friend to steady the unit. The scabbard can be layed down on its back to stamp the forward areas of the scope bulge. Stamp against the Forming Core. You'll notice that the bolt area has been stamped (see photo, page 48). This is accomplished by stamping directly on top of the Bolt Block.



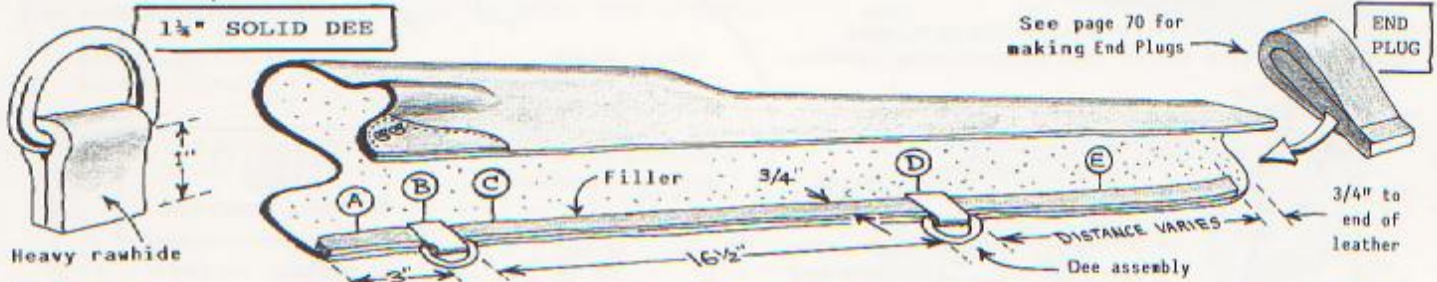
After completing the stamping, dye design if you wish. Do not apply any finish on the leather yet, not until the scabbard has been completed.

Burnish these edges



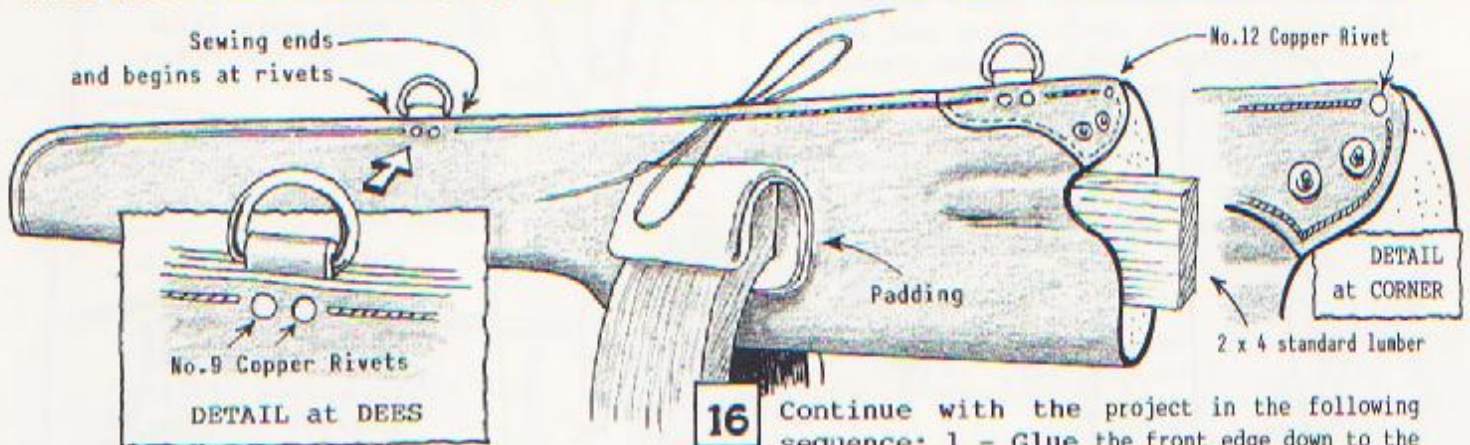
14 Cut a piece of 7/8oz. cowhide to the shape shown at left. Burnish the edges; gouge sewing channels. Install two Posts of the Lift-the-Dot snaps as indicated. These must be fastened to lighter weight leather as the prongs are not long enough to clinch properly in the thickness of the skirting leather. This overlay piece would be a good place to stamp the Serial No. of the gun.

After installing the snaps, glue the piece to scabbard (shaded area) and sew to the scabbard.



15 Prepare two Dee Assemblies as shown at left. If you don't have any heavy rawhide (bullhide) then use two layers of less thickness. Soak in water. The tabs should be cut a bit wider than the dee as the rawhide will shrink when drying. Tack the dee

Assemblies to the bench; allow to dry. Now cut fillers from 14/16oz. cowhide 3/4" wide to fit in the areas (above). Glue fillers and dees in place...following in sequence: Steps A, B, C, D, E. Carefully align edges. The base of the dees should be at the edge.

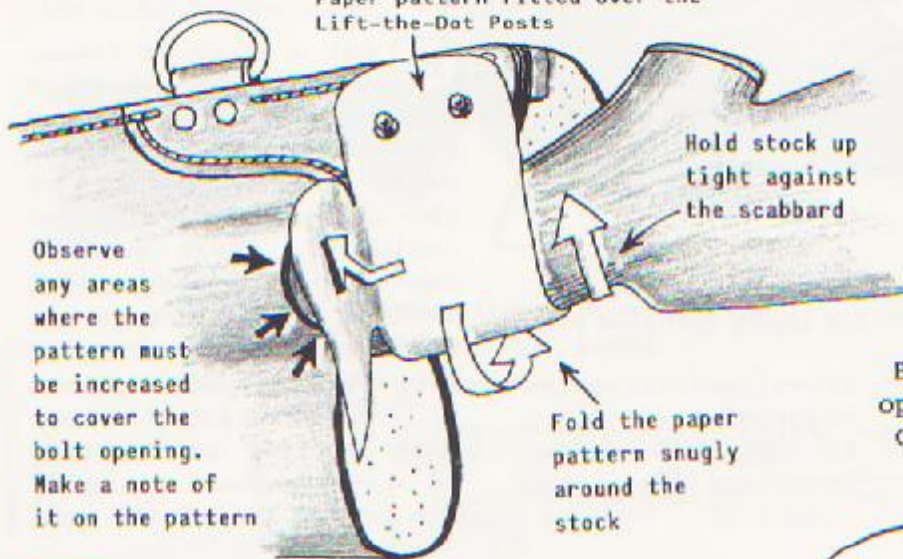


16 Continue with the project in the following sequence: 1 - Glue the front edge down to the fillers and dees. 2 - Glue End Plug in place. 3 - Drill holes for rivets and rivet dees and corner. 4 - Gouge the sewing channels on both sides, 1/4" from edges. Push a board, 1 1/2" thick, inside the scabbard at the scope area. This protects the scope bulge when clamped in the stitching horse. Use a 3/4" thick board inside, when sewing down the barrel. Sew the scabbard together. Burnish the edge.



SCOPE SCABBARD - Continued

Paper pattern fitted over the Lift-the-Dot Posts

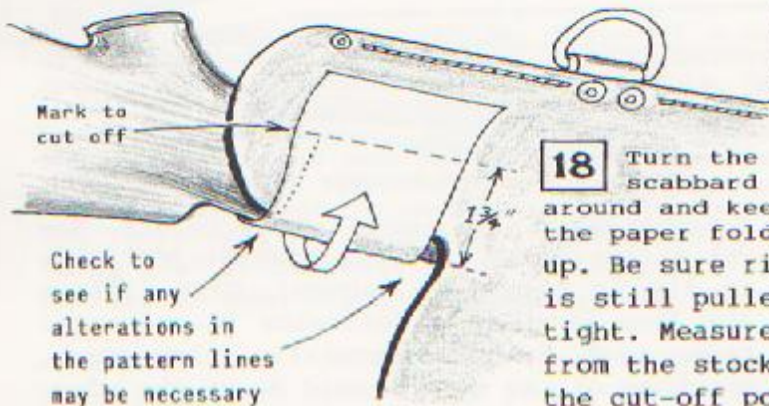


Observe any areas where the pattern must be increased to cover the bolt opening. Make a note of it on the pattern

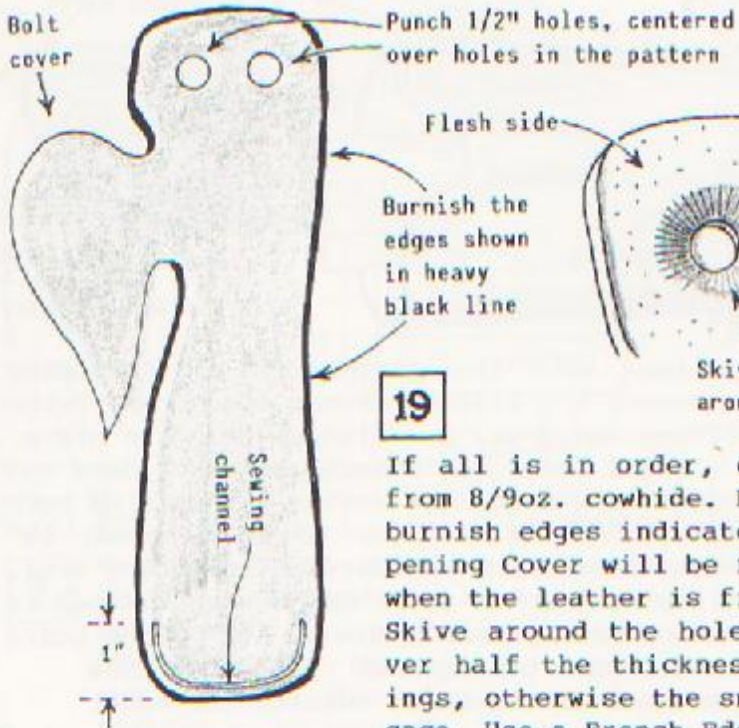
Hold stock up tight against the scabbard

Fold the paper pattern snugly around the stock

17 Place the rifle in the scabbard and comply with all of the notations above.



18 Turn the scabbard around and keep the paper folded up. Be sure rifle is still pulled up tight. Measure up, from the stock, for the cut-off point.



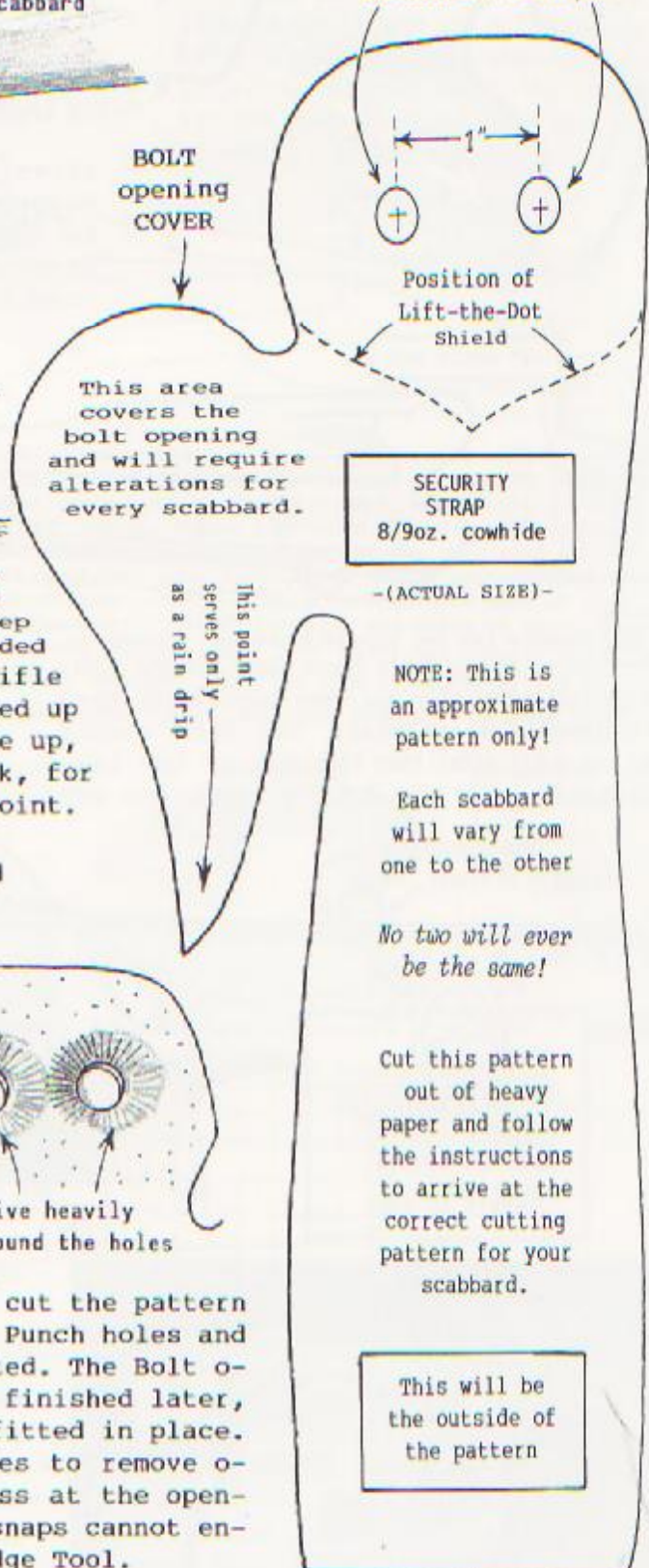
19 If all is in order, cut the pattern from 8/9oz. cowhide. Punch holes and burnish edges indicated. The Bolt opening Cover will be finished later, when the leather is fitted in place. Skive around the holes to remove over half the thickness at the openings, otherwise the snaps cannot engage. Use a French Edge Tool.

MAKING the SECURITY STRAP

ATTENTION: Holes may have to be adjusted up or down to insure a proper fit of the Security Strap!



Cut holes with a No.9 punch



SECURITY STRAP
8/9oz. cowhide

-(ACTUAL SIZE)-

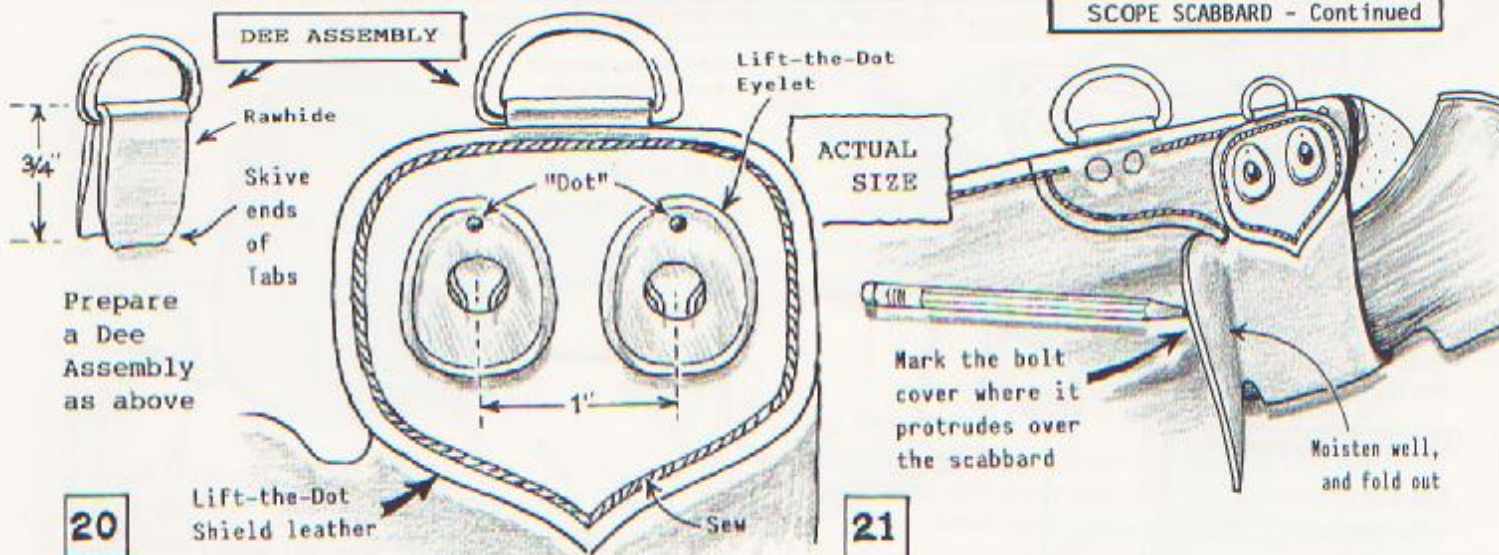
NOTE: This is an approximate pattern only!

Each scabbard will vary from one to the other

No two will ever be the same!

Cut this pattern out of heavy paper and follow the instructions to arrive at the correct cutting pattern for your scabbard.

This will be the outside of the pattern

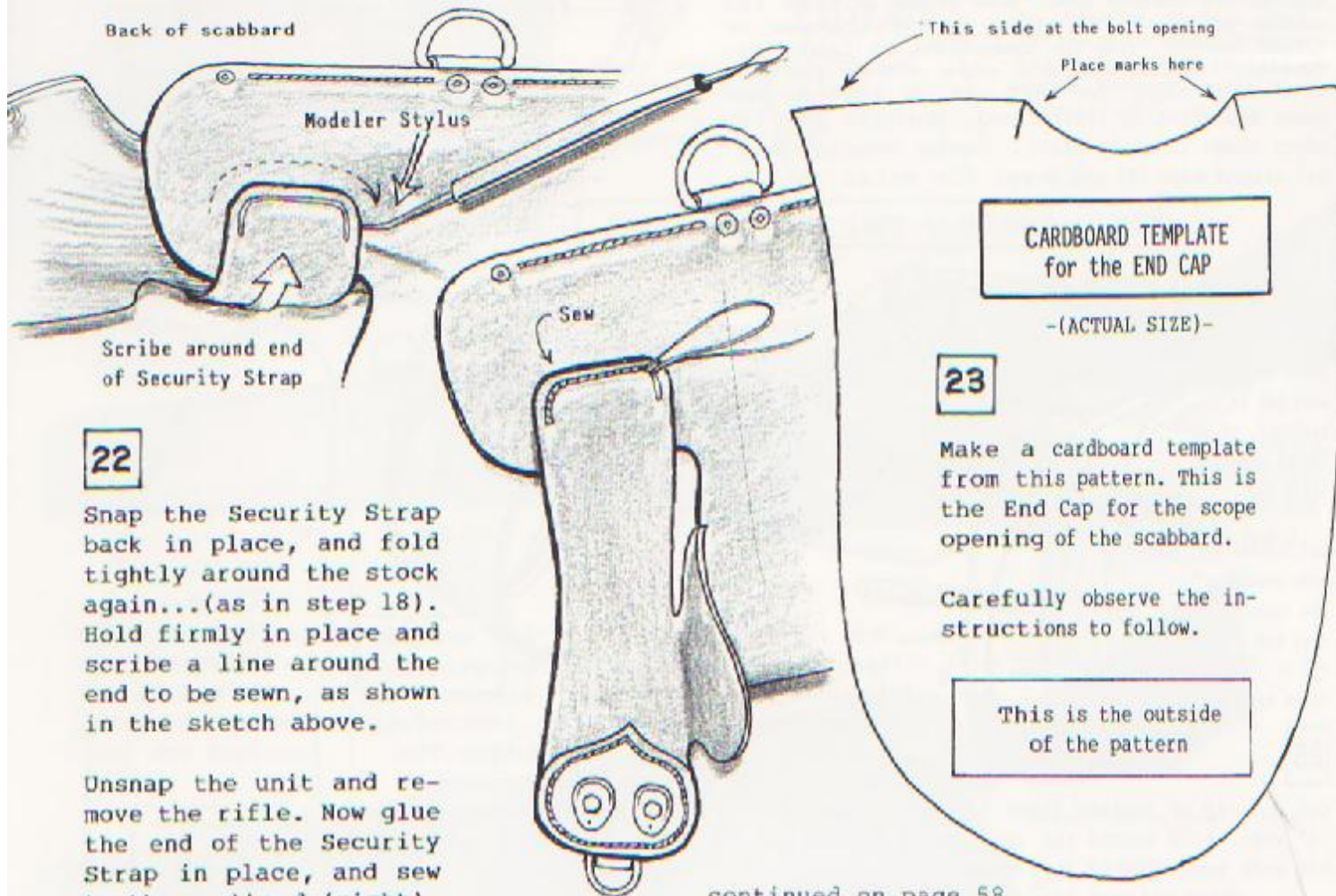


20

Cut the Lift-the-Dot Shield leather from 6/7oz. cowhide. Trim the top and sides to the contours of the Security Strap. Also, punch 1/2" holes to match the strap. Burnish the edges. Install two eyelets with the "DOTS" at the top. The eyelets must be equal, in distance, to the spread of the posts. Gouge sewing channel. Glue the Dee Assembly between the Shield and the Security Strap... and sew together as illustrated above.

21

Now snap the eyelets to the posts and fold the Security Strap tightly around the rifle stock (as in step 17). With the bolt cover now against the bolt opening of the scabbard, mark any areas extending outside of the contours of the bolt opening that will require trimming (see above). If satisfied, unsnap the unit and make any trimming necessary on the bolt cover. Flatten leather out and burnish the bolt cover edges.



22

Snap the Security Strap back in place, and fold tightly around the stock again...(as in step 18). Hold firmly in place and scribe a line around the end to be sewn, as shown in the sketch above.

Unsnap the unit and remove the rifle. Now glue the end of the Security Strap in place, and sew to the scabbard (right).

23

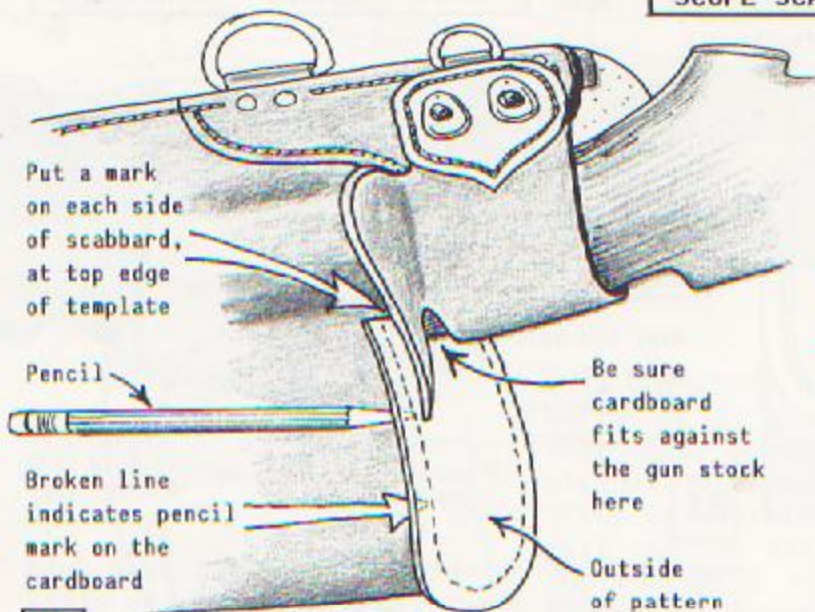
Make a cardboard template from this pattern. This is the End Cap for the scope opening of the scabbard.

Carefully observe the instructions to follow.

This is the outside of the pattern

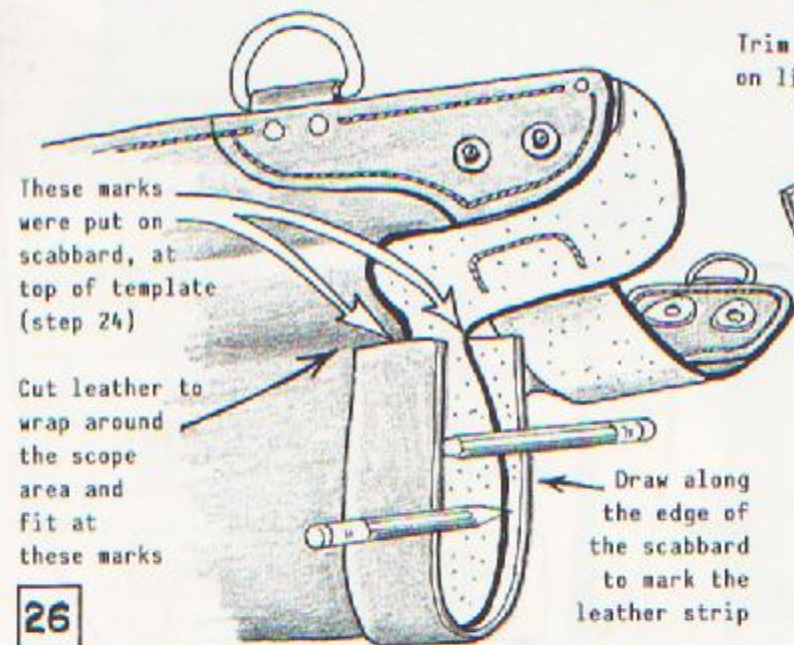
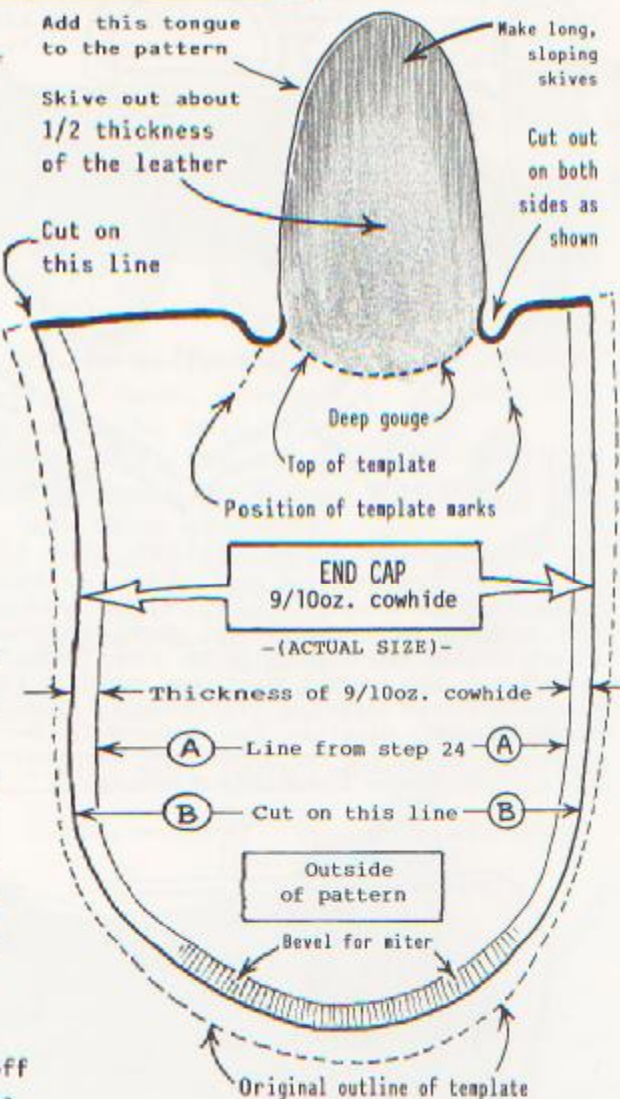
continued on page 58

SCOPE SCABBARD - Continued

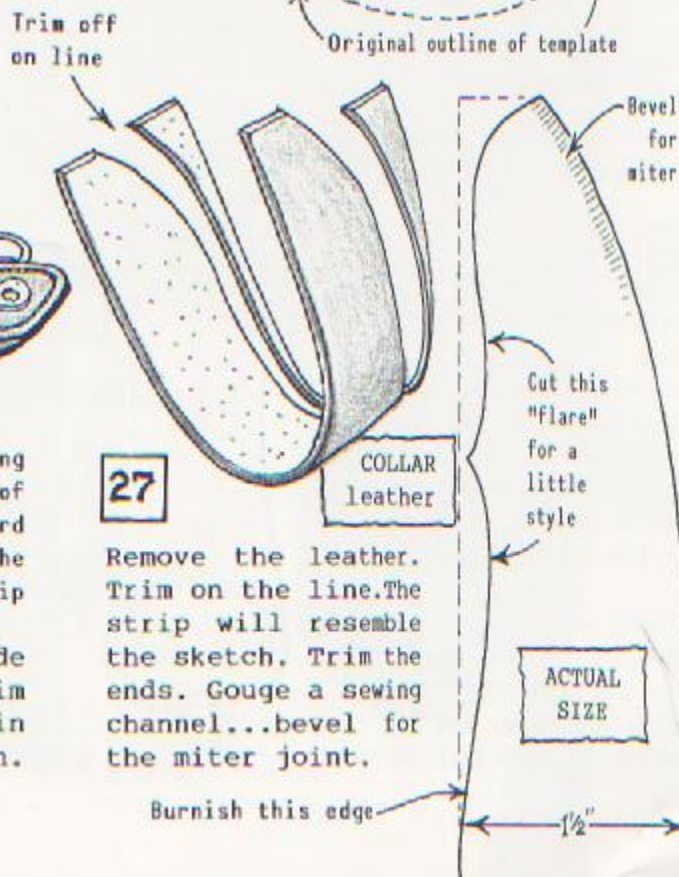


24 Make the Template (page 57). Fit it up against the rifle stock. Hold it tight and press it against the leather edges of the scope opening. Hold securely and draw around the leather to mark the cardboard...all around.

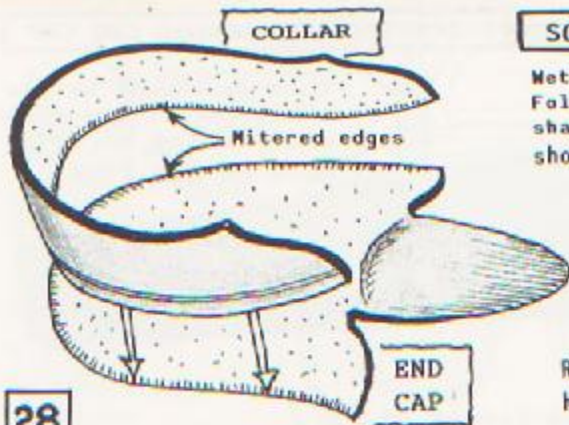
25 Remove the cardboard. Line (A) will show on the reverse side. Now draw a line (B) outside of line (A) to equal the thickness of 9/10oz. cowhide. Trim the Template on line (B). Turn the Template over and make a new pattern as shown at right. Cut this out of leather and gouge and skive as instructed. Burnish the top edges shown in heavy black. Gouge sewing channel around edge (B) and bevel for miter joint.



26 Cut a strip of leather from 9/10oz. cowhide 1 1/2" wide. Fold around the scabbard and trim the ends as indicated above. Hold firmly in place and mark the leather as shown.



27 Remove the leather. Trim on the line. The strip will resemble the sketch. Trim the ends. Gouge a sewing channel...bevel for the miter joint.

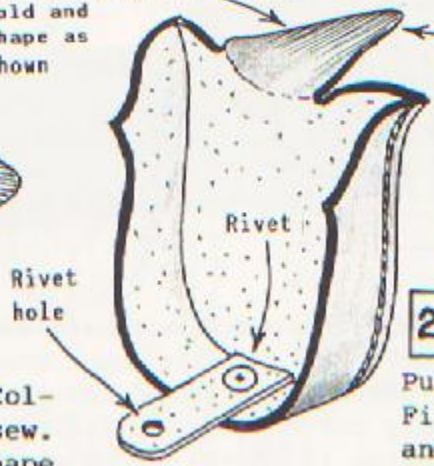


28

Cement the mitered edges of the Collar and End Cap together...and sew. Edge/burnish the miter joint. Shape the tongue as above. Now cut a strap from 4/5oz. leather 2-1/2" long by 7/8" wide. Rivet it to the center of the End Cap, as illustrated above.

SCOPE SCABBARD - Continued

Wet the gouge and tongue. Fold and shape as shown

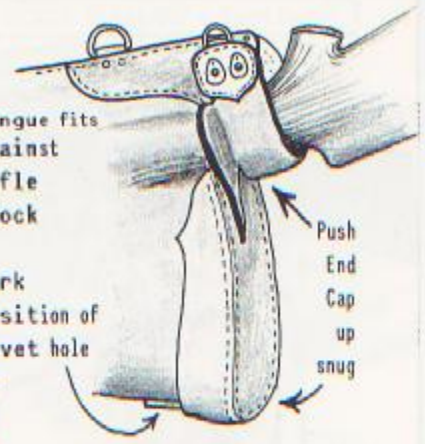


Rivet hole

Tongue fits against rifle stock

Mark position of rivet hole

29

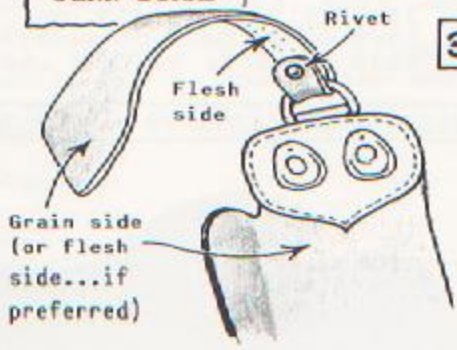


Put the gun back in the scabbard. Fit the End Cap in place, push up and snap Security Strap in place. This holds the tongue against the stock. Push Cap tight against the scabbard and mark rivet hole. Remove gun and rivet the cap-strap to the scabbard.



Security Strap and End Cap shown with carving design

JERK-STRAP



30

To complete the scabbard, install the Jerk-Strap as shown. Cut it about 7" long by 1" wide, tapering to 5/8" at the dee. Cut it from 8/9 oz. cowhide. Burnish edges. If the grain side of Security Strap is out, install as shown. Reverse if the flesh side is out.

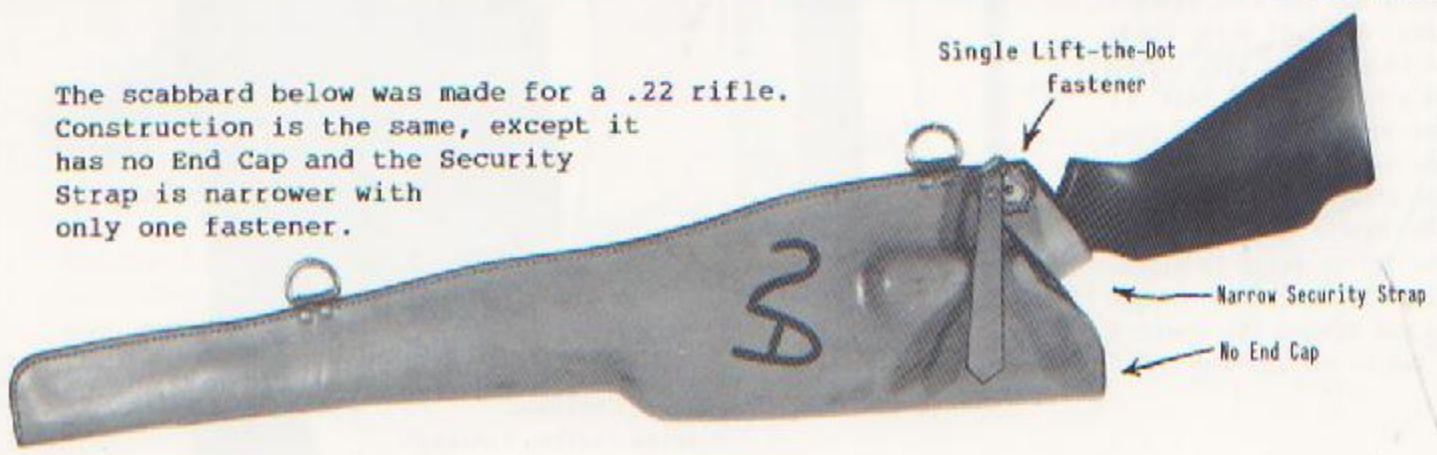
More ONE-PIECE SCOPE SCABBARDS - below

Follow all previous instructions for making this scabbard.

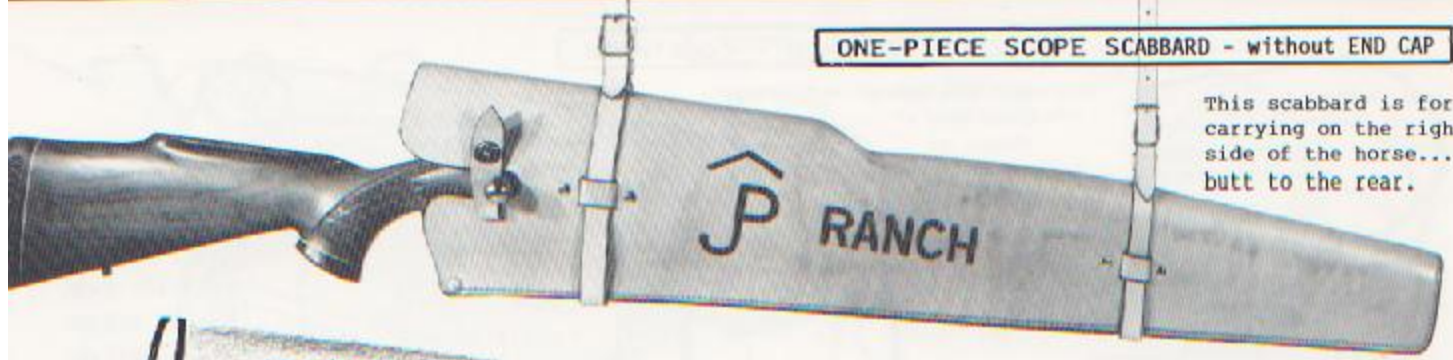


Carving designs are the choice of the customer and the maker.

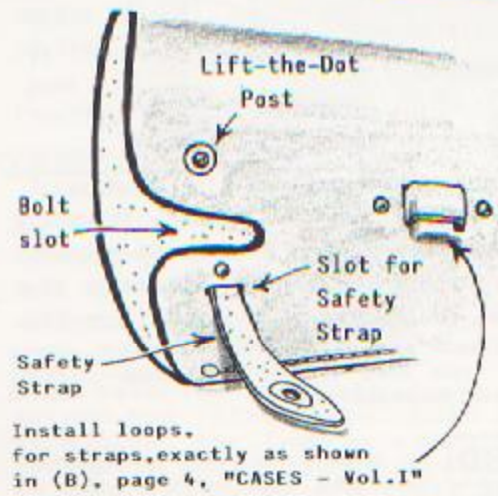
The scabbard below was made for a .22 rifle. Construction is the same, except it has no End Cap and the Security Strap is narrower with only one fastener.



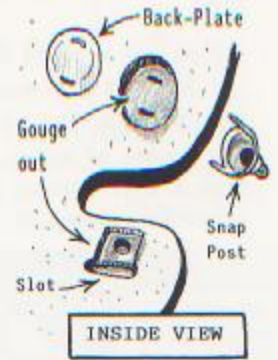
ONE-PIECE SCOPE SCABBARD - without END CAP



This scabbard is for carrying on the right side of the horse... butt to the rear.



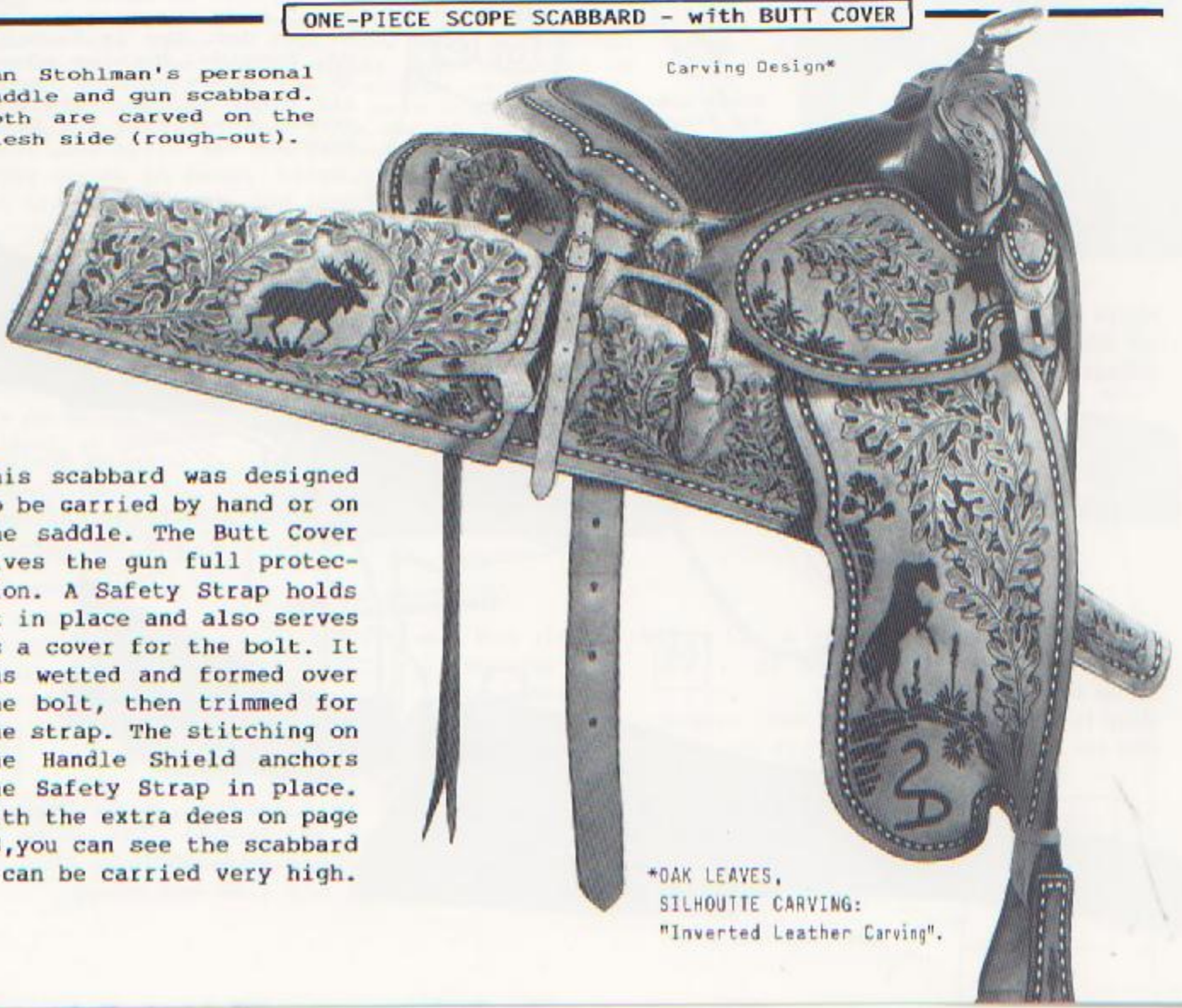
This one-piece scabbard is formed exactly as the previous ones. However, instead of forming for the bolt, simply cut out for it (left). The Safety Strap is installed as shown so it can fall out of the way when unstrapped. The inside of the scabbard should be gouged out above the slot to accommodate the strap so it lays flush. The snap post can be installed in heavy leather by gouging out a circle to recess the back-plate (right). Glue a thin piece of leather over the plate.



ONE-PIECE SCOPE SCABBARD - with BUTT COVER

Ann Stohlman's personal saddle and gun scabbard. Both are carved on the flesh side (rough-out).

Carving Design*



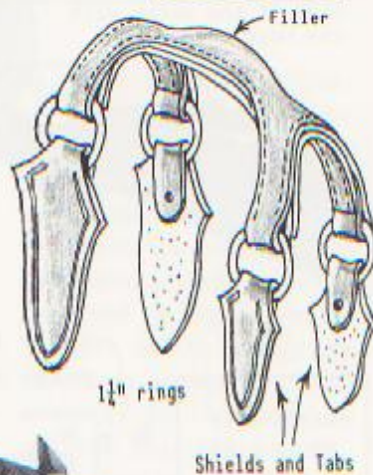
This scabbard was designed to be carried by hand or on the saddle. The Butt Cover gives the gun full protection. A Safety Strap holds it in place and also serves as a cover for the bolt. It was wetted and formed over the bolt, then trimmed for the strap. The stitching on the Handle Shield anchors the Safety Strap in place. With the extra dees on page 43, you can see the scabbard can be carried very high.

*OAK LEAVES, SILHOUTTE CARVING: "Inverted Leather Carving".

SCOPE SCABBARD - Continued

The top handle leather folds around the rings. Lining leather covers the skived ends of the folds. Add a filler between the leathers.

The HANDLE

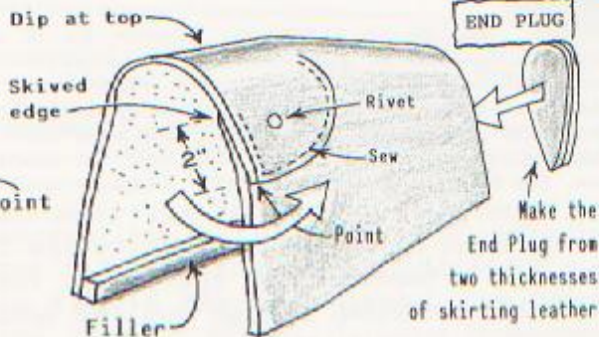
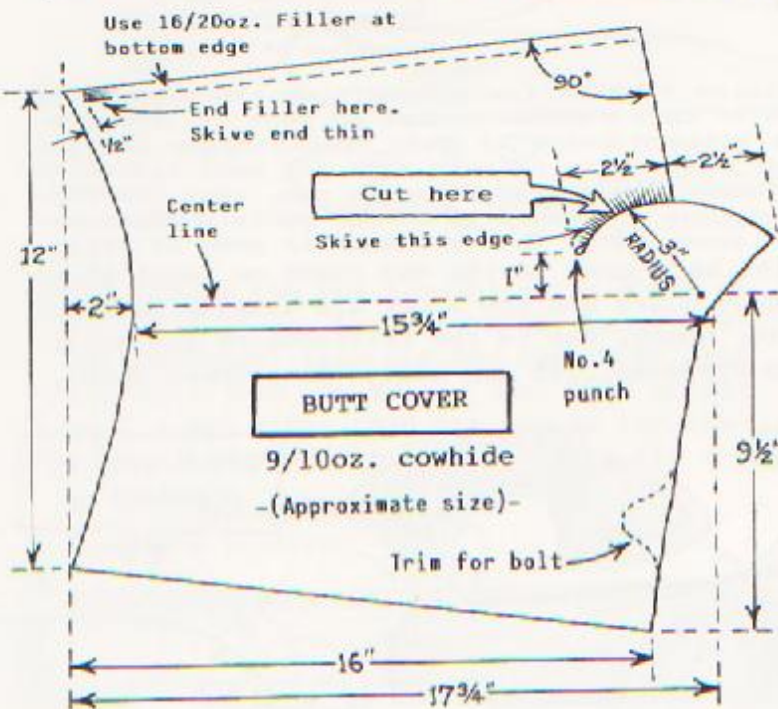


Remove straps when hand carrying

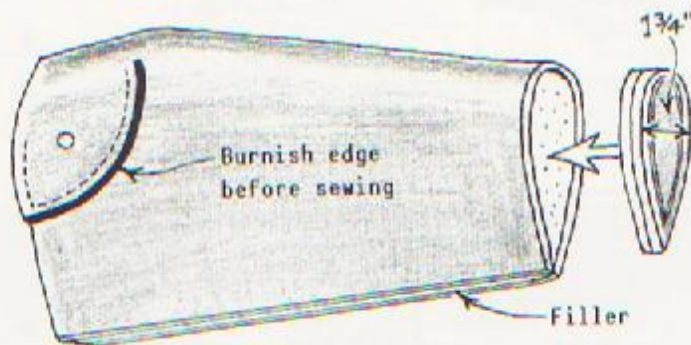


The Butt Cover cannot be made until the scabbard has been completed. The measurements shown are approximate, as each gun and scabbard will vary in size and shape.

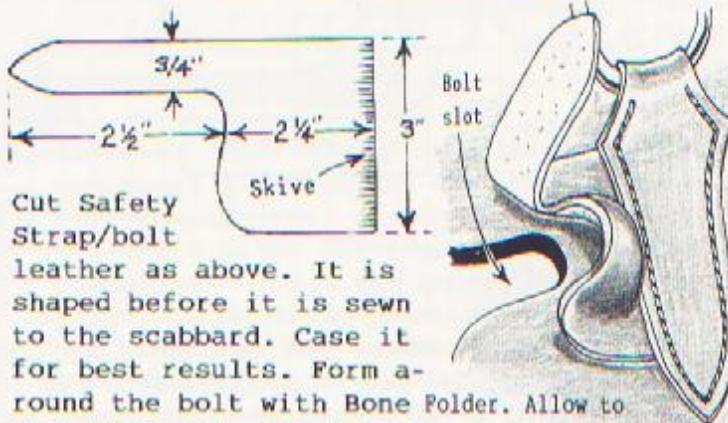
NOTE: Slot here is below sewing line



Cut the leather oversize in length & width. Cut the front as shown; burnish the edge. Fold the point down; cement in place. This makes a dip at the top. Sew; add a rivet at skived edge. Now fit this over the scabbard (with gun inside) and you can determine the cutting dimensions for width and length. Allow room for the filler. Trim out for the bolt to slide the cover forward.



Check your fitting again...and cut the proper width and length. Allow room for the End Plug. Cement the filler and End Plug in place, and sew. See page 70 for instructions on sewing End Plugs.



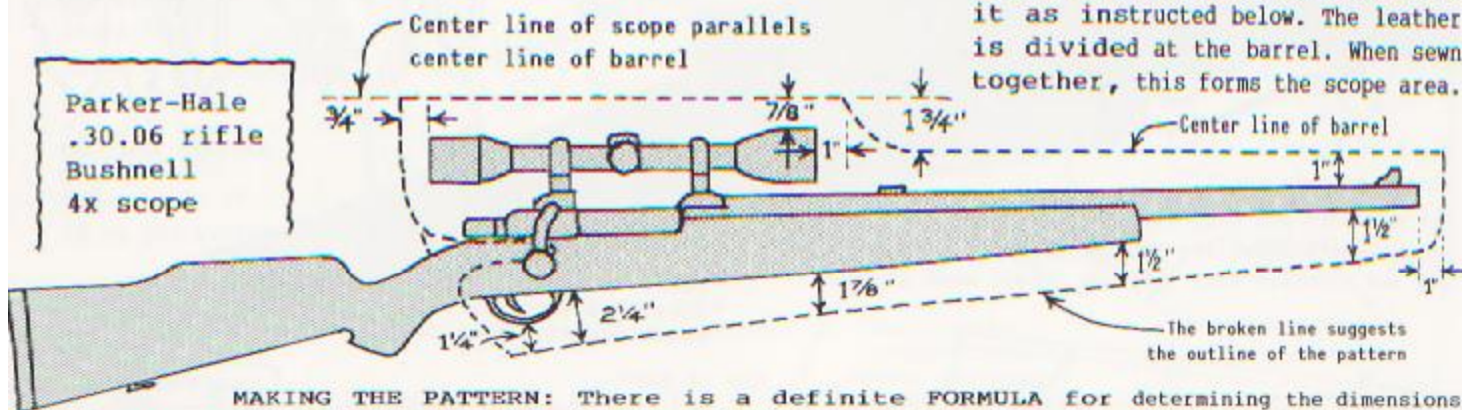
Cut Safety Strap/bolt leather as above. It is shaped before it is sewn to the scabbard. Case it for best results. Form around the bolt with Bone Folder. Allow to dry, then make any trimming necessary and burnish edges. When the cover is fitted in place, you can locate positions of snaps.

This scabbard is for carrying on the right side of the horse with the butt to the rear.

SCOPE SCABBARD - Alternate Construction

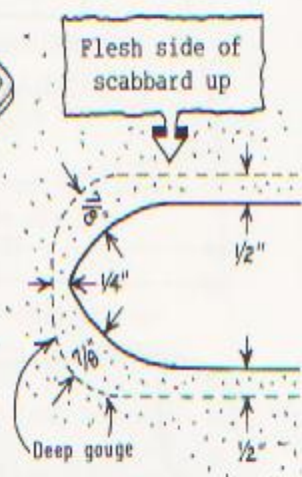
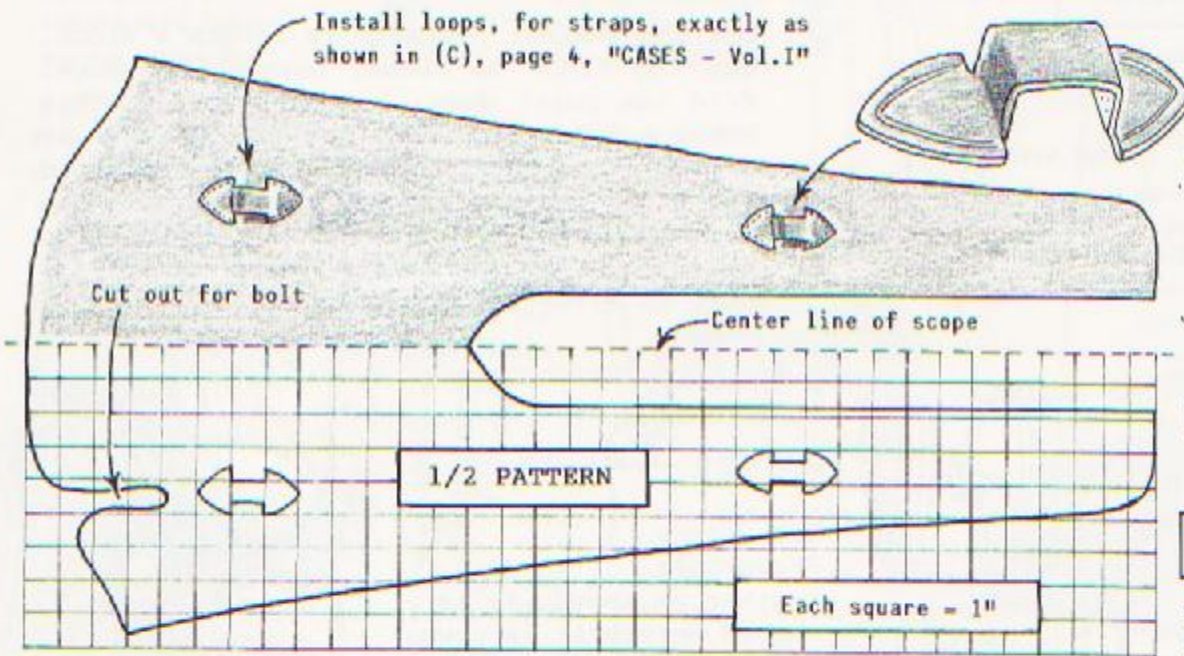


If you don't want the one-piece construction (previous scabbards), make it as instructed below. The leather is divided at the barrel. When sewn together, this forms the scope area.



Parker-Hale
.30.06 rifle
Bushnell
4x scope

MAKING THE PATTERN: There is a definite FORMULA for determining the dimensions of your scabbard or gun case. The explanation of this FORMULA begins on page 64. Measurements above are taken from this FORMULA. The pattern below is made specifically for the rifle and scope shown above. The barrel is 24" long. This pattern will fit most rifles of this size and caliber. However, if you are in doubt concerning your own gun, read the FORMULA instructions and you will see if modifications are required on the pattern shown below. The FORMULA applies to all rifles and shotguns. NOTE: This scabbard is made of skirting leather which is much thicker than the leathers used on the gun cases on pages 64 to 77. Therefore, the measurements below the trigger guard and the stock are usually increased by 1/4" to compensate for the lesser interior space, due to the thickness of the heavier leather when folded. *Always cut the leather oversize...it can always be trimmed down!*



2

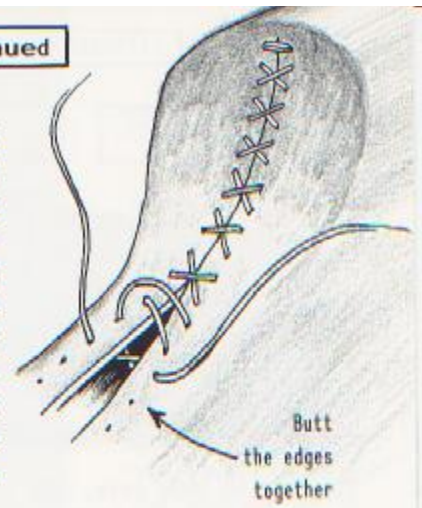
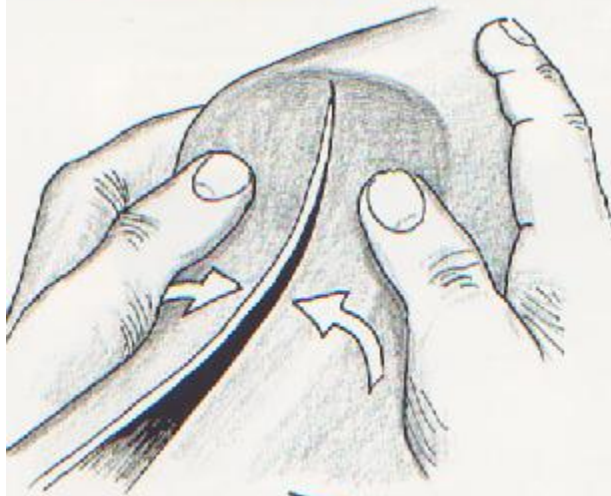
Turn the leather to the flesh side, and make gouges as suggested above. Make deep gouges at the scope area, to make forming easier. See step 3.

1 From the graph above, you can make the complete pattern. Make the full size pattern on heavy paper and cut out for the bolt. Be sure it is in the proper position. Mark the positions of the loops for the saddle straps. Cut out the scabbard. Make the loops as above; sew them in place. Or...cut slots in the leather as on page 45, or install loops as on page 60.

SCOPE SCABBARD - Continued

3

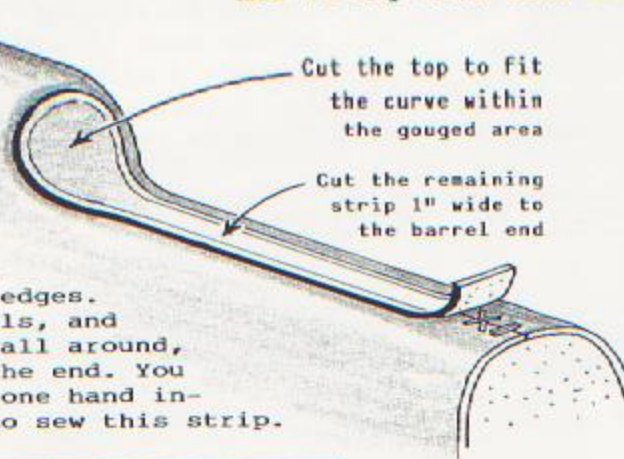
Thoroughly wet the leather around the gouged areas...and down the barrel length (both sides). Force the leather in as shown at left. Use dividers to mark sewing holes, and space them $3/16"$ apart. Use a heavy linen sewing thread and wax it. Sew the scabbard together as shown at right. The edges butt together. Pull the stitches tight. Tap with hammer to lay them down flat.



Butt the edges together

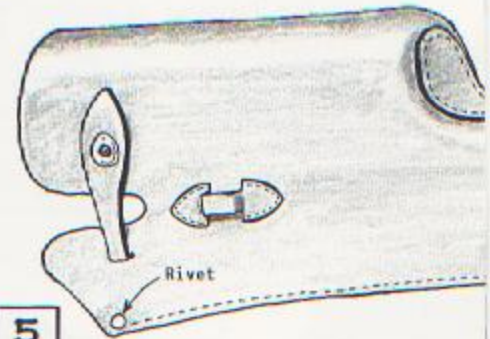
4

Cut the leather from $7/8$ oz. cowhide to fit over the stitches (from step 3) as shown at right. Burnish the edges. Gouge sewing channels, and glue in place. Sew all around, to within $1/4"$ of the end. You will have to reach one hand inside the scabbard to sew this strip.



Cut the top to fit the curve within the gouged area

Cut the remaining strip 1" wide to the barrel end

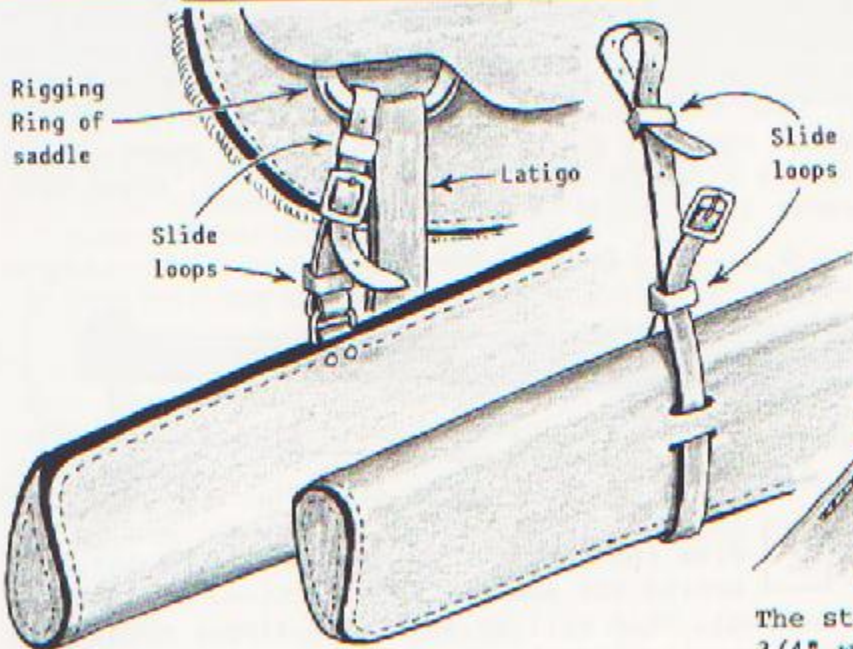


Rivet

5

Install the Safety Strap same as page 60. Wet the leather on the flesh side at barrel and scope area. Form the leather down so bottom edges come together. Glue a filler at bottom. Add the End Plug and sew scabbard together. Install a rivet as indicated.

MAKING the SCABBARD STRAPS



Rigging Ring of saddle

Slide loops

Latigo

Slide loops

Bridle Buckle

Roller Buckle

Rivet or sew

$6/7$ oz. cowhide

SLIDE LOOP

Regardless of which type of saddle scabbard you have, slide loops should be used as illustrated above. The loops hold the straps together and make a sturdy attachment. Also, it lessens chances of sticks or branches snagging between the straps.

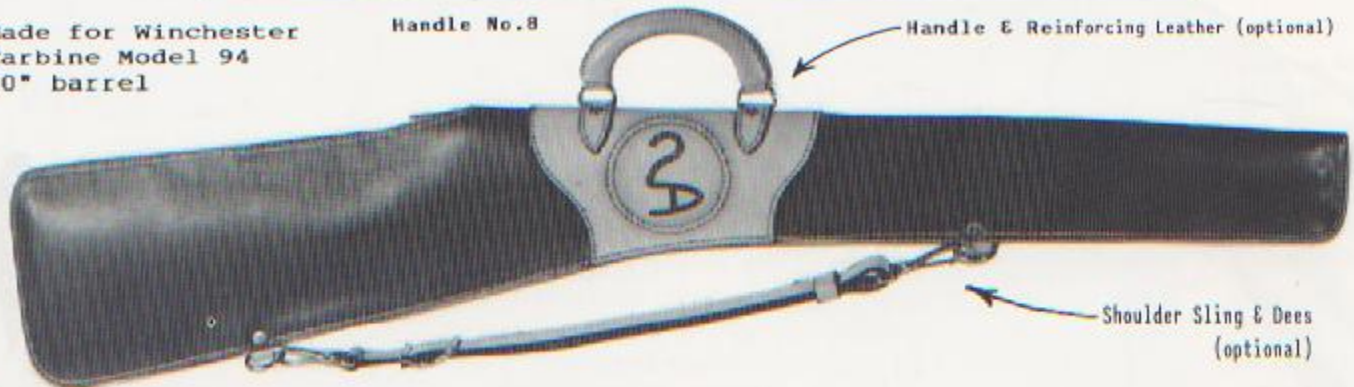
The straps are usually cut $3/4"$ wide. Cut from $7/8$ oz. cowhide for lasting service. The length of the straps will vary, depending on the position of the scabbard and where it is attached to the saddle. You will have to make these determinations by fitting to saddle. MAKING LOOPS: See page 9, "CASES -Vol.1".

ZIPPERED RIFLE CASE - for LEVER-ACTION and AUTOMATIC RIFLES

Made for Winchester
Carbine Model 94
20" barrel

Handle No. 8

Handle & Reinforcing Leather (optional)



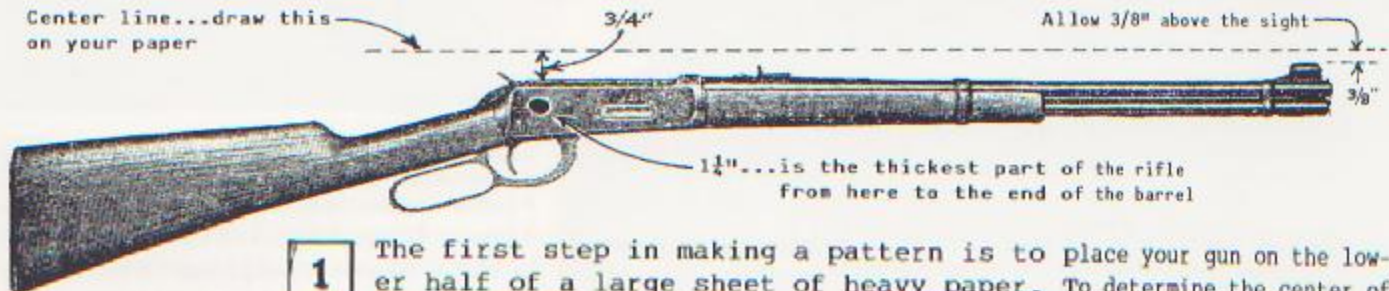
The case we show here, and on the following pages, is made of lightweight leathers as they are not intended to be used for horse-back transportation. The zipper closure allows easy access to your gun and gives full protection. The shoulder sling and the handle unit are optional features. The rein-

forcing piece for the handle gives added support and facilitates transportation. The body of the case is made from 4/5oz. to 5/6 oz. leather. A wide variety of leathers can be used. Oil-tanned leather would be ideal. The bottom is reinforced with a filler that is optional, but required for the sling.

The FORMULA...for MAKING the PATTERN

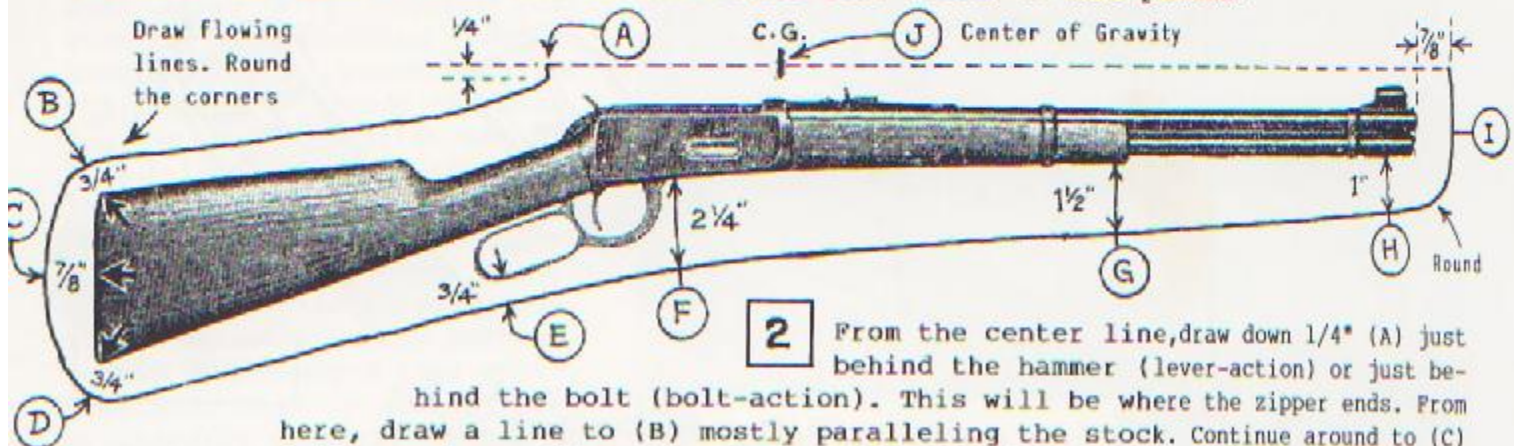
Center line...draw this
on your paper

Allow 3/8" above the sight



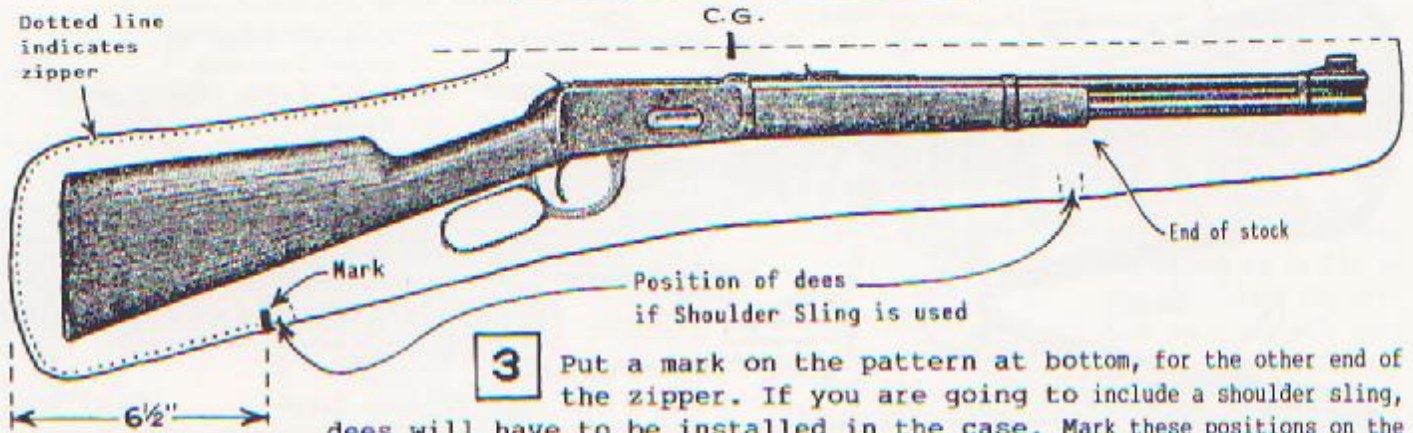
1 1/4" ...is the thickest part of the rifle
from here to the end of the barrel

- 1** The first step in making a pattern is to place your gun on the lower half of a large sheet of heavy paper. To determine the center of the pattern (fold line), the FORMULA begins as follows: Measure the thickest part of the gun...here, 1 1/4" (see above). Take 1/2 of this, which equals 5/8". Now add 1/8" to this which will equal 3/4". This will insure ample leather (on center line), where it will fold over the thickest part of the gun. Put a mark here, on the paper. Measure up 3/8" above the front sight. Now draw a straight line on these two marks, shown with a broken line above. This will be the center line (fold) of the pattern.



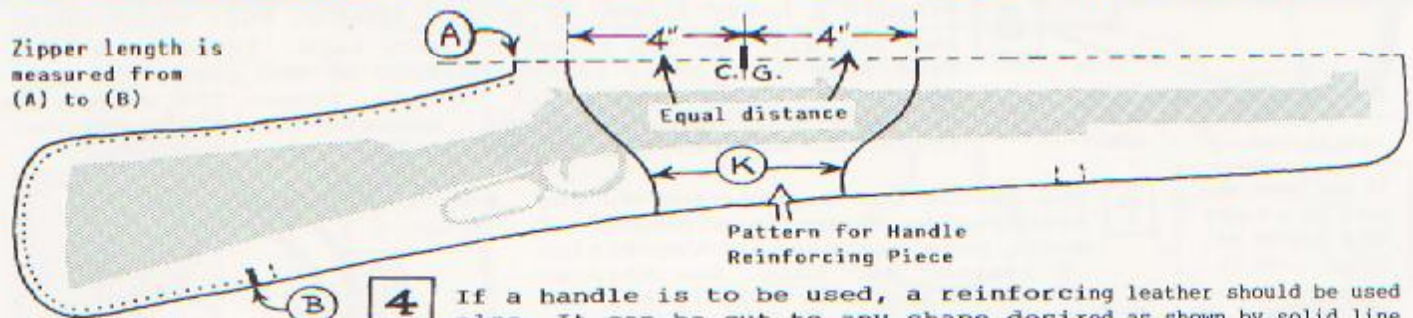
- 2** From the center line, draw down 1/4" (A) just behind the hammer (lever-action) or just behind the bolt (bolt-action). This will be where the zipper ends. From here, draw a line to (B) mostly paralleling the stock. Continue around to (C) and (D) as shown. Since the zipper will add 1/2" to these areas, the dimensions are ample for the gun butt within the case. Allow at least 3/4" under the lever (E), and 2 1/4" ahead of the trigger guard (F). Allow 1 1/2" at end of forearm stock (G), and a full 1" (H). Add 7/8" at end of barrel (I). Mark the center of gravity (J) on the pattern. This is predetermined by balancing the gun on a 1 1/2" wide board. This mark determines the center position of the handle (if used). Now draw a flowing line from (D) through to (I) as shown above. You have now completed 1/2 of the pattern outline. (continued)

ZIPPERED CASE - Continued

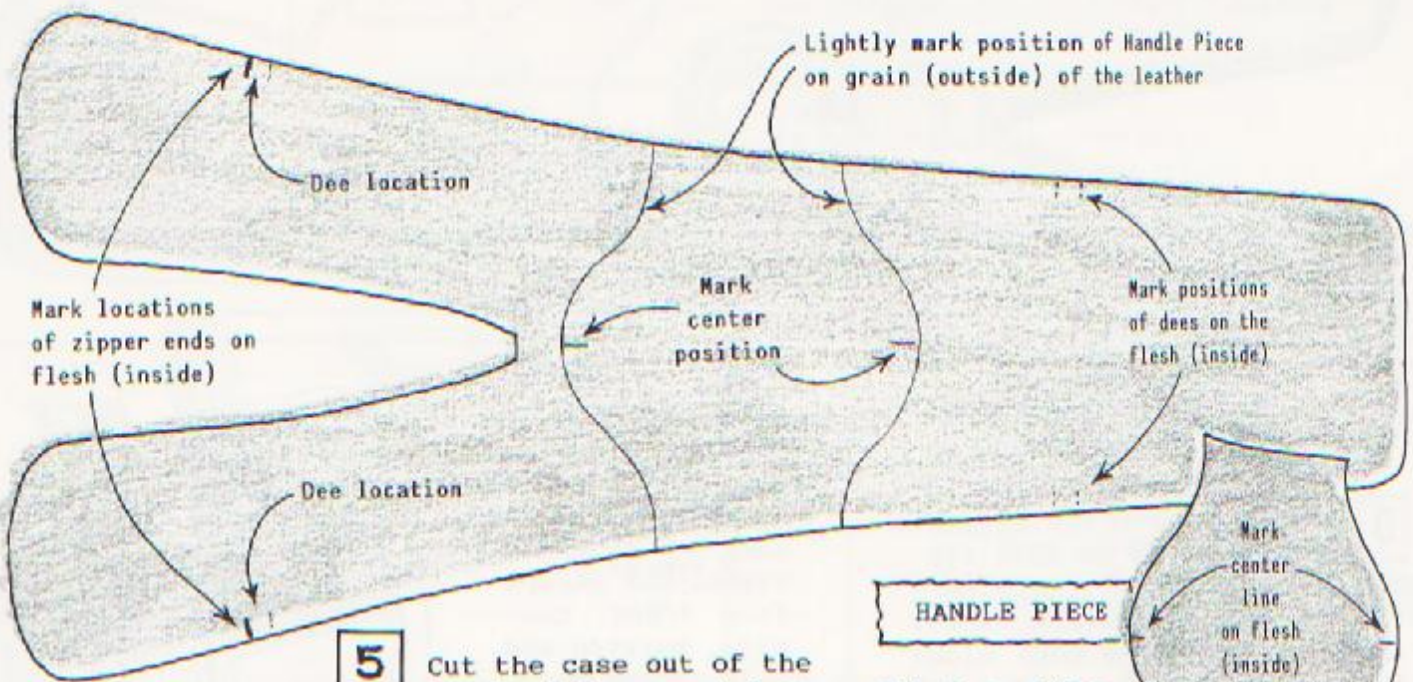


3 Put a mark on the pattern at bottom, for the other end of the zipper. If you are going to include a shoulder sling, dees will have to be installed in the case. Mark these positions on the pattern. The dee (at butt) fits next to the zipper end. The other dee is usually placed at the end of the forearm stock, regardless of the barrel length. Observe notations above.

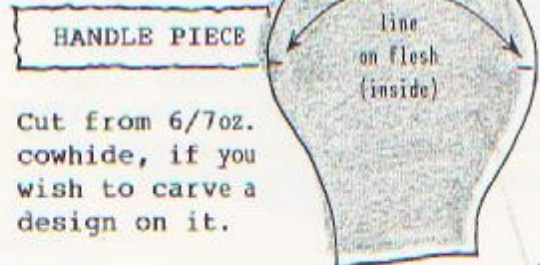
Zipper length is measured from (A) to (B)



4 If a handle is to be used, a reinforcing leather should be used also. It can be cut to any shape desired as shown by solid line (K) above. The leather should extend an equal distance on each side of the center of gravity mark. This is usually about 8" at the top. Draw these lines on your pattern. To complete the pattern, fold on the center line and transfer all previous lines and marks to the other 1/2 of the paper. Cut out the pattern. Make a separate pattern for handle piece.

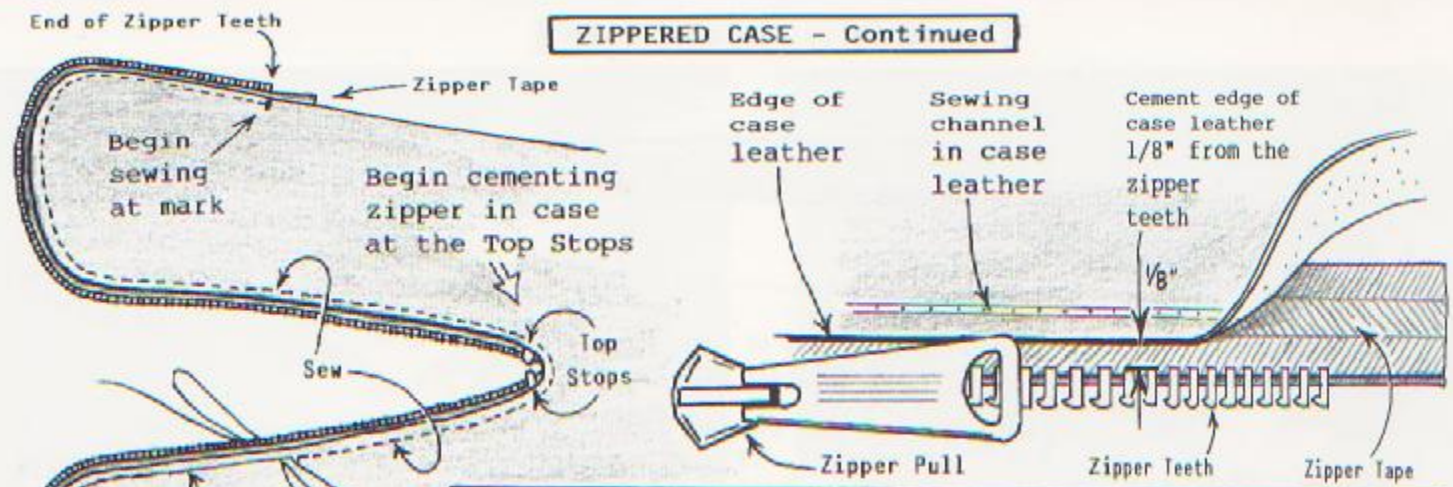


5 Cut the case out of the leather(s) suggested on page 64. Lighter weight leathers can be used if they are not prone to excessive stretch. Observe all notations above. Cut out the handle piece.



Cut from 6/7oz. cowhide, if you wish to carve a design on it.

ZIPPERED CASE - Continued

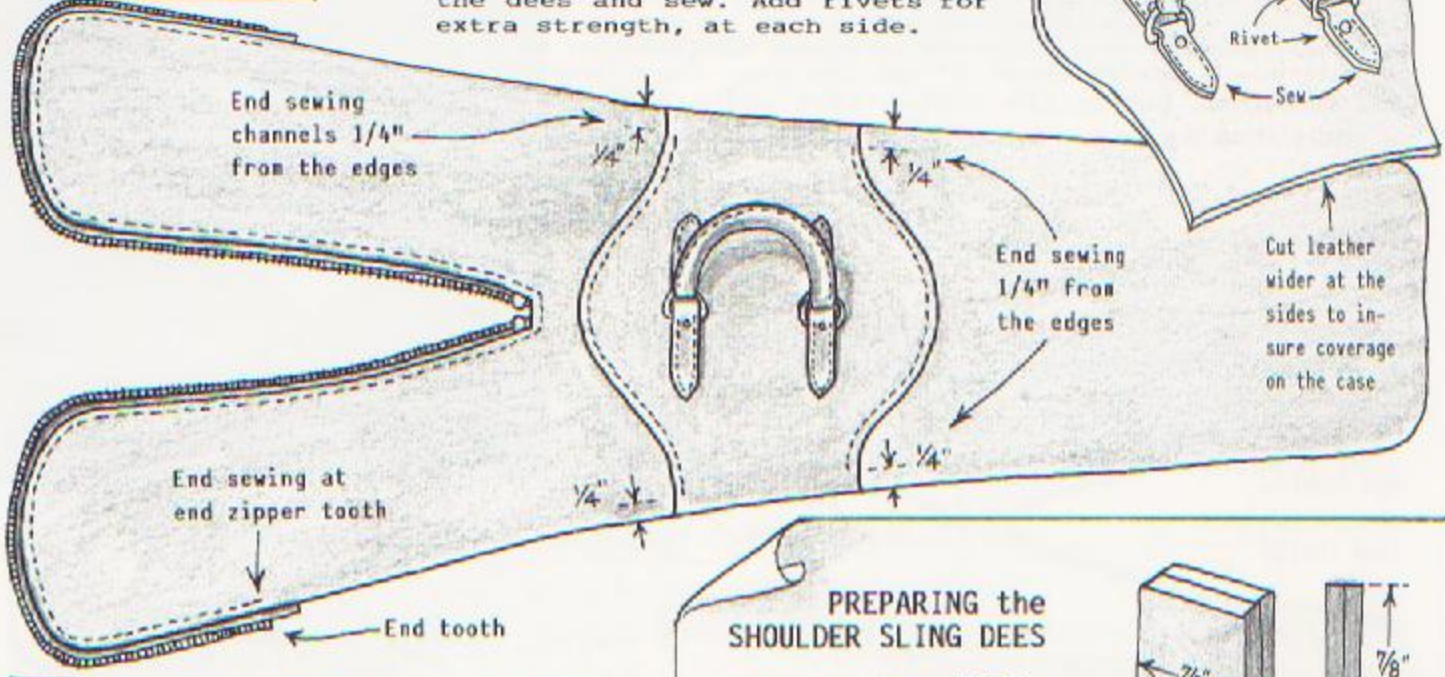
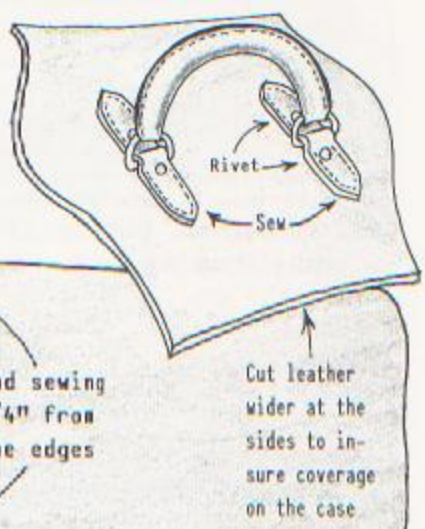


DO NOT sew zipper yet if the case is to be lined. See page 73

6 Prepare a heavy zipper of proper length. Pull teeth apart and install the Top Stops to each tape. Transfer marks, from step 3, lightly to the outside of the case. The zipper teeth end at this mark (above). Cement the zipper to the case as instructed above. Observe all of the annotations. *DO NOT* install the Bottom Stop! Sew in place.

If you have access to a heavy duty sewing machine...use it.

7 The handle can be attached to the Reinforcing Piece in a number of ways. Here we have cut two strips of leather $3\frac{1}{2}$ " long. Run through the dees and sew. Add rivets for extra strength, at each side.



8 Complete sewing in the zipper. Do not sew beyond the last zipper tooth; end stitches at the mark from step 3. Now cement the Handle Assembly in place. Trim both sides flush with the edges of the case, if necessary. Gouge sewing channels and sew, as indicated on the drawing.

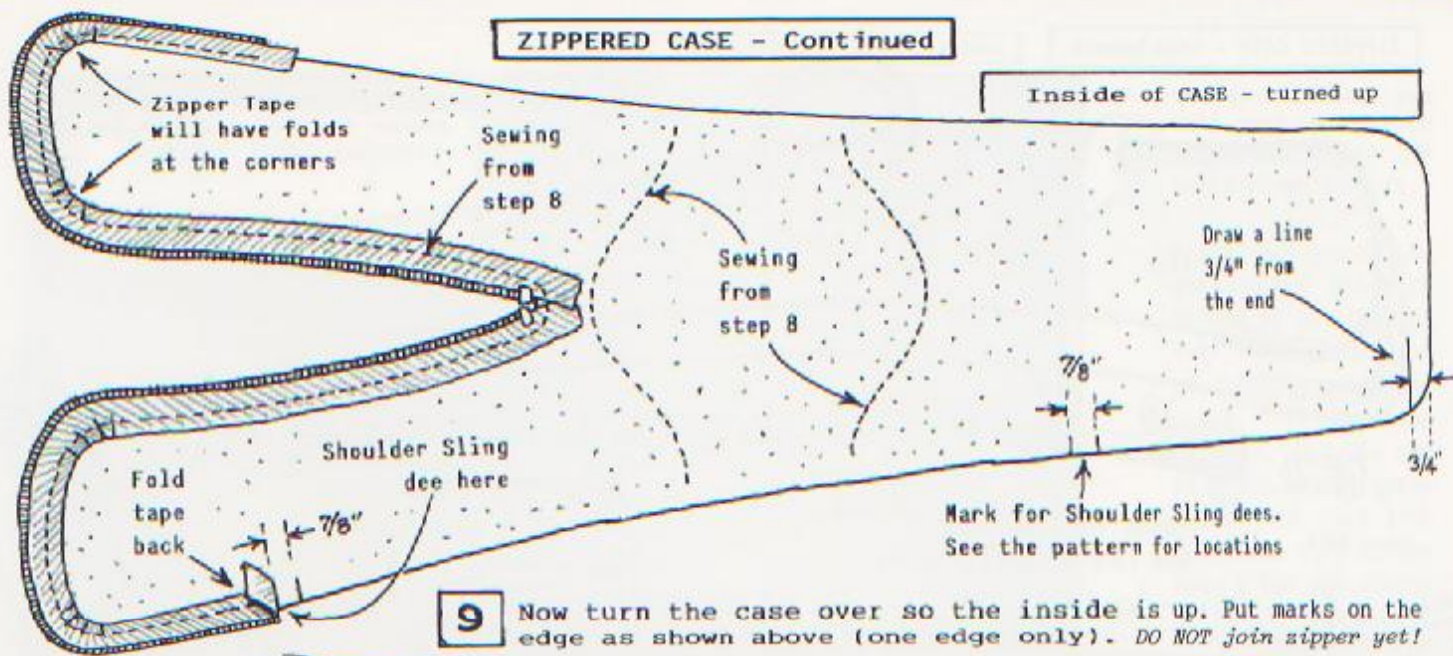
PREPARING the SHOULDER SLING DEES

Prepare two $\frac{7}{8}$ " dees as shown at right. Cut straps from $\frac{7}{8}$ oz. cowhide. Moisten and fold around dees; glue together and trim ends to the measurement given at right.

7/8" SOLID DEE EDGE VIEW

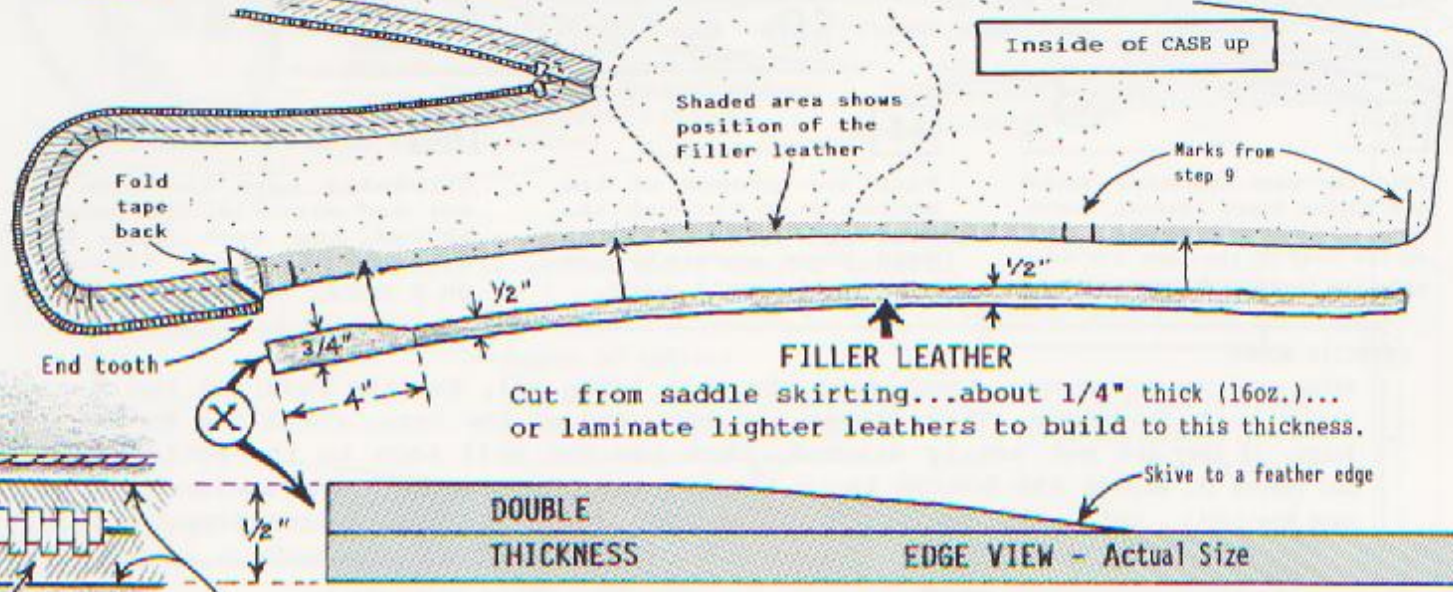
ZIPPERED CASE - Continued

Inside of CASE - turned up

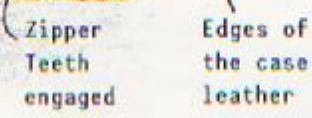


9 Now turn the case over so the inside is up. Put marks on the edge as shown above (one edge only). *DO NOT* join zipper yet!

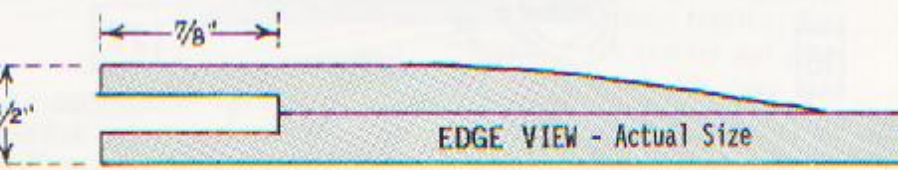
Inside of CASE up



10 A filler leather should be used at the edge of the case so it will be more rigid. When the zipper teeth are engaged, the gap between the edges of the case leather is about 1/2" (shown at left). Therefore, the end of the filler leather (next to the zipper) must be built up to equal this thickness. A 4" piece of saddle skirting is added here to build up the thickness at (X). See the edge view above. If the shoulder sling is not used...the filler leather is left in one piece. It is cemented inside the case as indicated above. The double-thickness end butts against the zipper teeth after the tape has been folded back. The other end of the filler should cut off at the mark at end of case.

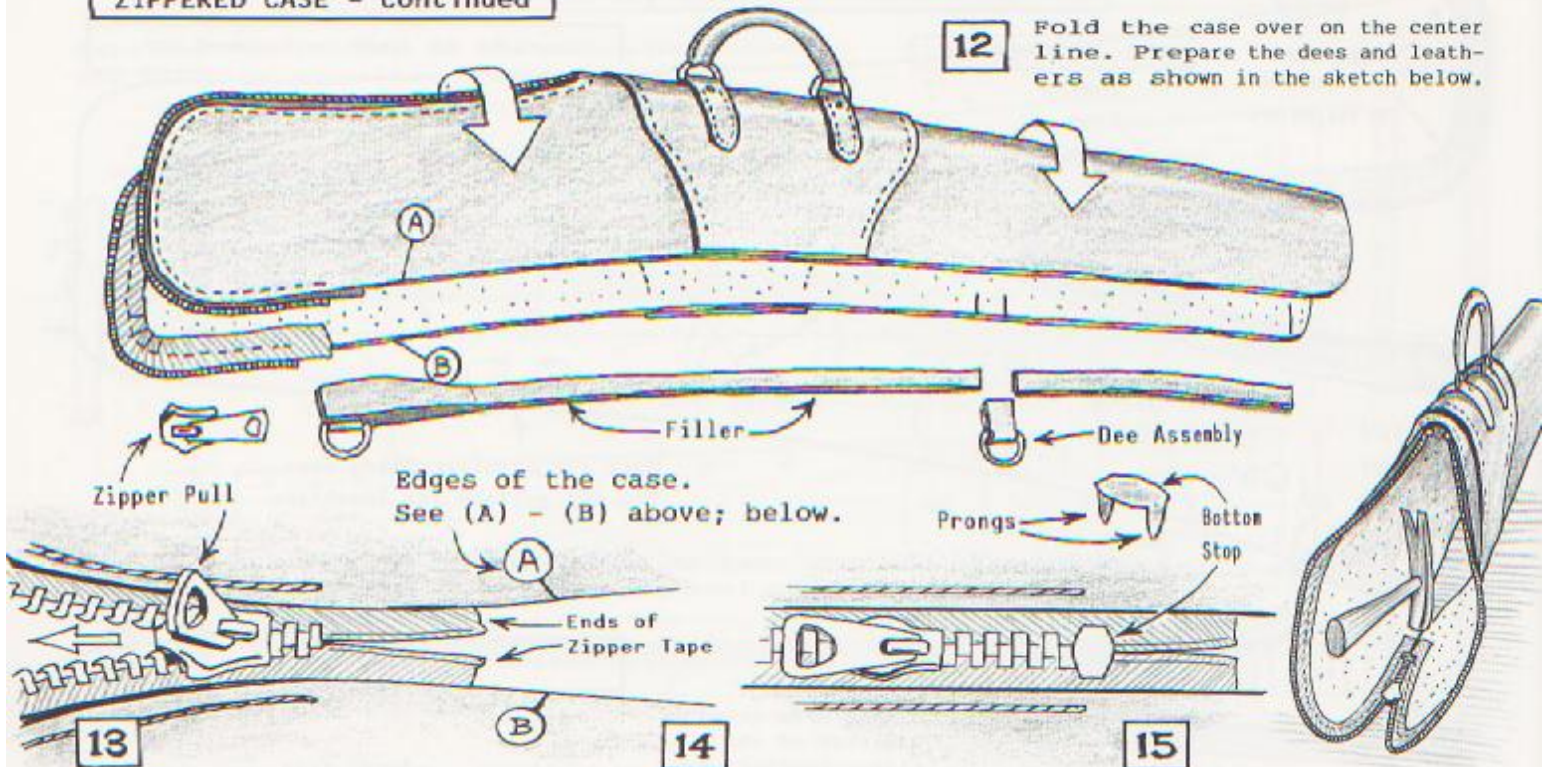


Fit the Dee Unit in the notch. Check to see if it still measures 1/2". If alright, glue the dee between the fillers.



11 When the shoulder sling is used, the double filler must be cut out to accommodate the equal thickness of the dee leathers. Notch the fillers with a sharp knife (on flesh side) before gluing.

12 Fold the case over on the center line. Prepare the dees and leathers as shown in the sketch below.



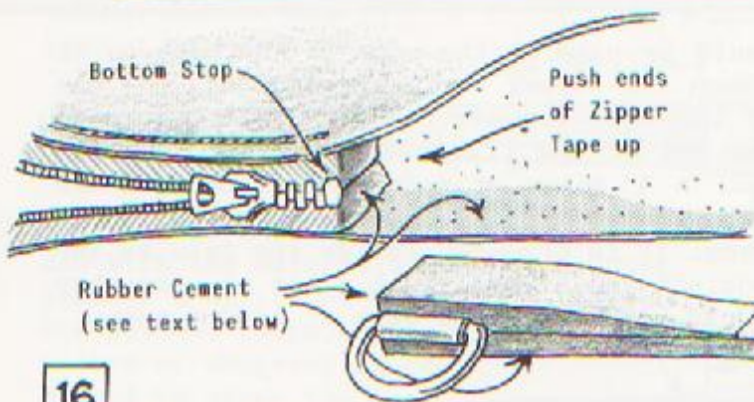
13 Fold the case together. Hold the zipper tapes against each other and run the zipper Pull up the ends of the tape to engage the teeth.

14 Push the prongs of the Bottom Stop through the tape at the last teeth. Hold tape securely, so the teeth won't part.

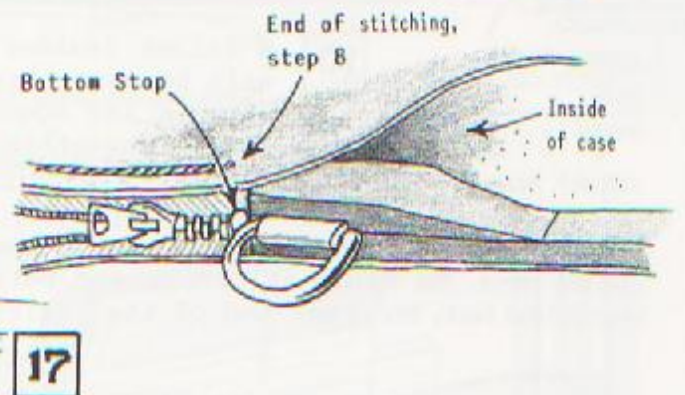
15 Carefully turn the case over and place on the bench. Spread the case open and clinch the prongs (inward) on a metal surface.

SPECIAL NOTE:

After engaging the zipper teeth with the Pull (step 13), run the Pull all the way up to the Top Stops. This closes the butt end of the case. Check the Top Stops. If they are not nearly aligned, then run the Pull back to the bottom and remove it. Adjust the bottom teeth (in the way they overlap) and again engage the teeth...until the Top Stops are together. Then install Bottom Stop.

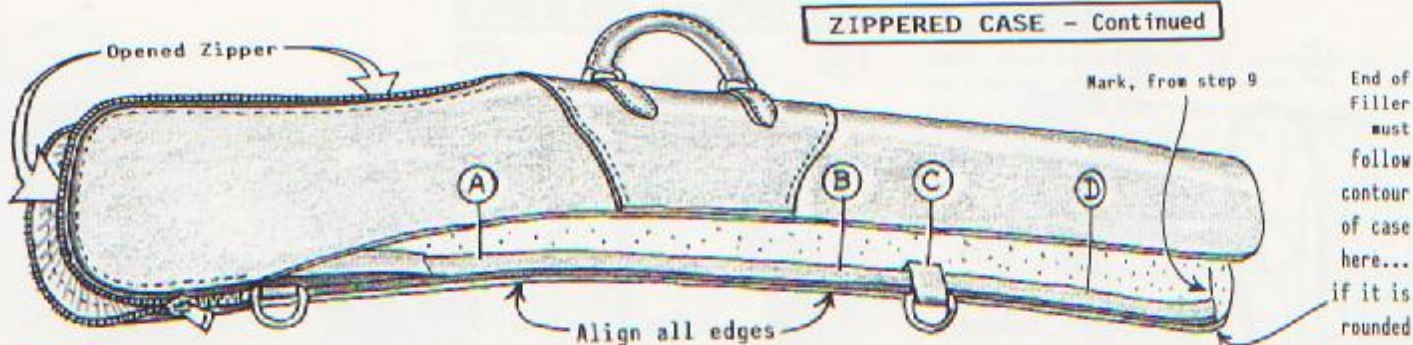


16 After clinching the Bottom Stop (step 15), open the bottom of the case and fold the ends of the zipper tape up. Apply rubber cement to the ends of the tape. Also, cement the end and underside of the filler, and along the bottom edge, inside the case.



17 Spread the case open as far as possible (at the Bottom Stop) and begin adhering the Dee and Filler Assembly in place. Force it up tight against the Bottom Stop (above). Now reach inside the case (from butt) and adhere the zipper tape to the end of filler.

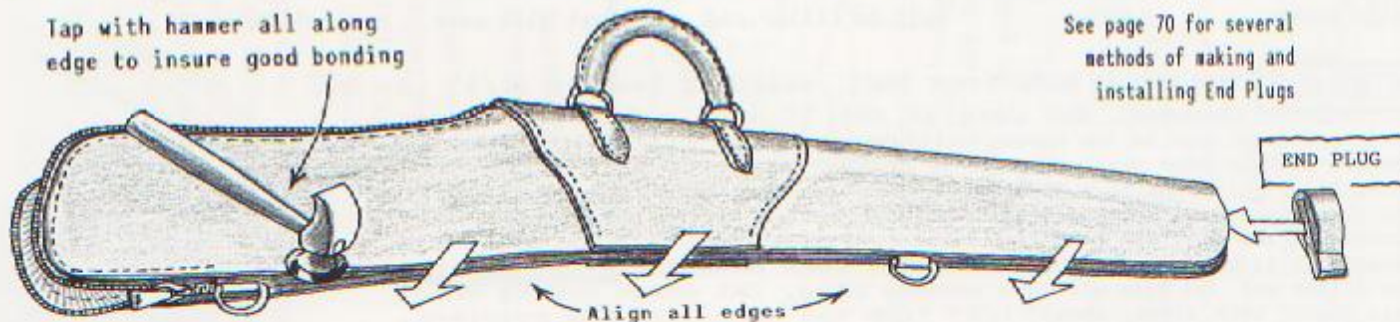
ZIPPERED CASE - Continued



18 After beginning the installation of the filler (step 17), continue in the following sequence: Adhere along the edge (A) and (B) and cut off at the dee position. Adhere the Dee Unit (C). Adhere the remaining filler (D). Push tight to dee leather; end at mark.

Tap with hammer all along edge to insure good bonding

See page 70 for several methods of making and installing End Plugs

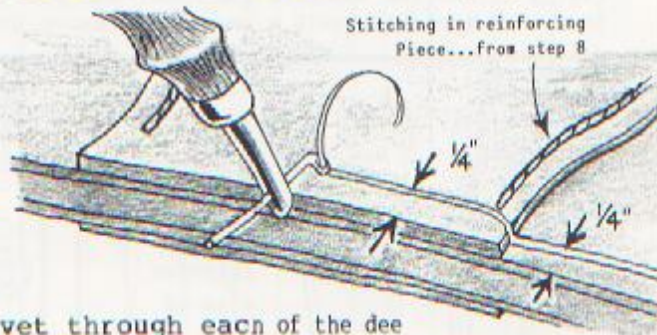
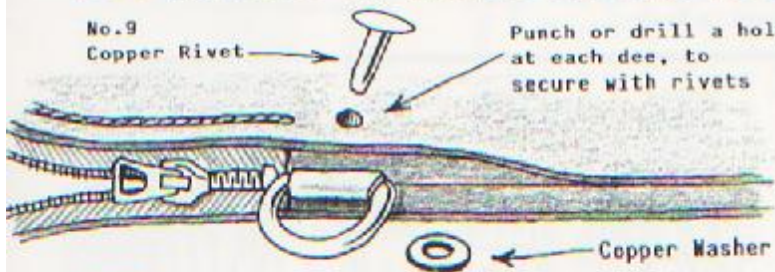


19 Now apply cement to the top side of the filler and to the inside of the other edge of the case. Lay the top edge down and adhere it to the filler. Glue the end plug in.

No. 9 Copper Rivet

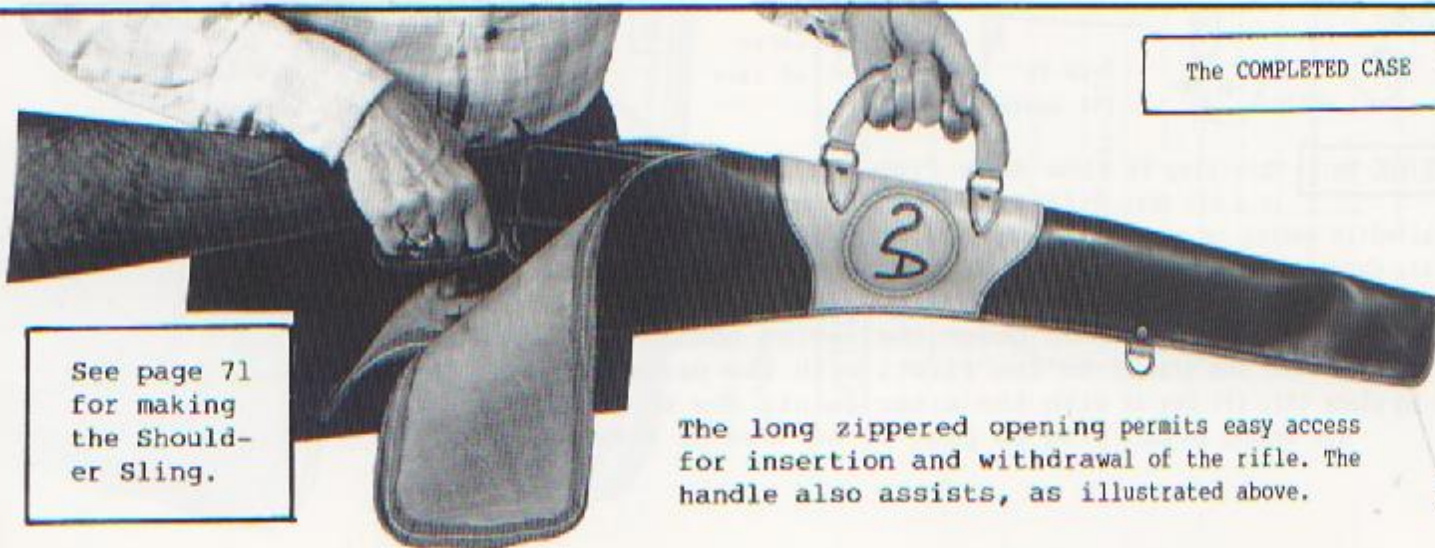
Punch or drill a hole at each dee, to secure with rivets

Stitching in reinforcing Piece...from step 8



20 With the filler secured, "set" a copper rivet through each of the dee leathers. Now gouge a sewing channel 1/4" from the edge, on both sides. Avoid gouging into the rivets. Sew the case together by following all previous instructions. TIP: When sewing along the filler (using the stitching horse) it would help to have a length of 1/2" thick board inserted in the case. Use a large Beveler to round the edges, then burnish.

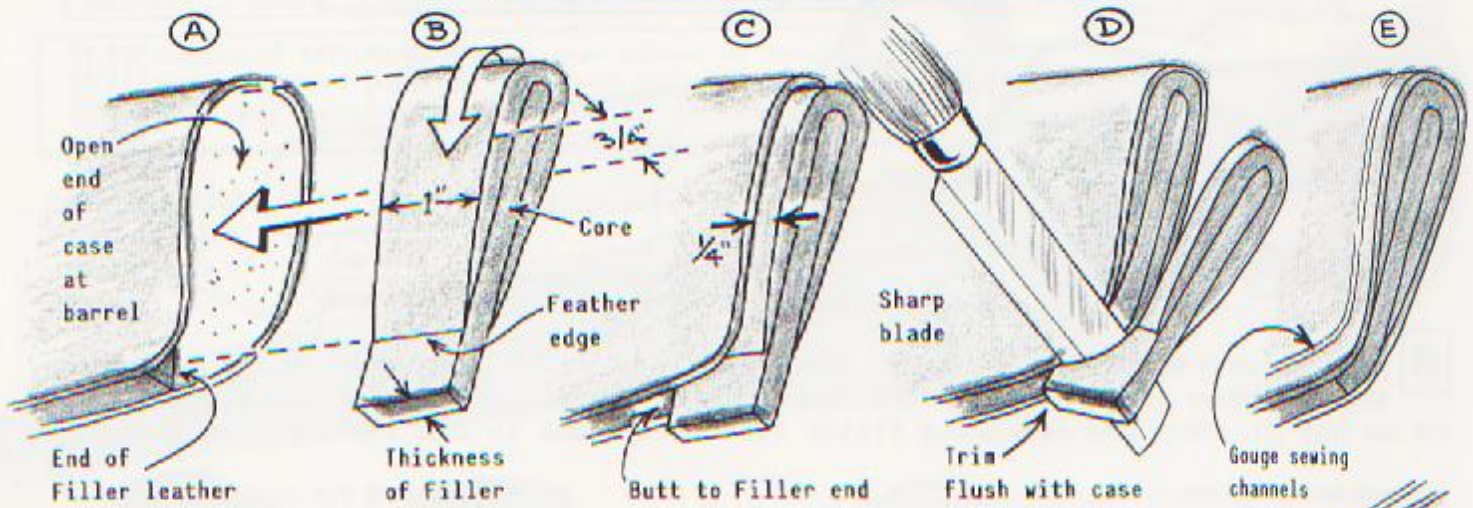
The COMPLETED CASE



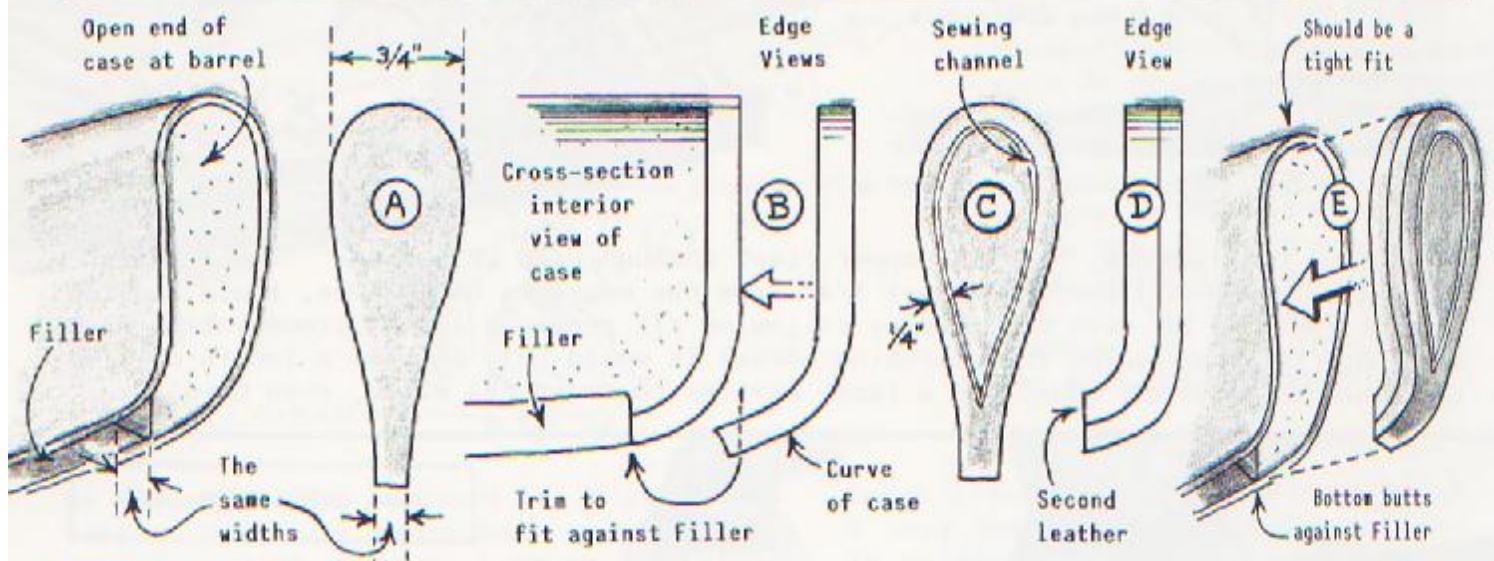
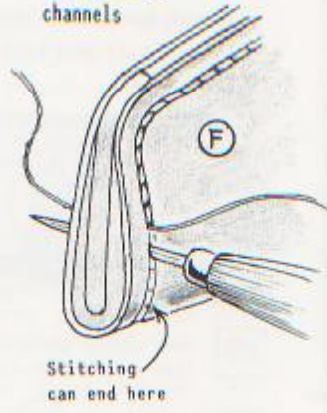
See page 71 for making the Shoulder Sling.

The long zippered opening permits easy access for insertion and withdrawal of the rifle. The handle also assists, as illustrated above.

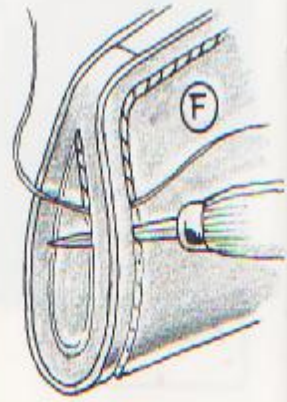
MAKING and INSTALLING the END PLUGS



METHOD No. 1 This plug is made from 16oz. skirting leather (1/4" in thickness). The core is cut 1" wide and a bit longer than needed. It must be the same thickness as the filler. The top is rounded with an Edge Beveler. Cut a second piece to fold around the core. Skive both ends to a feather. The skived ends (when glued to the core) should be about midway at the filler width, see (A) & (B) above. (C) Now glue the plug in place with about 1/4" extended. It should fit tightly inside the case. The core must fit tight against the filler end. (D) Trim off the excess plug. (E) Gouge sewing channels around both sides, about 1/4" from the edge. (F) Sew together. You will need a heavy awl, as you must sew through the total thickness. NOTE: When sewing through the plug, do not pry it back & forth trying to hit the opposite channel or you may break the blade. Keep it sharp! Make stabs with a straight push on the awl blade.



METHOD No. 2 This plug is also made from 16oz. skirting leather. It is a bit more difficult to fit in the case, but once installed is easier to sew. The shape of the plug will resemble sketch (A). Cut it longer than required at the bottom...which should be the same thickness as the filler. (B) Shows how you trim and fit it to the case. (C) When properly fitted, gouge the sewing channel. (D) Now cut a second leather and glue it to the first, with the proper curve. Glue it in place (E). (F) Sew as with the miter joint. See the instructions for sewing in this plug on page 11 of "How to Make Holsters".





Squared end of the case or scabbard (see Shotgun Case - page 77)

METHOD No.3 This is the same as Method No.2...except that the end of the case is cut square, not rounded. This makes the forming and installing of the plug much simpler. The filler will extend closer to the end unless 3 thicknesses of plug leather are used. Sew the plug as in step (F) of Method No.2.

Cross-section interior view of case

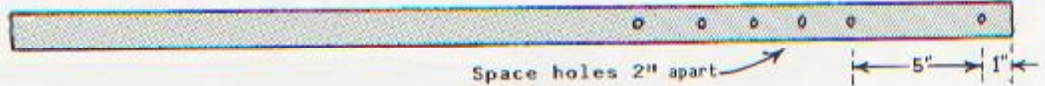
Filler

Double thickness

Edge view of plug

Equal dimensions

MAKING the SHOULDER SLING

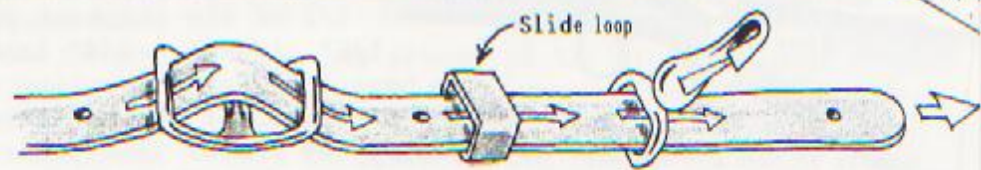


This sling is simple to make and easy to assemble. Cut the strap from 7/8oz. cowhide, 3/4" wide and about 36" long. The length will vary depending on the distance between the dees on your case. You will have to cut it even longer if the sling is carried to the opposite shoulder, across the chest. Punch No.5 holes as indicated.

1 Burnish the edges. Skive some of the thickness off of the ends. Rivet or sew one of the snaps to the plain end of the strap (right). Round the other end.



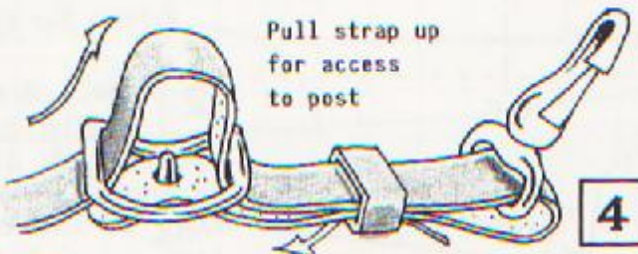
Carry the case with the barrel up or down.



2 Make a Slide Loop from 6/7oz. cowhide. Begin assembly as follows: Run strap through Conway, Loop, and snap as shown above.



3/4" CONWAY BUCKLE



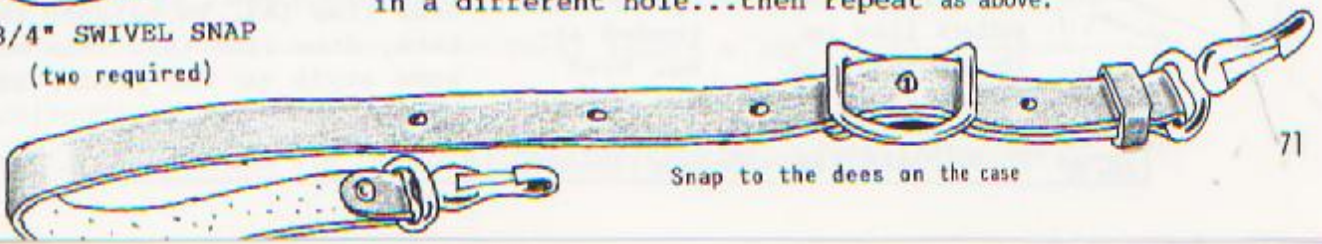
Pull strap up for access to post

3 Turn the strap under, go back through loop and up inside the buckle. Fit the end hole over the Conway post.



3/4" SWIVEL SNAP (two required)

4 Pull the strap down so one of the holes fits over the post. Adjust the straps to lay flat. This puts the snap at the fold. Force the loop up close to the snap. To make longer or shorter adjustments, pull the loop away from the snap. Put the strap in a different hole...then repeat as above.



Snap to the dees on the case

ZIPPERED CASE - for BOLT-ACTION RIFLES

This case has a two-handle assembly with Dees & Shields.

Handle No.4 - 9½" long

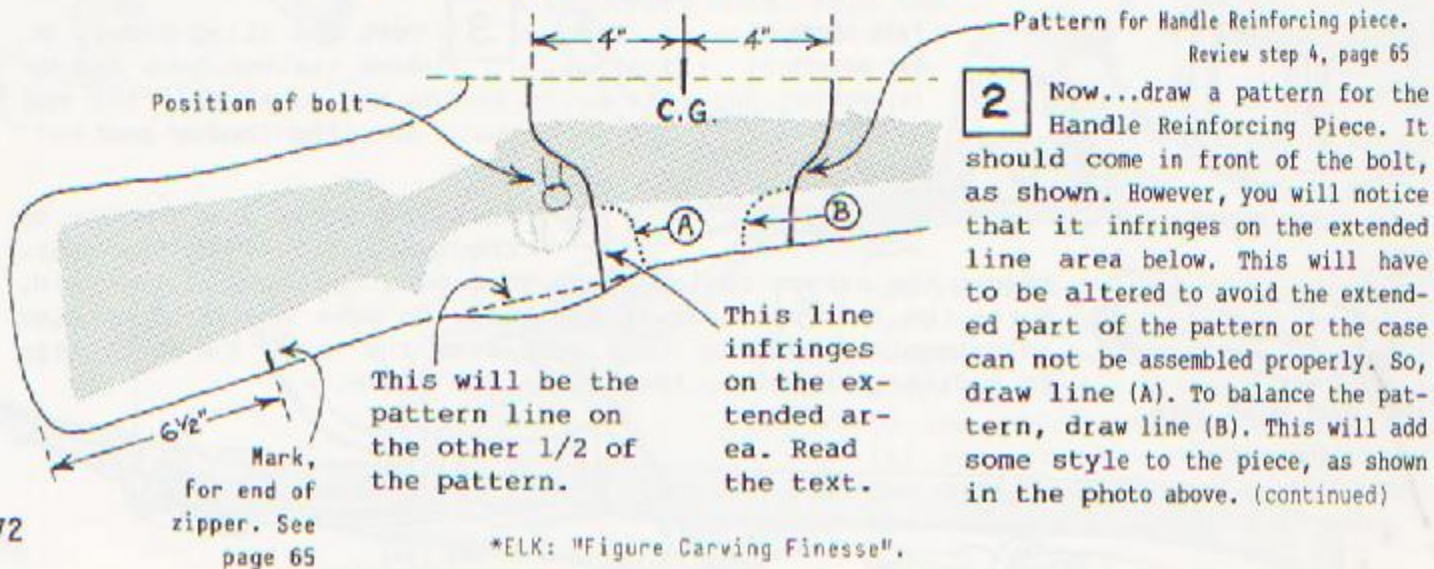
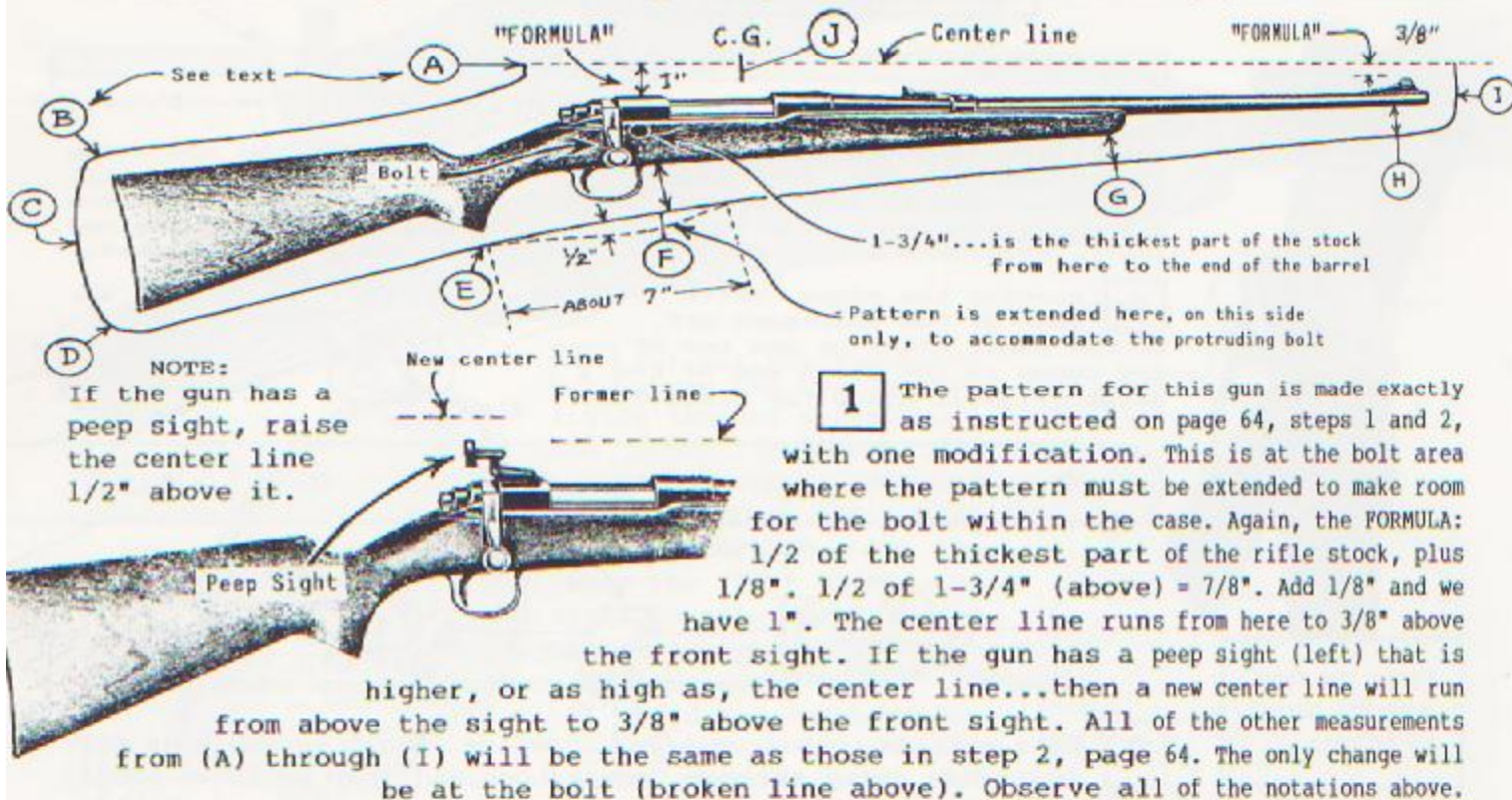


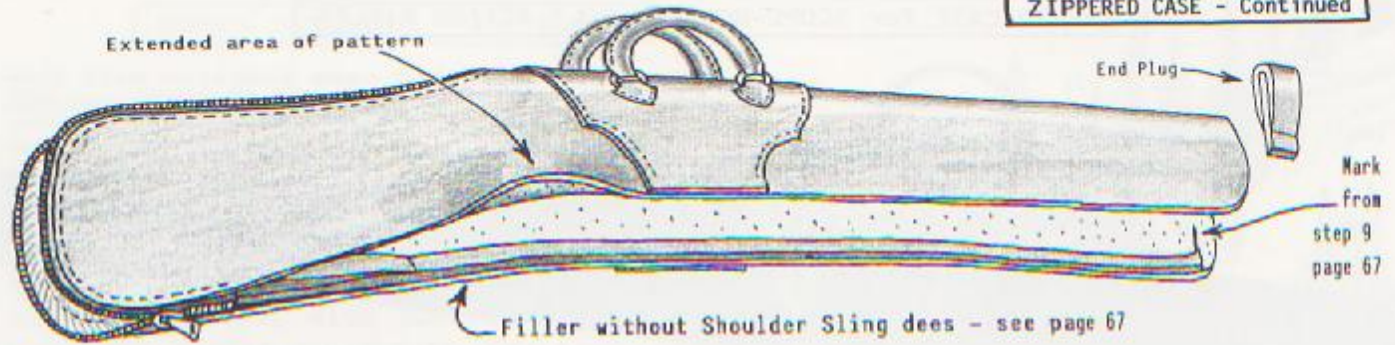
Carving Design*

This case is made of the same leathers as suggested on page 64. No shoulder sling dees.

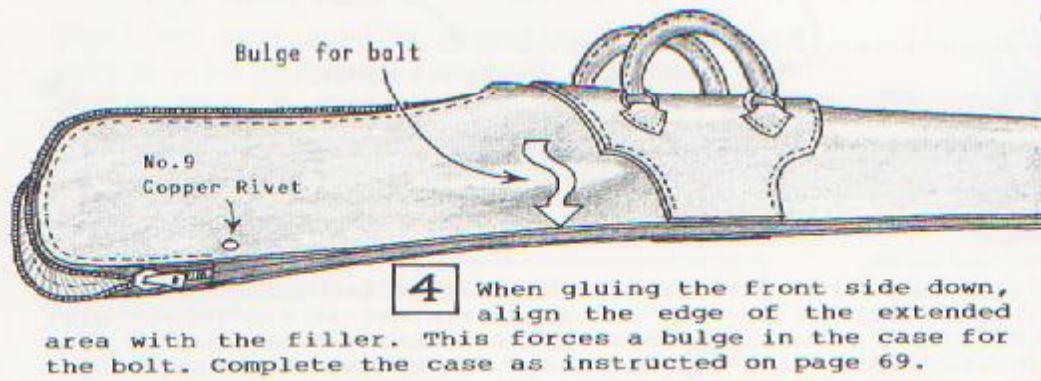
MAKING the PATTERN

This pattern is made by using the same "FORMULA" as on page 64.

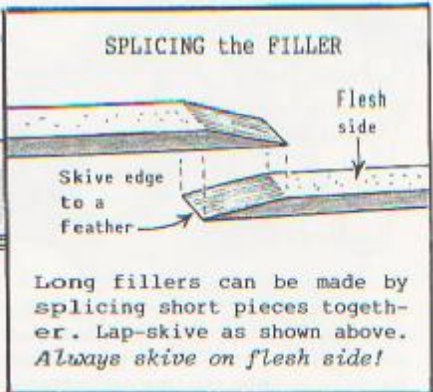




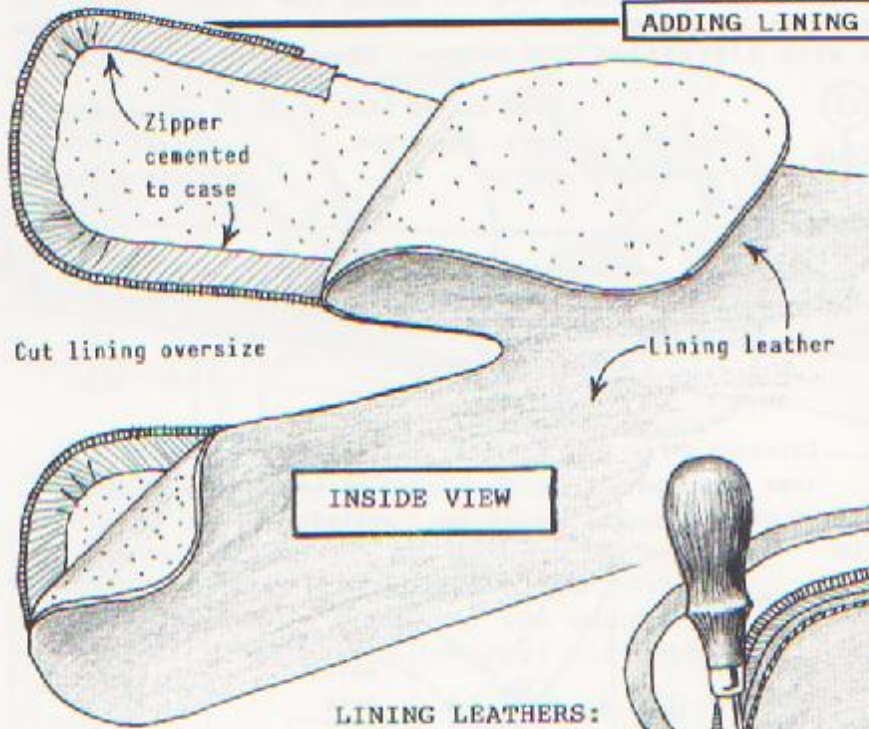
3 Now continue assembling the case exactly as instructed in steps 5 through 18, pages 65 to 69. Make the filler as instructed on page 67. This is made in one continuous strip, as shoulder sling dees are not used.



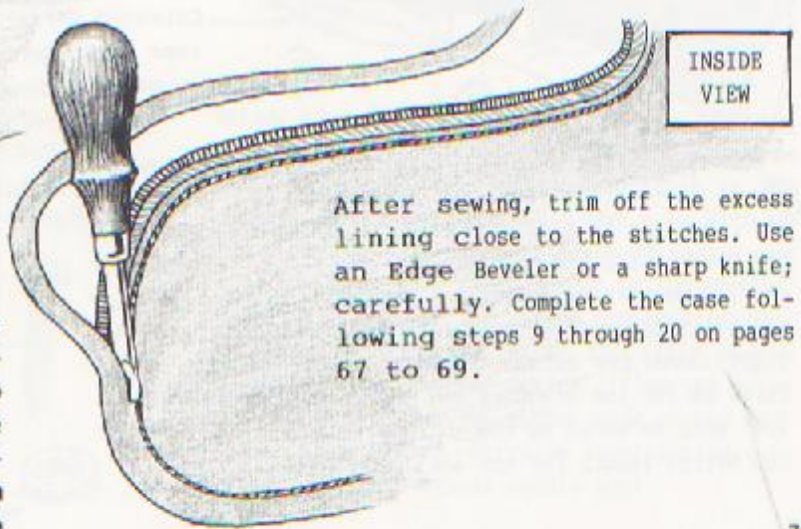
4 When gluing the front side down, align the edge of the extended area with the filler. This forces a bulge in the case for the bolt. Complete the case as instructed on page 69.



ADDING LINING to the ZIPPERED GUN CASE



If you are going to line the case, do not sew the zipper in until the lining has been cemented in place. Cut the lining oversize to be sure of catching the stitches. Now, you can go ahead and sew in the zipper and Handle Assembly as instructed in step 8, page 66. Sewing through the Handle Reinforcing Piece along with the lining, aids in securing the lining to the case.



After sewing, trim off the excess lining close to the stitches. Use an Edge Beveler or a sharp knife; carefully. Complete the case following steps 9 through 20 on pages 67 to 69.

LINING LEATHERS:
Most any durable lightweight leather is preferred. Stay away from materials that are water absorbent. We do not recommend shearling if the case is subjected to much rain. If shearling is used, you will have to trim the wool near the zipper's edge so the teeth will not engage it.

ZIPPERED CASE for SCOPE-MOUNTED BOLT-ACTION RIFLES

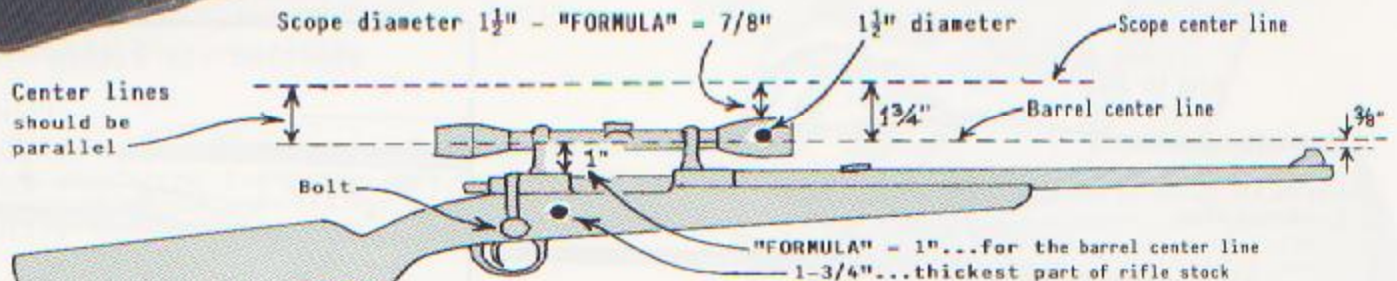
Handle No.4 - 9½" long

This case features Welt Construction above the barrel.

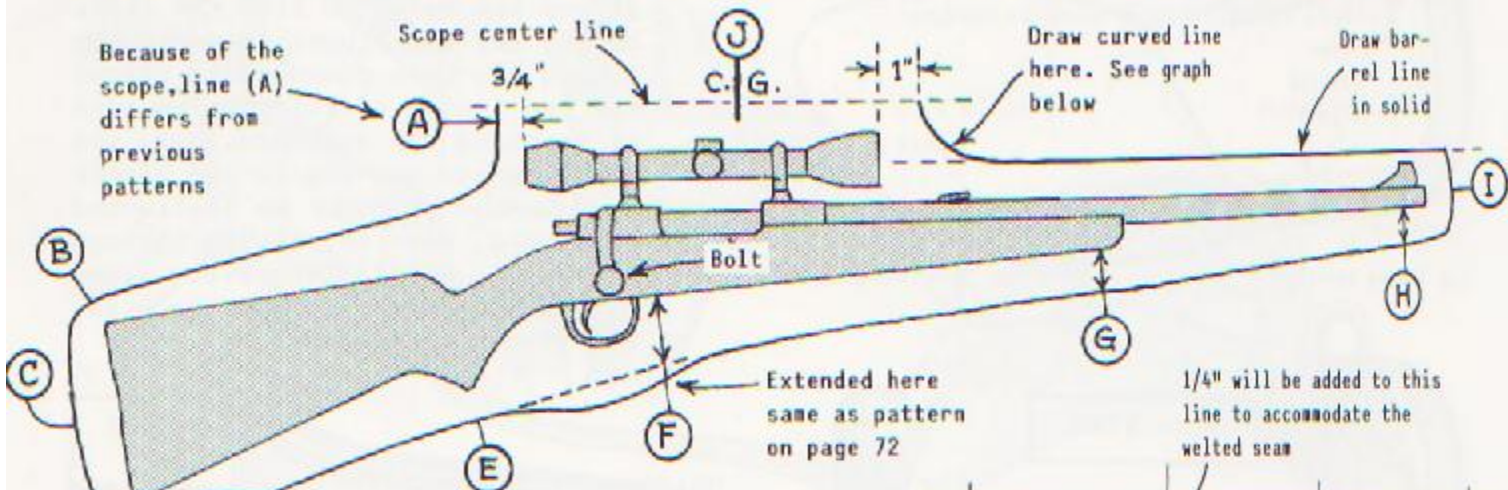
Carving Design*



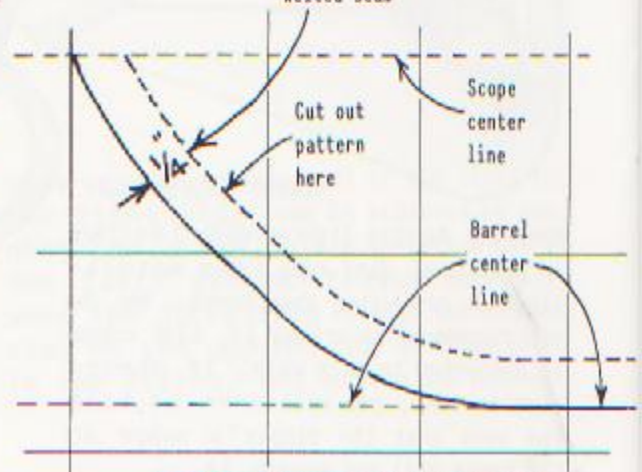
Be sure to review the "FORMULA" instructions in step 1, page 64. This also applies to the scope.

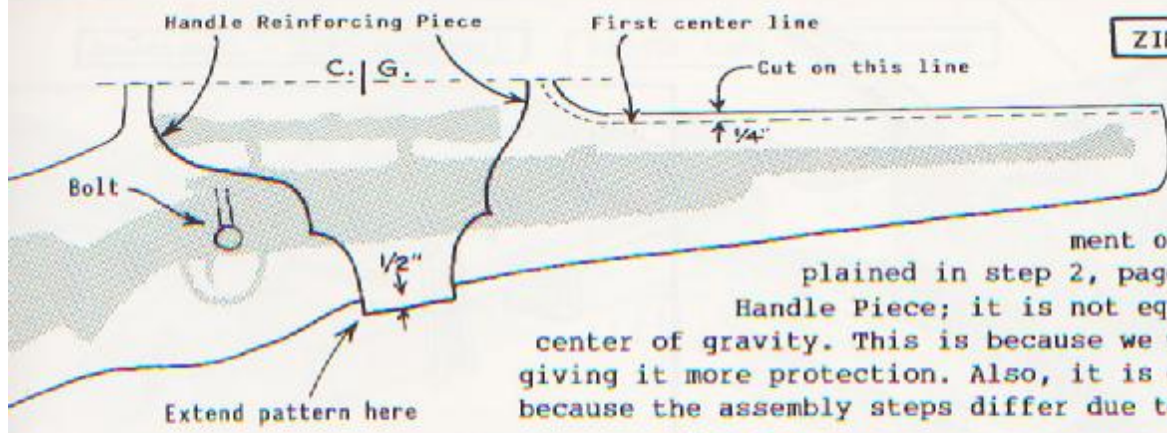


1 Forming the scope area for this case is similar to the scabbard on page 62. However, this differs in that the split leather at the barrel will be sewn together with a welt. As before, first establish the center line for the barrel. Next...the center line for the scope, which (here) is 1½" in diameter. FORMULA: 1/2 of 1½" = 3/4". Add 1/8" and you have 7/8"...above the scope. Draw the center lines on your paper to begin the pattern. In this instance, the center lines are 1-3/4" apart. This will not be the same with all rifles and scopes. Observe the notations.

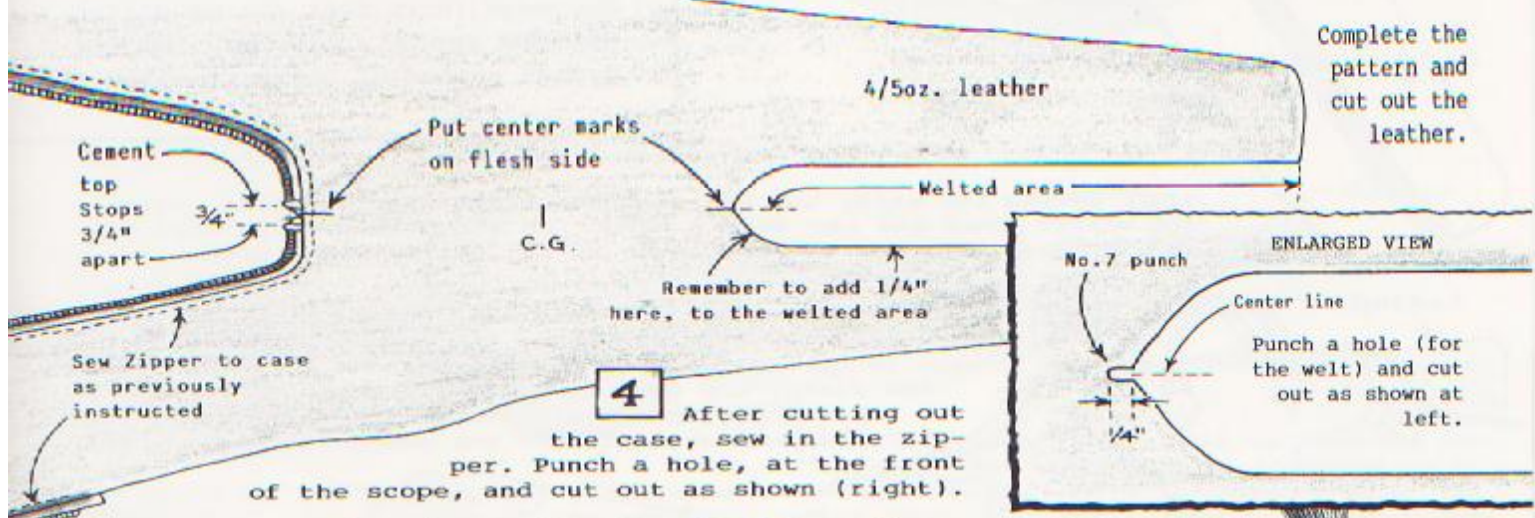


2 Draw line (A) down as shown. Dimensions from (B) through (I) will be the same as those in step 2, page 64. Extend the pattern for the bolt as on page 72. Complete the 1/2 pattern by drawing a curved line (at the scope) to connect the center lines. The graph at right shows the actual curve. This is the same curve as for the scabbard on page 62. However... 1/4" must be added at the curve and along all of the barrel length for the welted seam.

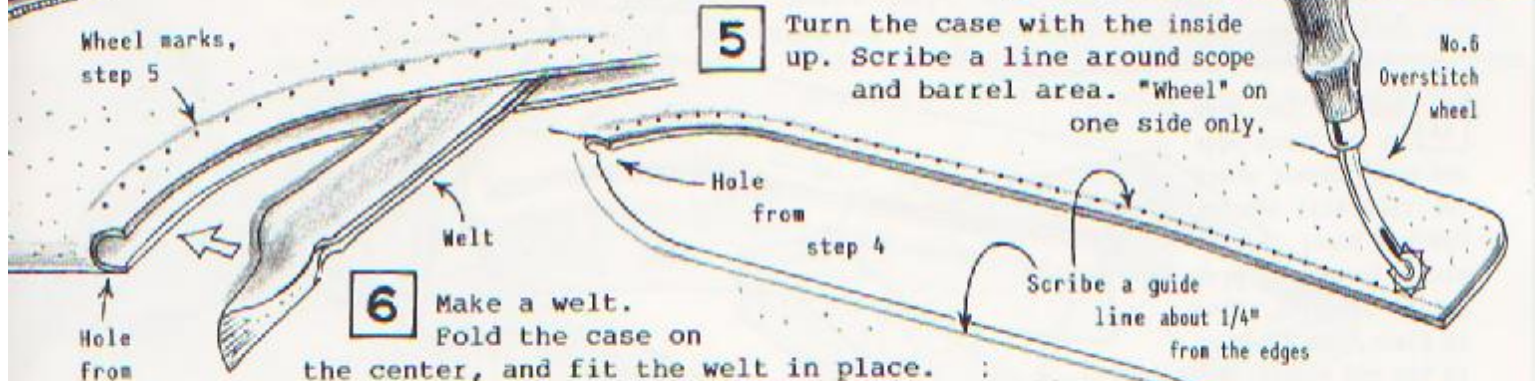




3 Draw the Handle-Piece pattern as indicated, avoiding the bolt and infringement on the extended area (explained in step 2, page 72). At the top of the Handle Piece; it is not equal on both sides of the center of gravity. This is because we want to cover the scope, giving it more protection. Also, it is cut longer at the bottom because the assembly steps differ due to the welt construction.

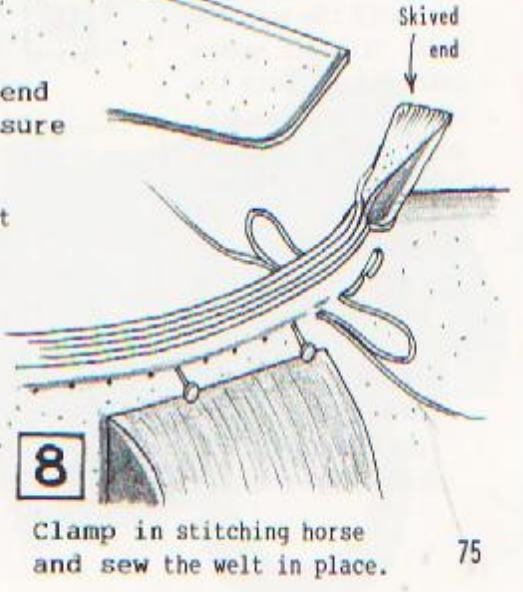
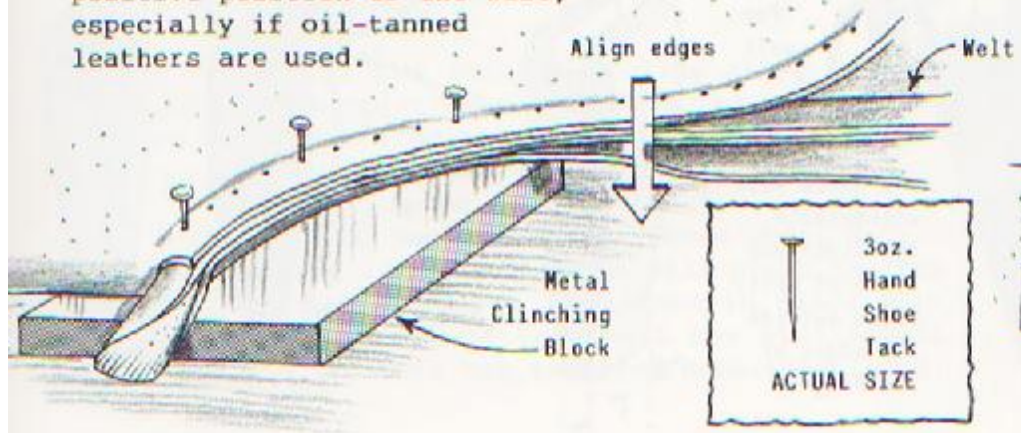


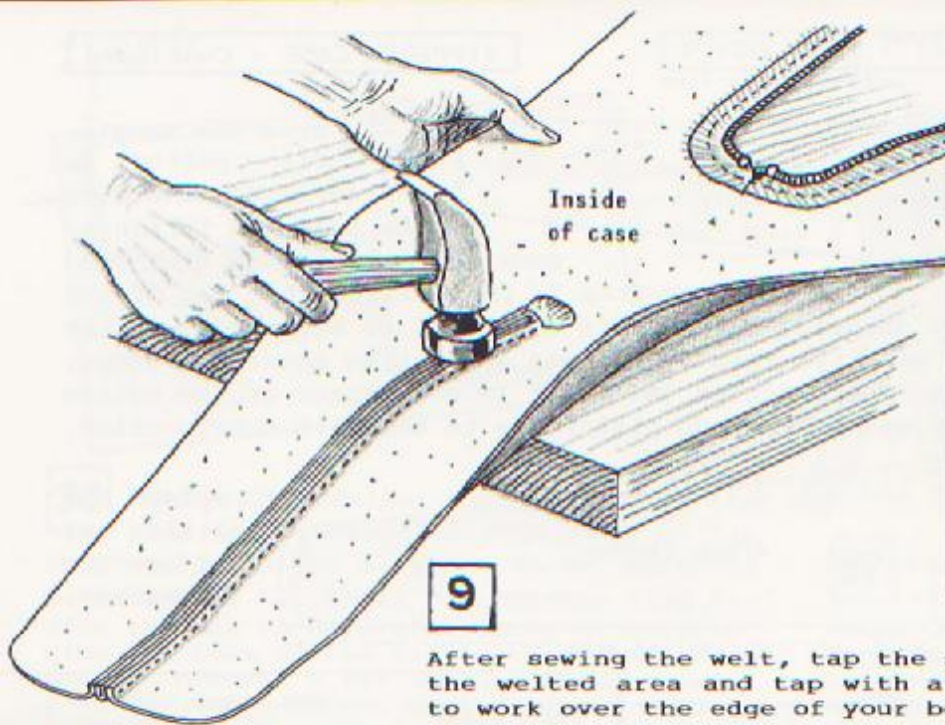
4 After cutting out the case, sew in the zipper. Punch a hole, at the front of the scope, and cut out as shown (right).



6 Make a welt. Fold the case on the center, and fit the welt in place.

7 Place a tack in the first wheel mark to secure the end of the welt. The welt can be cemented, but tacks insure positive position of the welt, especially if oil-tanned leathers are used.

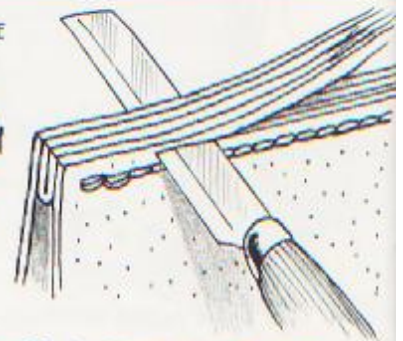




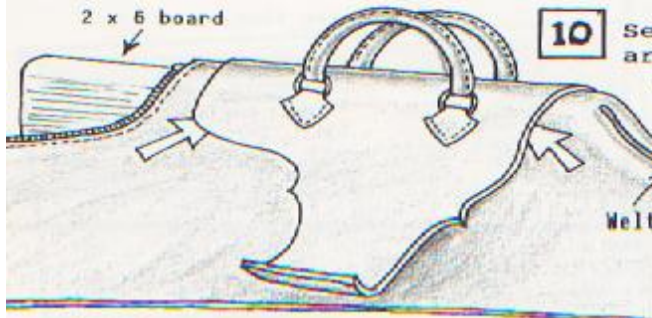
9

After sewing the welt, tap the stitches flat. Trim the welt. Moisten the welted area and tap with a hammer as shown above. You will have to work over the edge of your bench to tap at the scope area.

Trim off excess welt

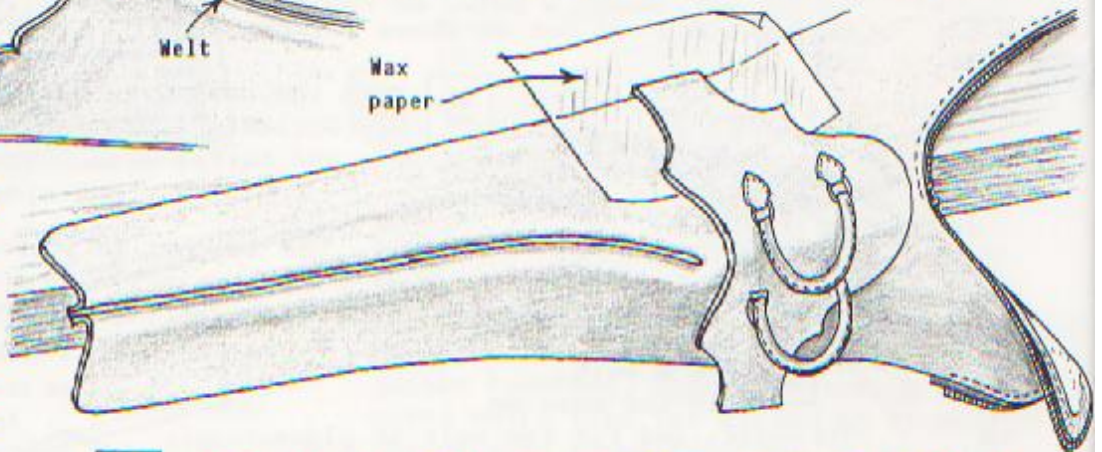


See page 78 in "The Art of MAKING LEATHER CASES", Vol. TWO, for the proper method of trimming welts.



10

Sew the handles to the Reinforcing Piece. Since the scope area cannot lay flat, cementing the Handle Assembly to the case is more difficult. Lay a length of 2"x6" lumber on the bench; top edge rounded. Place the scope area on this board, and begin cementing at the top (large arrows at left). Do not cement the sides, yet.

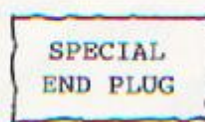


11

Now lay the case on the bench edge and apply cement where the side will adhere. Use wax paper if necessary to prevent premature adhesion. When in place, use a hammer to tap and secure. Repeat with the opposite side. Trim off excess leather flush with the edge of the case. Now, gouge sewing channels. Sew the Handle Assembly to within 1/4" of the edge of the case, as instructed in step 8, page 66.

12

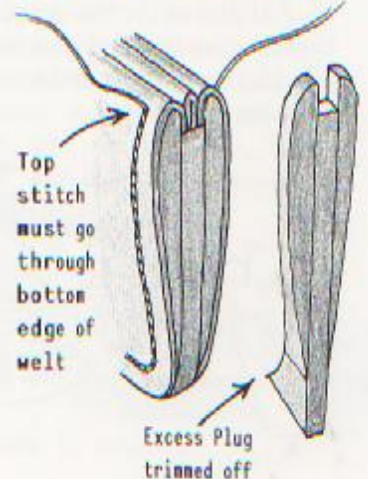
Complete the case now by adding the filler and the end plug. Follow all previous instructions for riveting, sewing, etc. NOTE: A special end plug (below) is required.



Open end of case

Notch for welt

The notch must accommodate the width and depth of welt. Round outside top edges of the Plug



Top stitch must go through bottom edge of welt

Excess Plug trimmed off

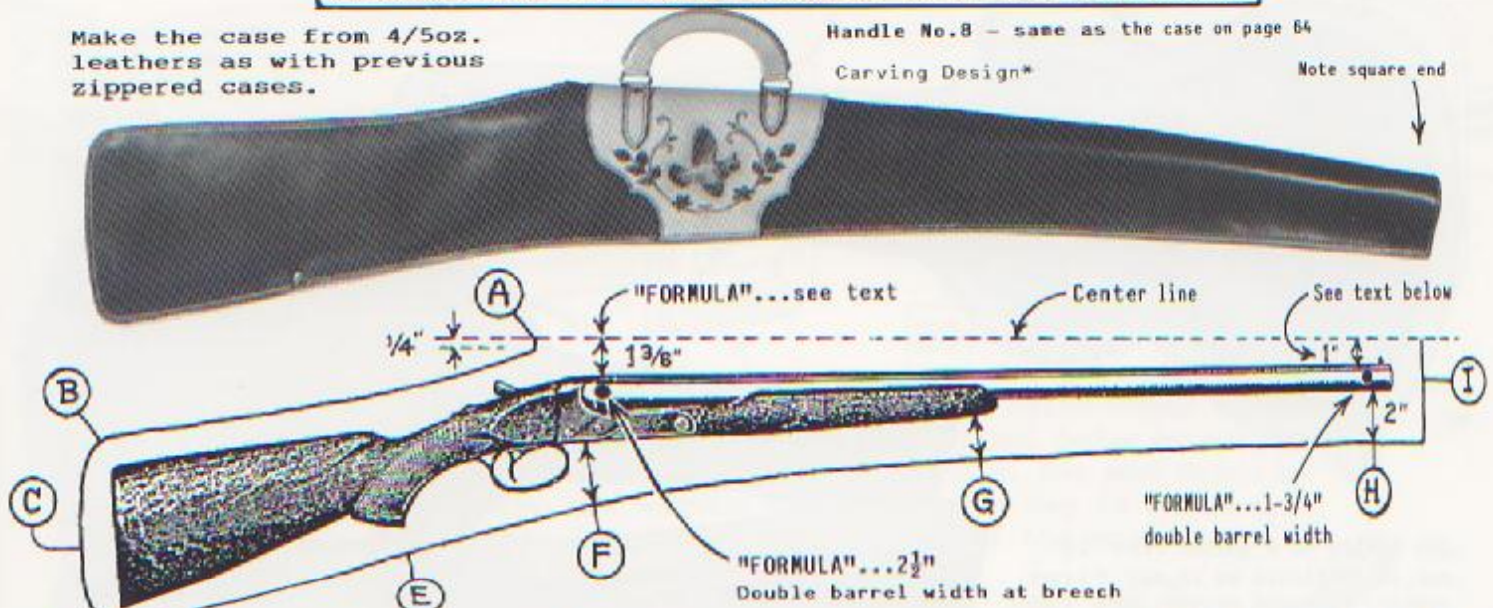
ZIPPERED CASE for DOUBLE BARRELED (side-by-side) SHOTGUNS

Make the case from 4/5oz. leathers as with previous zippered cases.

Handle No.8 - same as the case on page 64

Carving Design*

Note square end



This case is made exactly as the one on page 64, with one exception: This is at the end, where both barrels lay side-by-side with only a button front sight. The FORMULA is used: $1/2$ of $1-3/4" = 7/8"$. Add $1/8"$ to this for a total of $1"$ to the center line above barrel. Since the barrel widths here are so extreme, add another $1"$, below the barrel, to make $2"$ to the pattern line at (H). The FORMULA is also employed

at the breech: $1/2$ of $2 1/2" = 1 1/4"$. Add $1/8"$ for a total of $1-3/8"$ to the center line.

Line (A) begins just ahead of the thumb release. The rest of the measurements from (B) through (I) are the same as step 2, on page 64...except for (H). Complete the case by following steps 3 through 20, pages 65 to 69. Use Method No.3, page 71, for making the End Plug. Cut it to the shape as below. Remember the center of gravity; for handle.

OTHER SHOTGUNS

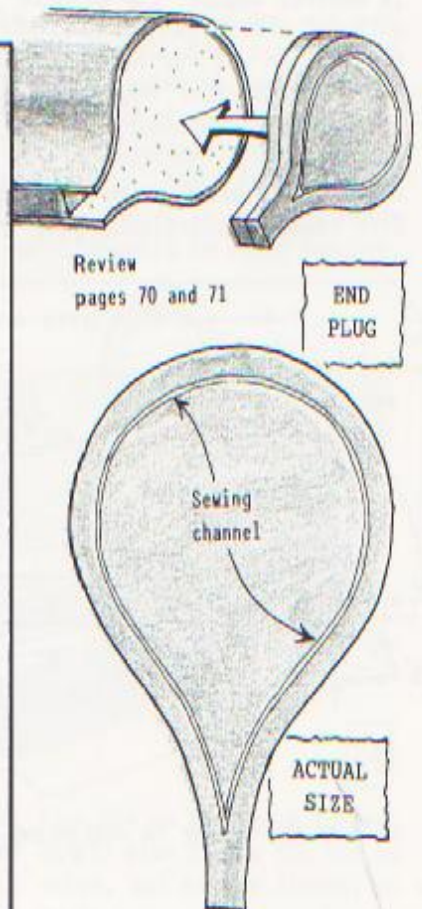
Over-Under

Pump-Action

Automatic

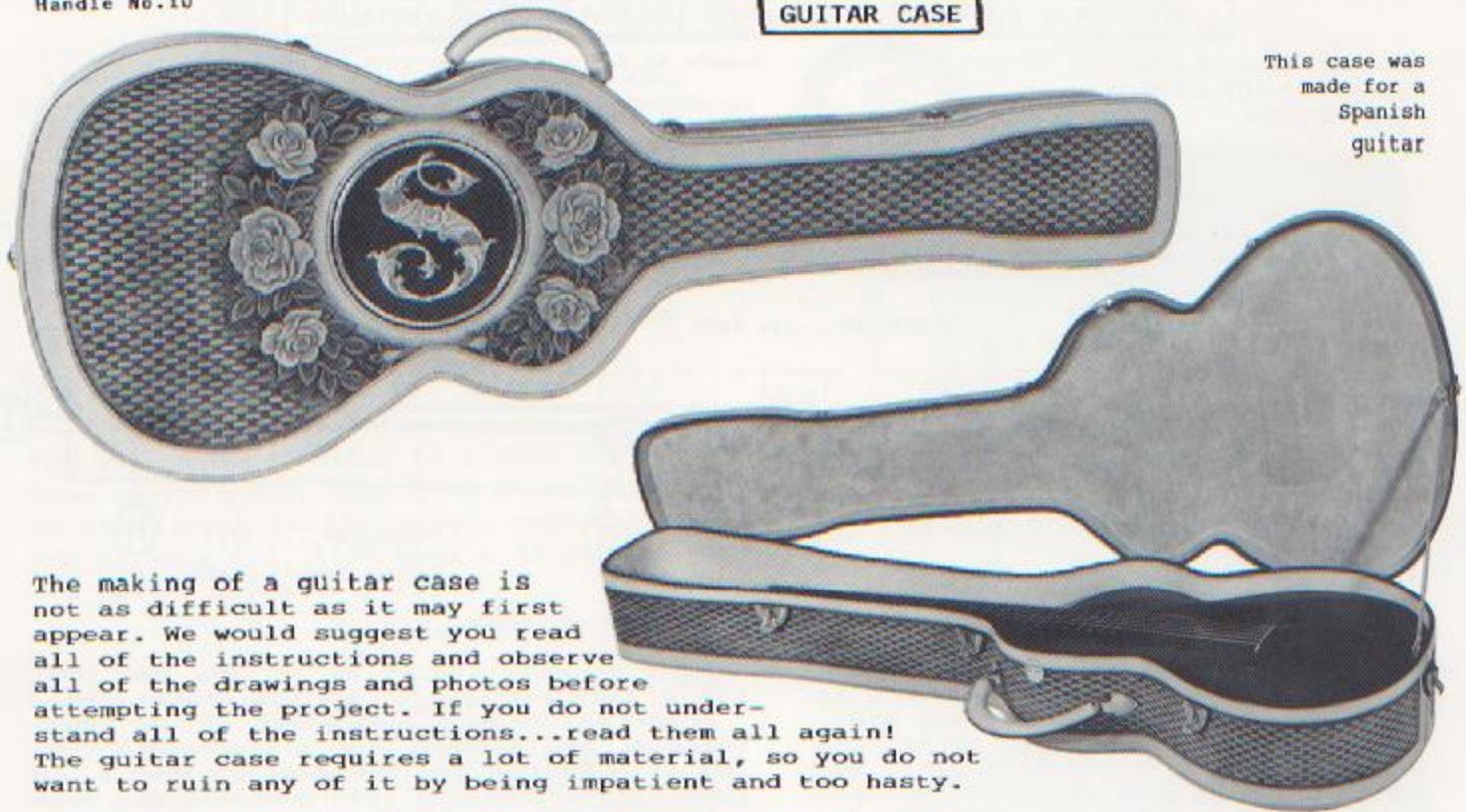
Single Barrel

NOTE: for AUTOMATIC, PUMP, OVER-UNDER, or SINGLE barrel shotguns...use the same instructions as given on pages 64 through 69. However, with all shotguns (not including side-by-side double barrel above), the center line should be $1/2"$ above the barrel. With a bolt action shotgun, follow instructions on pages 72 & 73.



GUITAR CASE

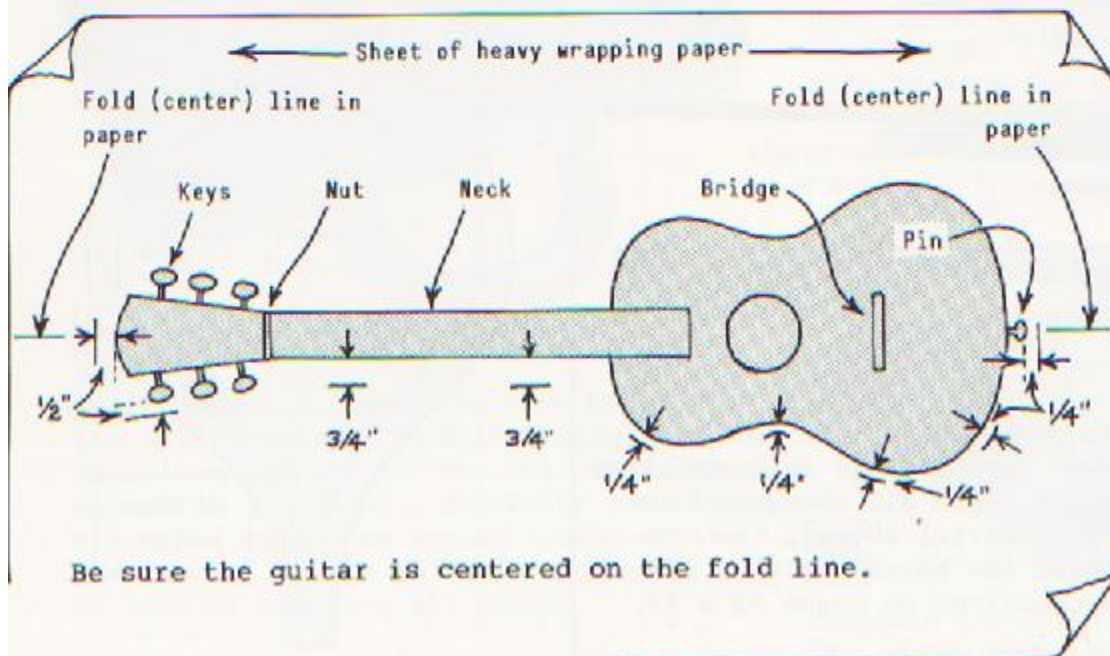
This case was
made for a
Spanish
guitar



The making of a guitar case is not as difficult as it may first appear. We would suggest you read all of the instructions and observe all of the drawings and photos before attempting the project. If you do not understand all of the instructions...read them all again! The guitar case requires a lot of material, so you do not want to ruin any of it by being impatient and too hasty.

The design on this case is a combination of basket stamping and traditional carving and stamping of the rose. The roses are colored in natural shades. The basket stamping was antiqued (see "COLORING LEATHER"). The center section was cut out with gold-kid piping at the circles' edge. The letter "S" is embossed with secondary plugs (see EMBOSsing LEATHER). The letter was cut out and appliquéd to green suede (see cover photo). With these instructions, you can also make

cases for banjos, violins, mandolins, and other stringed instruments of similar construction, regardless of their outer shape. Before beginning be sure to have all of the necessary materials including the catches and other hardware. Metal hinges cannot be used successfully because the three hinging points will not be on a straight line. Use leather hinges. Observe the exploded view on the opposite page to familiarize yourself with the parts required for the case.

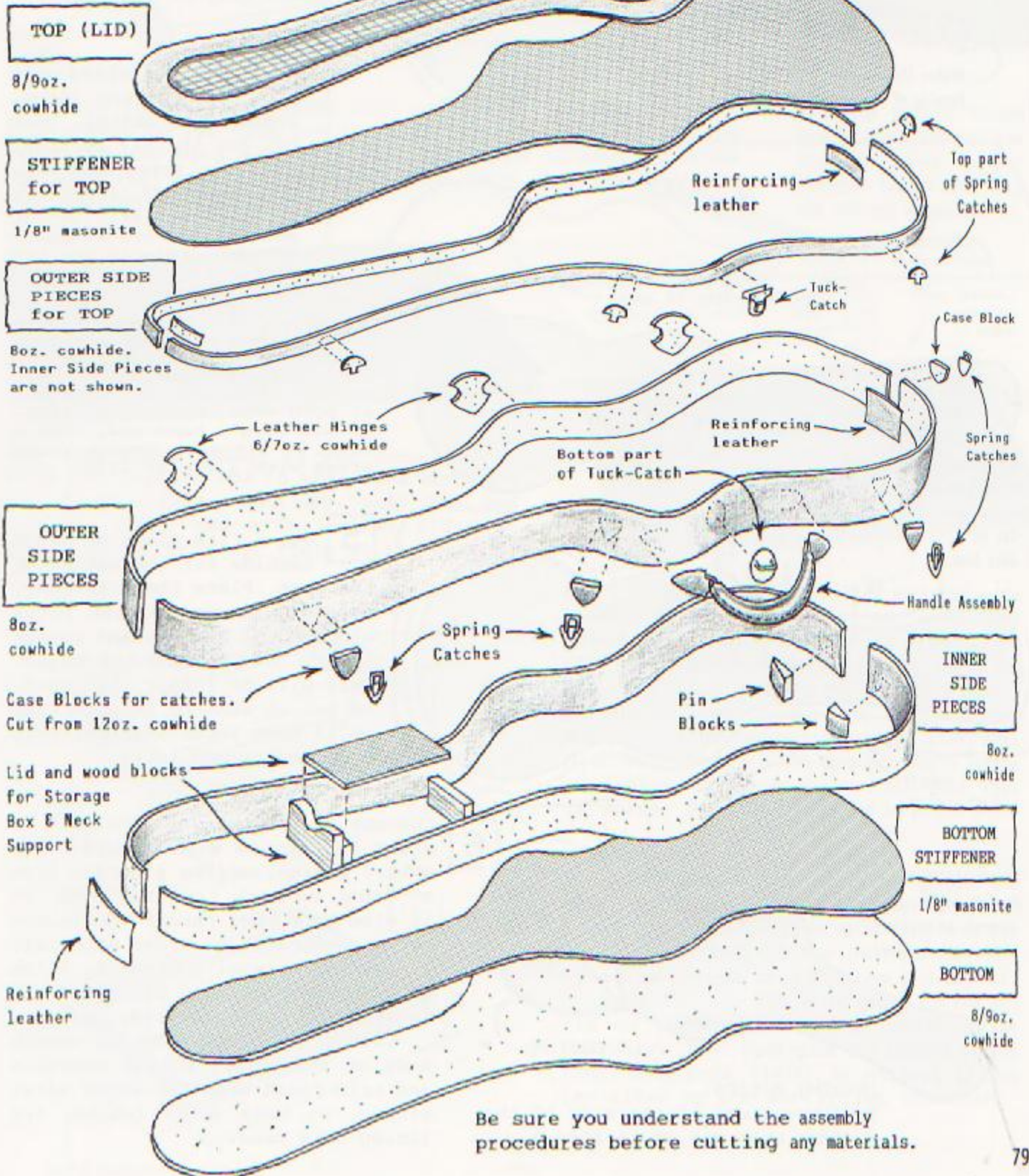


- 1 The first step is to make the pattern for the bottom of the case. Fold a sheet of paper in half to create a center line. Spread it out flat on your bench and place the guitar centered on this fold line. Put some marks on the paper away from the guitar as shown at left. This will allow clearance for the guitar within the case.

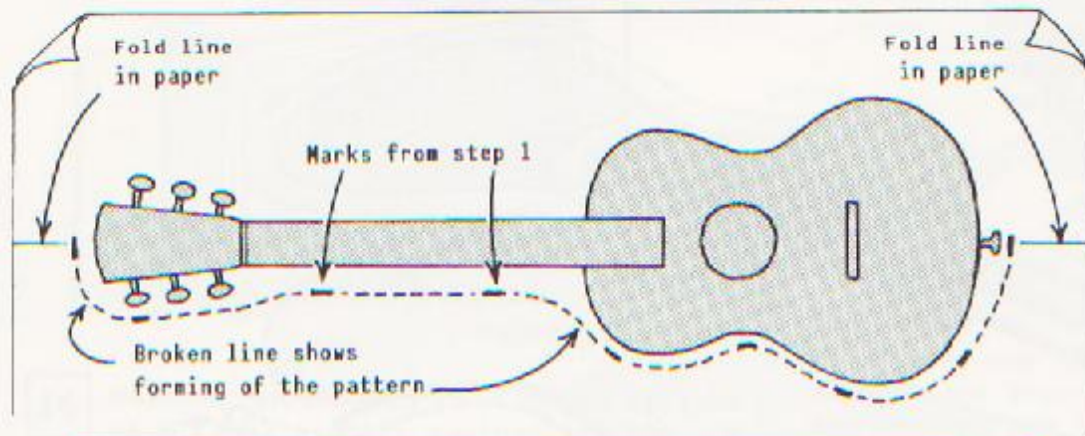
Instructions are continued on page 80.

EXPLODED VIEW of the GUITAR CASE

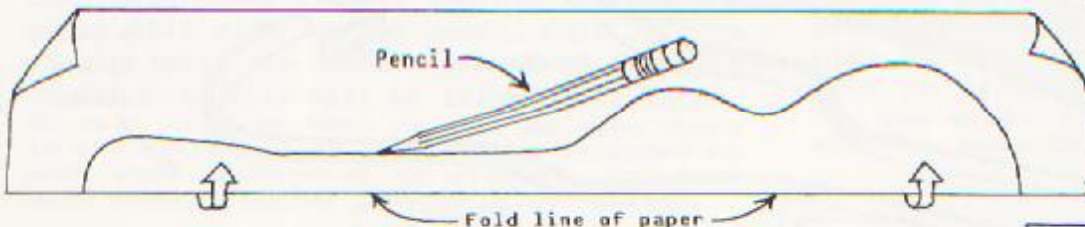
Except for the lining leathers, all parts for the guitar case are shown. Refer to the step-by-step instructions for the proper assembly procedures.



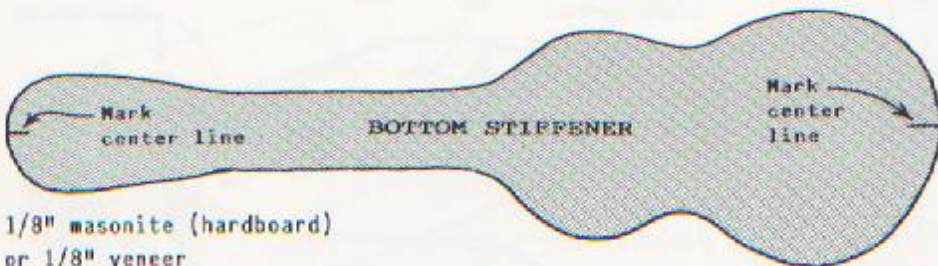
GUITAR CASE - Continued



2 Now draw lines connecting all of the marks from step 1, shown with broken lines; left. Draw flowing lines for a pleasing effect. Curve out where the neck joins the body of the guitar.

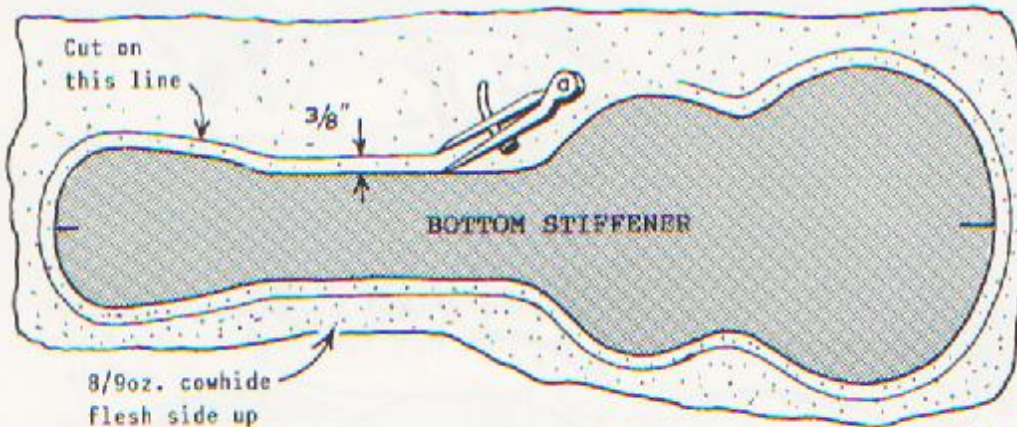


3 When satisfied with the pattern lines, remove the guitar. Then cut out the 1/2 pattern. Fold the paper and draw the other 1/2 of pattern as shown at left. Unfold and cut out the complete pattern. This is for the bottom stiffener only.



1/8" masonite (hardboard)
or 1/8" veneer

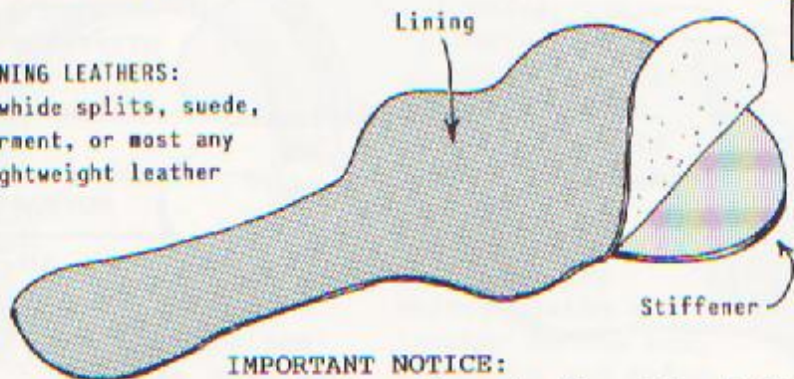
4 Tape the pattern down so it does not move and draw around it to transfer lines to the stiffener material. Mark center lines on the stiffener at both ends. Cut the stiffener out with a band-saw, coping saw, or jig-saw. Smooth rough areas with a coarse file.



8/9oz. cowhide
flesh side up

5 Use a firm piece of 8/9oz. cowhide for the bottom of the case. Place the stiffener, smooth side up, on the flesh side of the leather and scribe a line 3/8" around the edges. This will be larger than needed but we want to be sure that we'll have ample leather. This will be trimmed later.

LINING LEATHERS:
Cowhide splits, suede,
garment, or most any
lightweight leather



IMPORTANT NOTICE:
The lining glues to the side of the stiffener that was up in step 5.

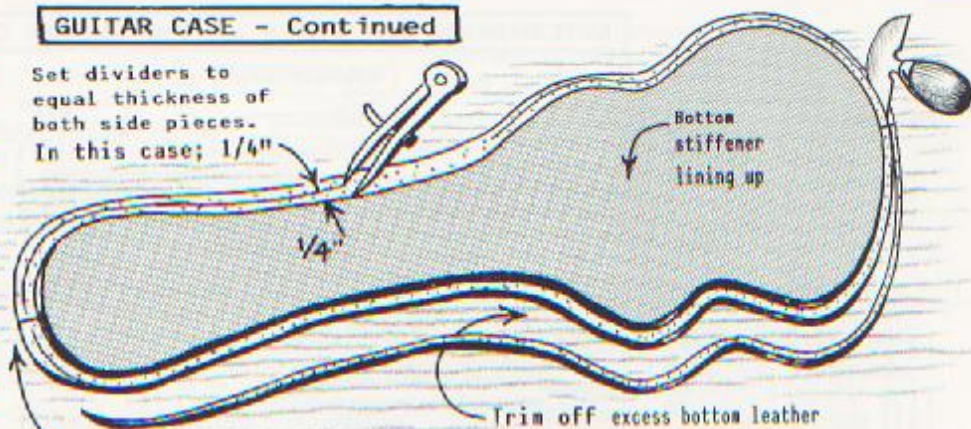
6 Cut out the leather. If you wish to stamp the bottom with a border (or other) design, scribe a border line at least an inch from the edge. It is wise to rubber cement the leather to cardboard, or other material, to prevent excessive stretch. Allow leather to thoroughly dry before it is removed from cardboard.

Glue a lining leather to smooth side of stiffener. Cut it oversize and trim flush with the edges after gluing. We used suede leather for lining this case.

7 Lay the bottom leather flesh side up, and put the stiffener on it. Notice all edges may not be even, especially if bottom leather was stamped. Juggle the stiffener until you have at least $\frac{1}{4}$ " at all edges. Draw around it to mark position, then glue the stiffener to the bottom in this position. Now mark a line $\frac{1}{4}$ " from the stiffener edges, equaling 2 thicknesses of 8oz. leather (the Side Pieces). Trim off excess. Hold the blade perpendicular when cutting.

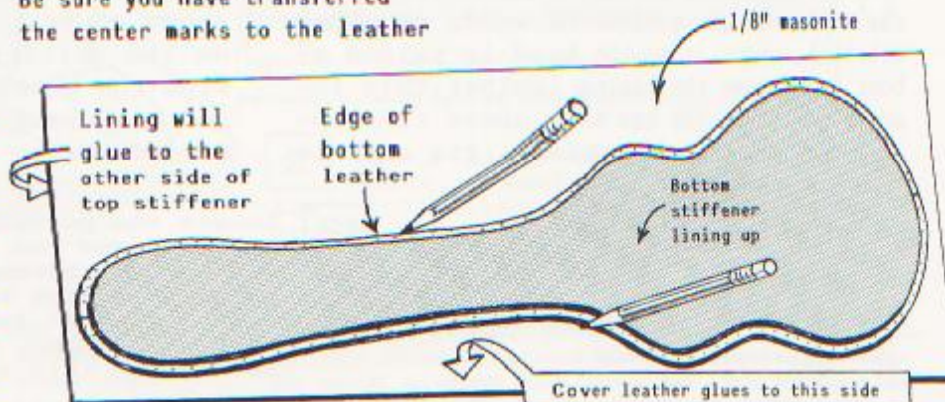
GUITAR CASE - Continued

Set dividers to equal thickness of both side pieces. In this case; $\frac{1}{4}$ "



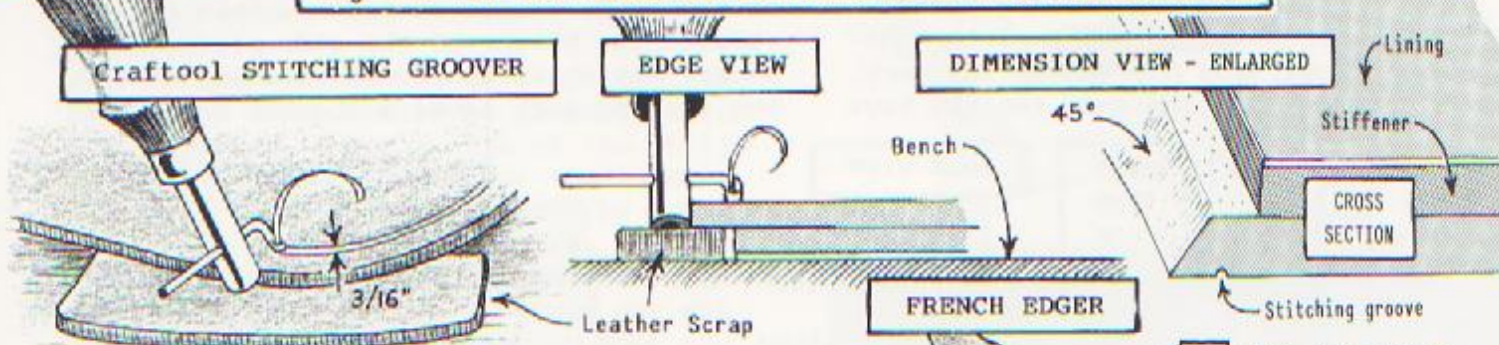
Be sure you have transferred the center marks to the leather

8 Now we must make the top stiffener. Place bottom unit on the rough side of the masonite. weight it down so it will not move! Draw a line against the edge of the leather to mark the outline on the masonite. Use pencil or ballpoint pen to clearly make the line legible. This will guarantee you a perfect fitting lid if you are accurate with your cutting of the masonite. Be sure you do not cut *inside* the line. A coarse file will smooth out any uneven edges. The top leather will glue to the rough side of the masonite. See SPECIAL NOTE; right.

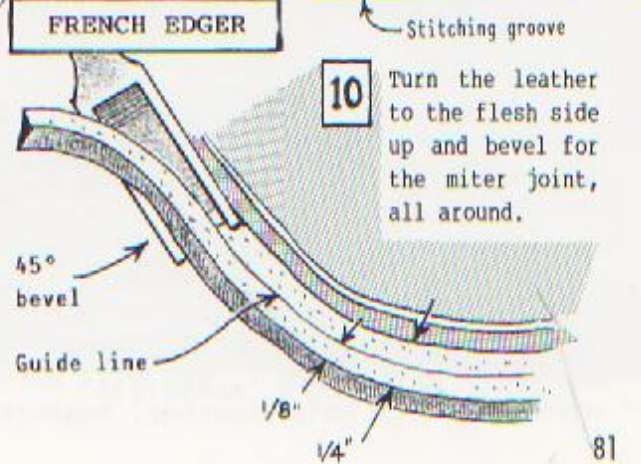


SPECIAL NOTE: One side of the masonite is smooth and the other rough. We have chosen to glue the bottom/top leathers to the rough side. If you are using smooth veneer you must mark which side the leathers will glue to for a perfect fitting lid. If you glued to the wrong side, the fit may not be proper as both sides of the stiffener are not likely cut exactly the same. *This is very important!*

Lay the TOP STIFFENER aside...and return to the BOTTOM UNIT

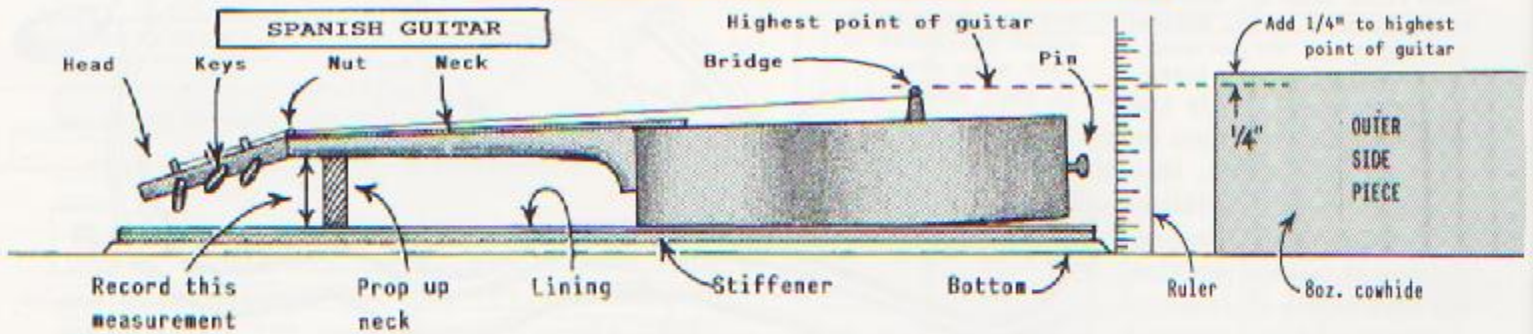


9 Now turn the bottom leather up and gouge a sewing channel $\frac{3}{16}$ " from the edge all around the bottom. The masonite prevents the leather from touching the bench so a scrap of 8/9oz. leather can be used as suggested above to give support for gouging the channel. Move the leather as required. Or...hold the bottom edge over the edge of the bench (if it would be practical) to make gouge.



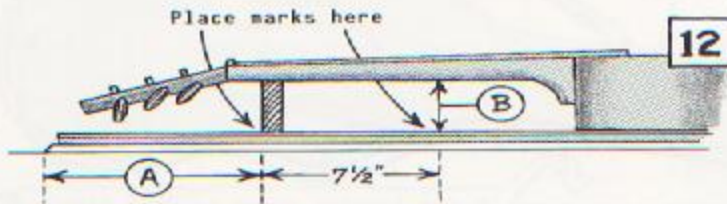
10 Turn the leather to the flesh side up and bevel for the miter joint, all around.

DETERMINING the DEPTH of the GUITAR CASE

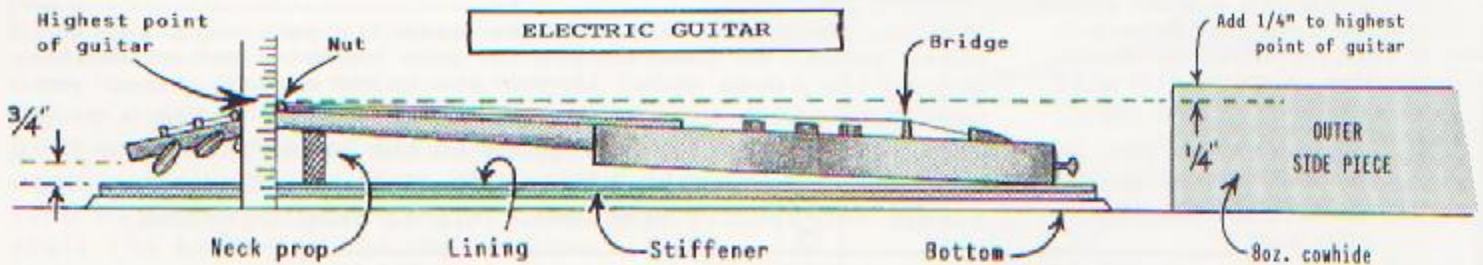


11 Lay the bottom assembly on your bench and position the guitar on it. Raise the neck and put a block of wood, or other material, under it so the head is raised about $3/4"$ above the lining leather. This insures clearance for the keys above the lining. With most Spanish guitars, the neck is

usually raised higher so the bottom of the guitar box lays flatter on the lining...as shown above. Now measure the highest point on the guitar; usually the bridge. Measure from the bench. Add about $1/4"$ to this, and you will have the height for the outer side pieces. Write down the neck prop height.

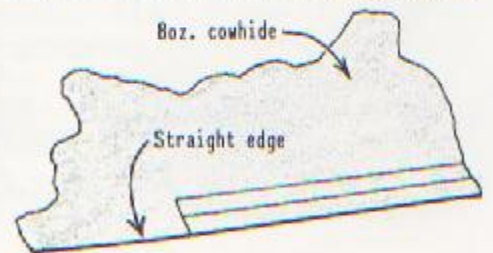
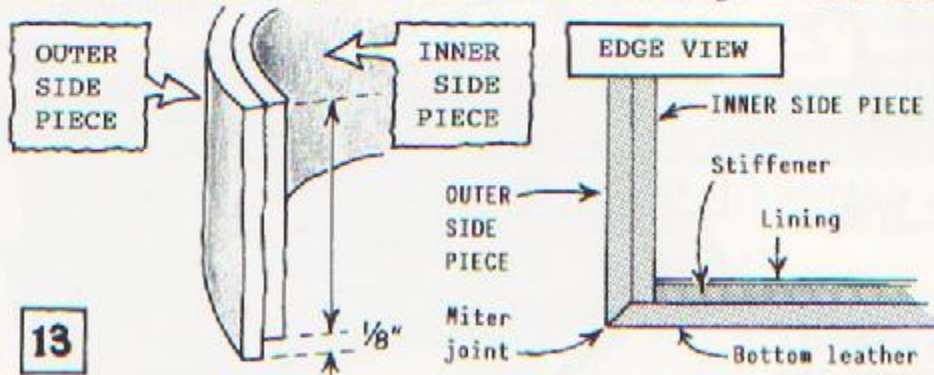


12 Locate the positions of the support blocks for the neck and the storage box. Measure from the end of the bottom (A) to $1\frac{1}{2}"$ behind the nut. Mark the lining here for the neck support. Also mark at (B) for storage box block. Also record the height (B) to be sure the block will not exceed this measurement.



Most Electric guitars have shallow boxes... resulting in the highest point of the guitar at the nut, after propping up the neck. You should have $3/4"$ clearance for the keys

at the head. You'll notice how this greatly reduces the height of the side piece, as is shown. Pay attention to measurement at (B). The sloping neck needs a shorter box block.

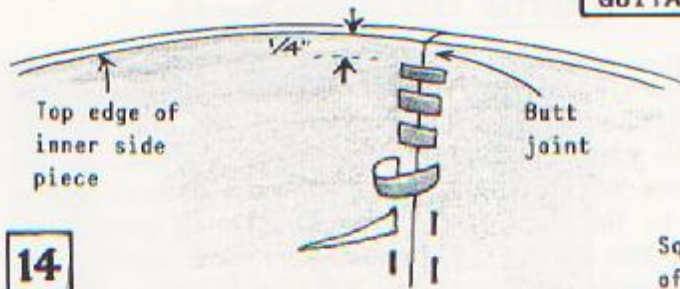


Cut the side pieces from the firmest part of the leather.

13 Cut the outer side pieces to the height arrived at in step 11. It would require over 8ft. to go around the case...so the pieces will have to be cut in two parts. If you've followed the notes in step 7, you will have center marks on the bottom leather. Measure

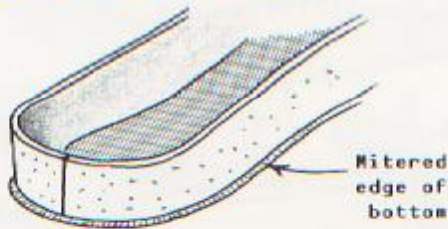
between these marks and add $1"$ to $2"$ to insure ample length. Cut the inner piece $1/8"$ narrower than the outer pieces, because the outer side pieces are mitered to fit at the bottom miter. The inner pieces fit against the stiffener (see edge view above).

GUITAR CASE - Continued



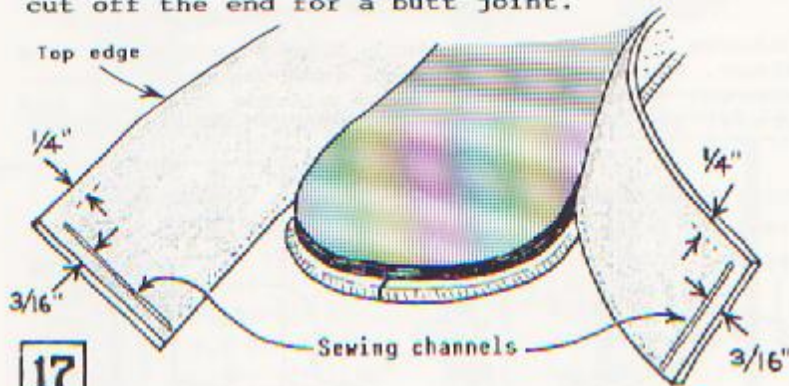
14

Begin assembly with the inner side pieces. Cut one end of each piece square. Butt together and sew or lace as illustrated above. Tap the seam flat with a hammer.



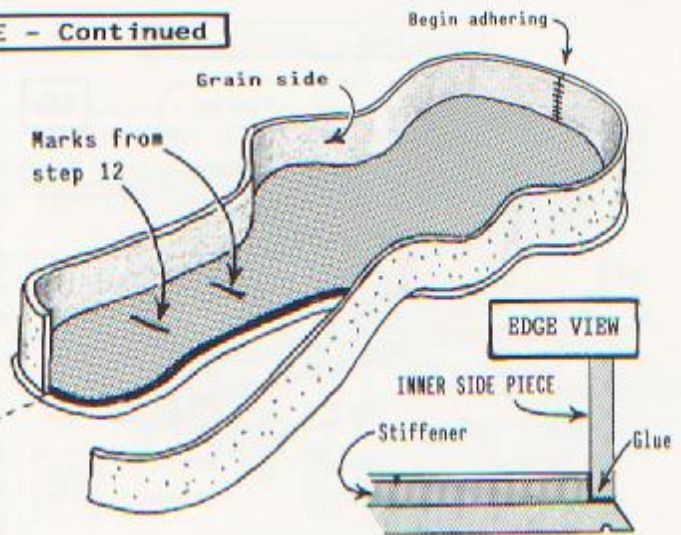
16

Bring the other side around and cut off the end for a butt joint.



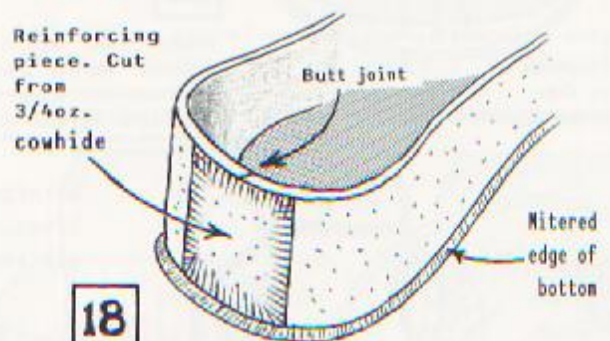
17

Now peel the leathers loose and fold out enough to gouge sewing channels on the ends as shown above. The gouges should end 1/4" from the top.



15

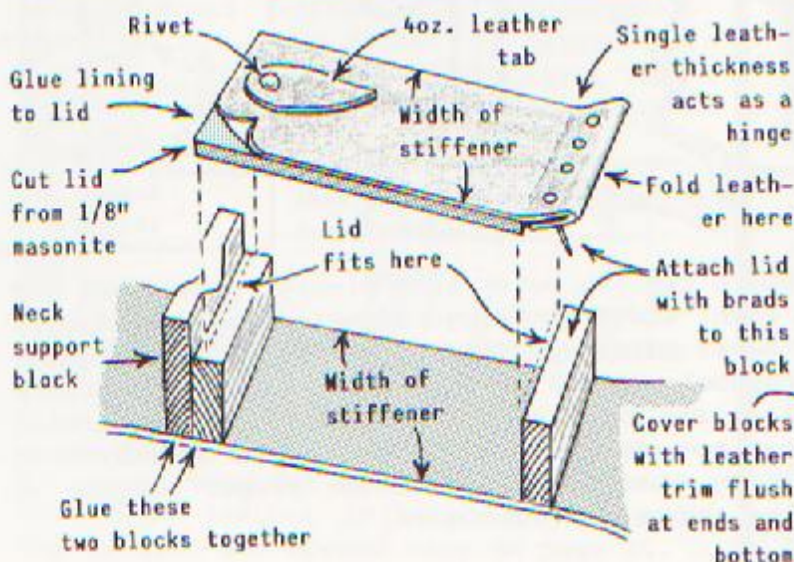
Apply contact cement to the bottom edges of the side pieces, the bottom leather and the edge of the stiffener as shown by the heavy black line in the sketch above. Apply with a small brush if necessary. Begin adhering at the center line. Press down against the bottom leather firmly, and tightly against the stiffener. Carefully follow the contours of the case adhering one side at a time. Trim the leather at the center line as illustrated above.



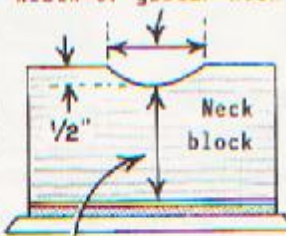
18

Re-apply glue to edges and butt joint and adhere as in step 16. Cut a reinforcing piece about 2" wide. Skive all edges to a feather. Glue in place with the top edges flush, as shown above.

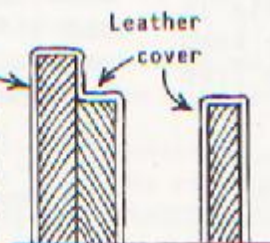
MAKING the STORAGE BOX

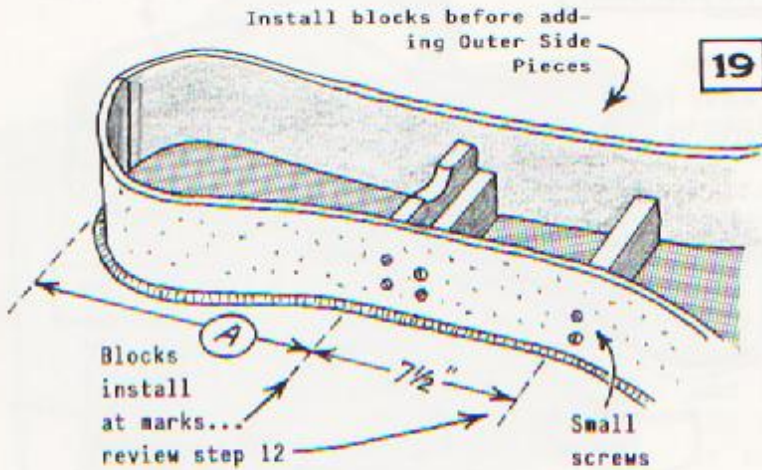


Width of guitar neck



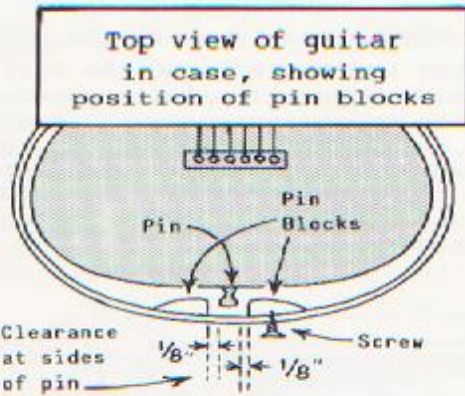
Cut the blocks from 3/4" pine or fir. Cut neck block 1/2" higher than measurement in step 11, then curve it down 1/2" for the guitar neck. Cut the other blocks shorter (3/8") than the curve in the neck block. Width of the blocks must be equal to the stiffener width, at point of contact. Observe all the notations at left.



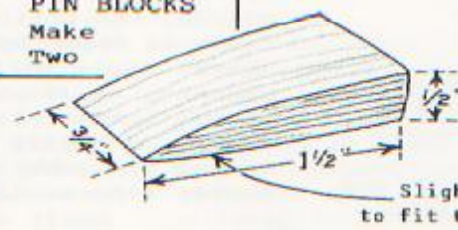


19

If you have followed previous instructions you will have marks on the stiffener lining, where the blocks will go. The width of the blocks must be flush with the stiffener edges...right at these marks. Set the blocks in place; check the fit. Be sure the lid will fit in properly. Adjust the marks if necessary. Now apply glue to the ends and bottoms of the blocks. Spread the side pieces out; set the blocks in place. Secure with screws into the blocks. Place the lid in position and anchor with small brads. This box not only strengthens the neck of the case but is also useful for storing the picks, guitar strings, amplifier cords, etc.

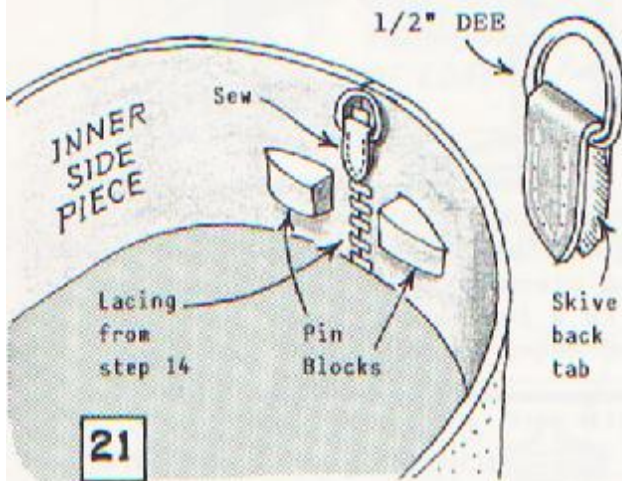


PIN BLOCKS
Make Two



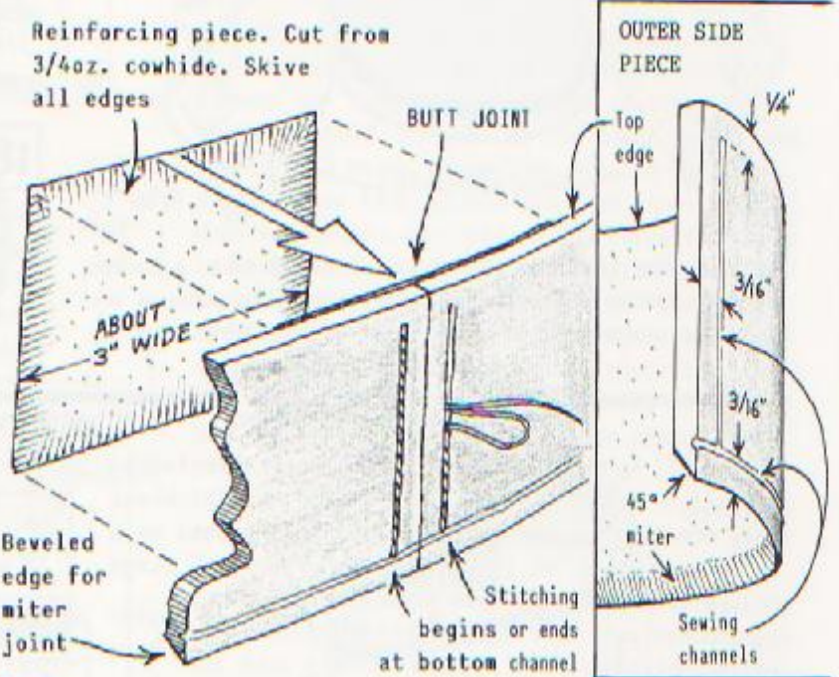
20

Make two wood blocks to the approximate dimensions above and cover with leather. Place guitar in the case to locate positions of the blocks. Remove guitar. Glue blocks in place and secure with screws. These blocks help to keep guitar secure.



21

From 2 1/2 oz. leather cut a strip 1/2" x 2 1/4". Prepare 1/2 for sewing and fold around a 1/2" dee; above. Glue this unit inside the case, centered on the seam, with the top of the dee almost at the top of the side piece. Sew in place, through the side pieces. This is for the retaining strap to keep the lid of the guitar case from falling back (see page 91).



22

Prepare the two outer side pieces. Square one end on each. Gouge a sewing channel along one edge... and 45° bevel this edge for the miter joint. Now gouge sewing channels at the squared ends. Glue the leathers together at the butt joint, then glue the reinforcing piece in place. Sew the leathers together as indicated above. Study the illustrations for proper gouging of the sewing channels. (continued)

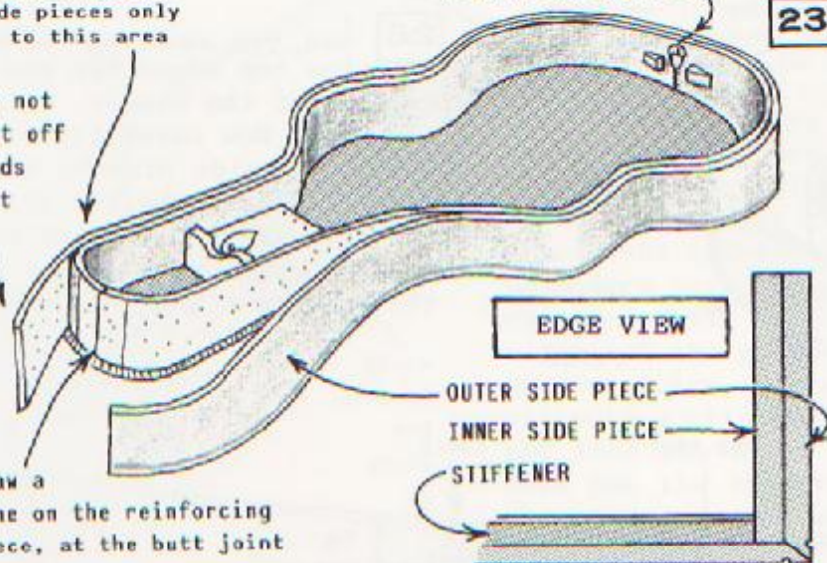
Adhere the outer side pieces only up to this area

Begin adhering here

23

Do not cut off ends yet

Draw a line on the reinforcing piece, at the butt joint



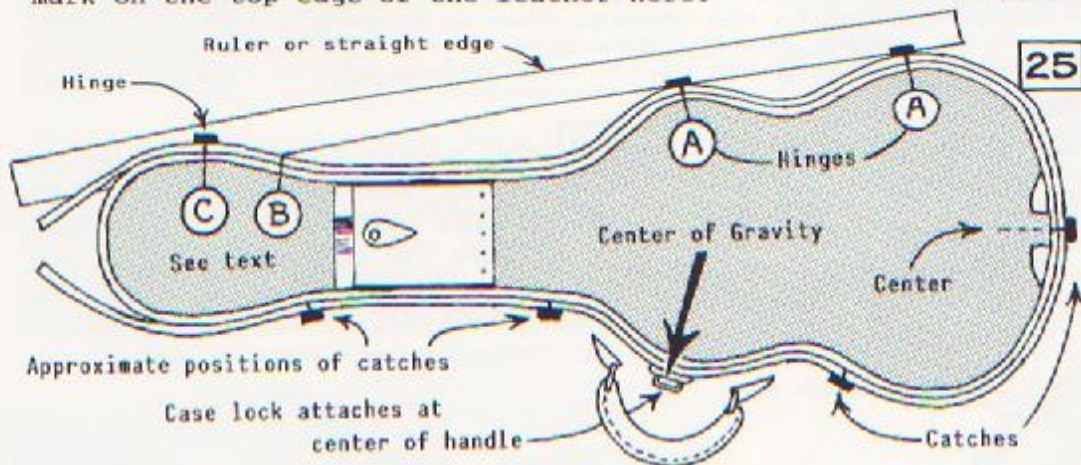
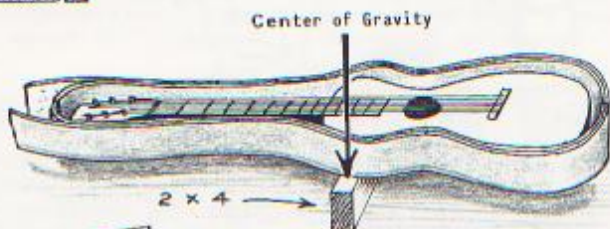
The NEXT STEP: Fit the outer pieces around the inner ones so we can determine the location of the handle, lock, catches, hinges. Apply rubber cement to the flesh sides sparingly except at the curved areas, so they can be peeled apart after fitting, as the hardware fastens only to the outer piece.

Begin fitting at the end, as shown. If your cutting has been accurate, the top edges will be even, and the miter joint will fit properly. Fit each side carefully and push firmly in at all of the curves.

24

LOCATING the CENTER OF GRAVITY

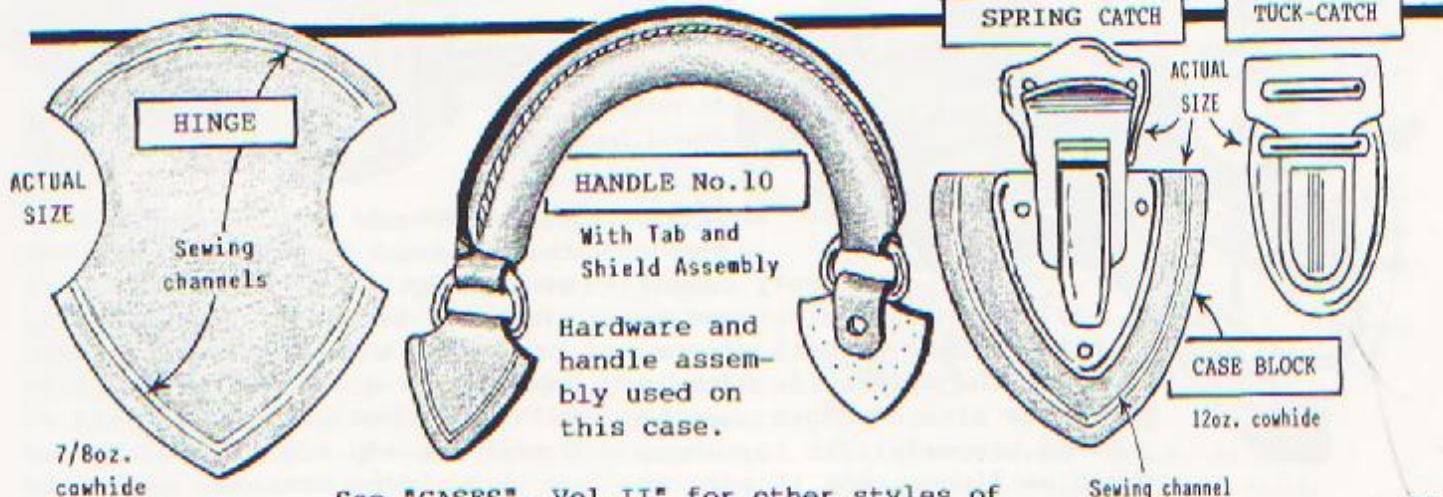
We must now locate the center of gravity to put the handle in its proper place. The handle will be centered here. Place the guitar in the case and put it on the edge of a board (right) until it balances. Put a mark on the top edge of the leather here.



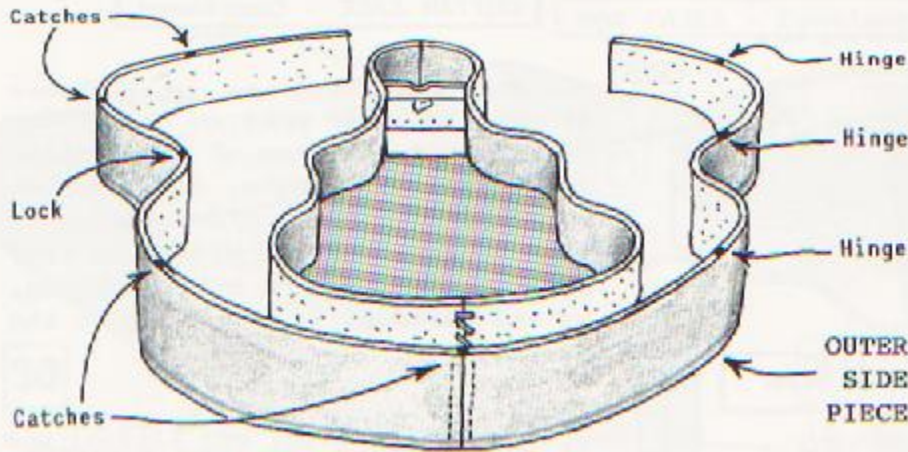
25

To locate the hinge positions, put a ruler on the high points (A). A hinge cannot be put where ruler touches at (B). It could not function properly due to the bulge ahead of it. Therefore place the hinge at (C). This may be anywhere from 4" to 6", from the end of the case. This won't be on line with the center hinge, but operable with leather hinges.

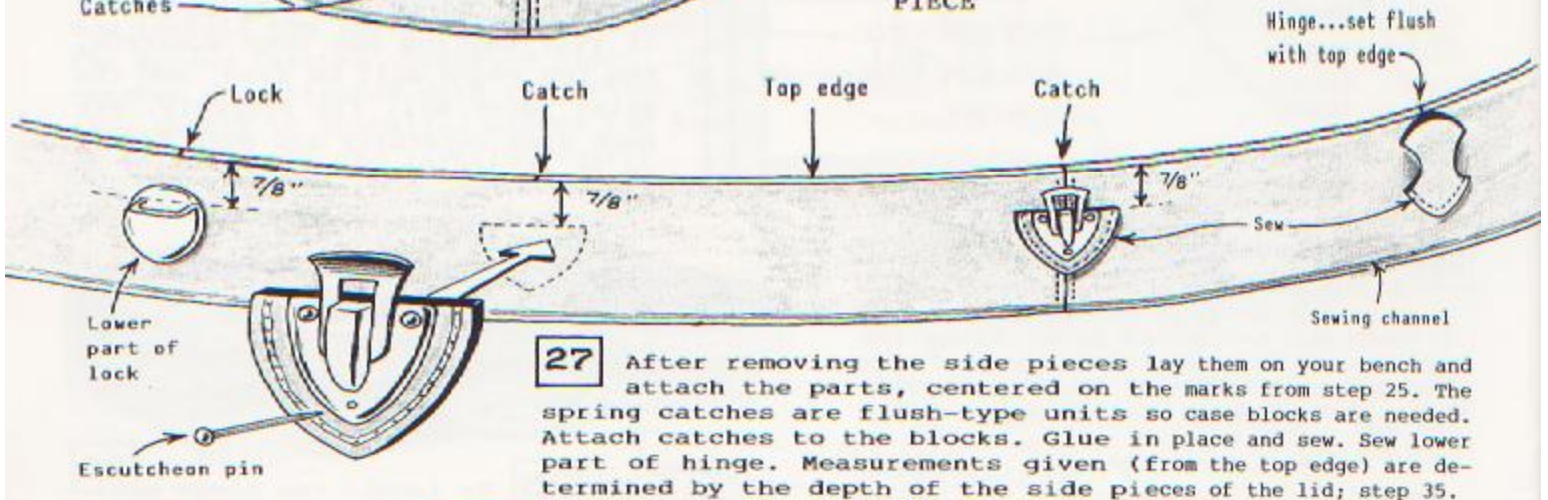
Mark positions of CATCHES, LOCK, HINGES, on edge of leather



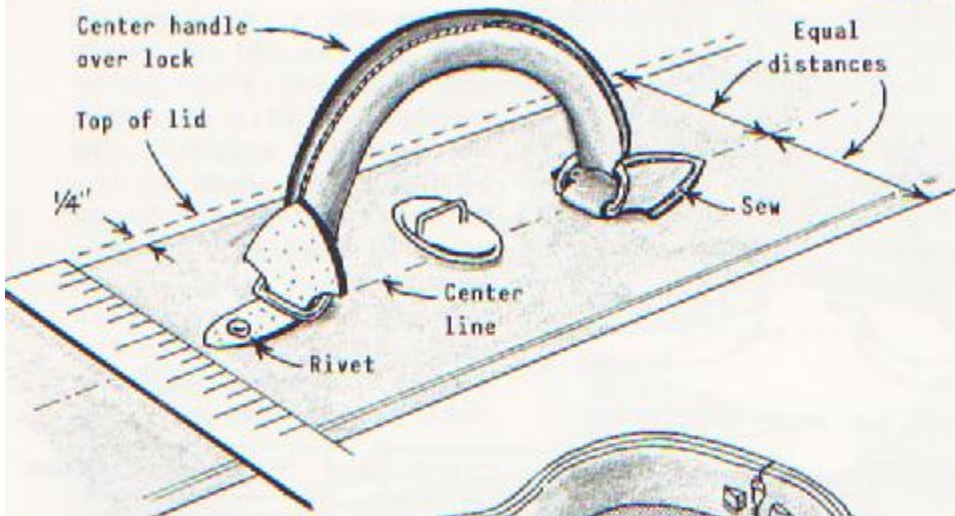
See "CASES", Vol. II for other styles of catches and instructions for installing.



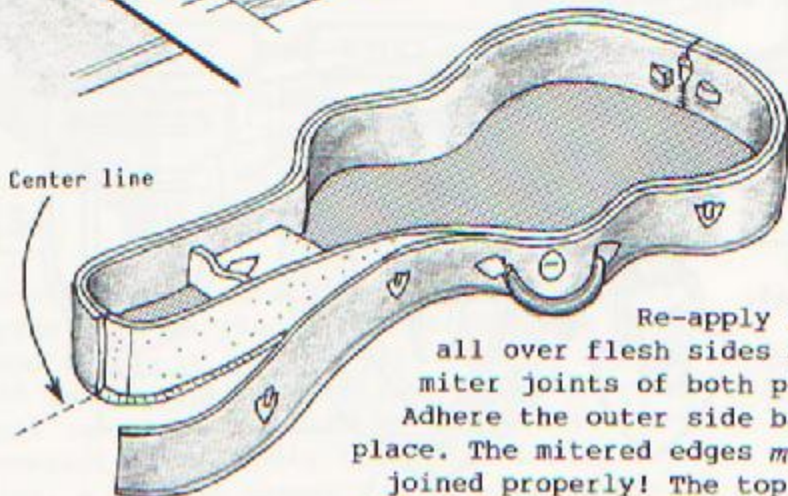
26 Did you remember to mark the top edges for the locations of the hinges, catches and lock? Now carefully remove the outer side pieces. Loosen them from the adhesion and try not to loosen the glued edges of the inner side pieces from the stiffener and the bottom.



27 After removing the side pieces lay them on your bench and attach the parts, centered on the marks from step 25. The spring catches are flush-type units so case blocks are needed. Attach catches to the blocks. Glue in place and sew. Sew lower part of hinge. Measurements given (from the top edge) are determined by the depth of the side pieces of the lid; step 35.

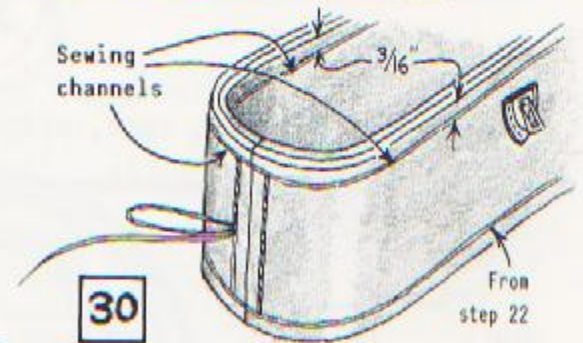


28 The handle is installed on the center line. This is the width of the side piece, plus 1/4" allowance to include the thickness of the top. Attach the handle as shown. See page 7 of "CASES, Vol. I" for many patterns and installation instructions.



29

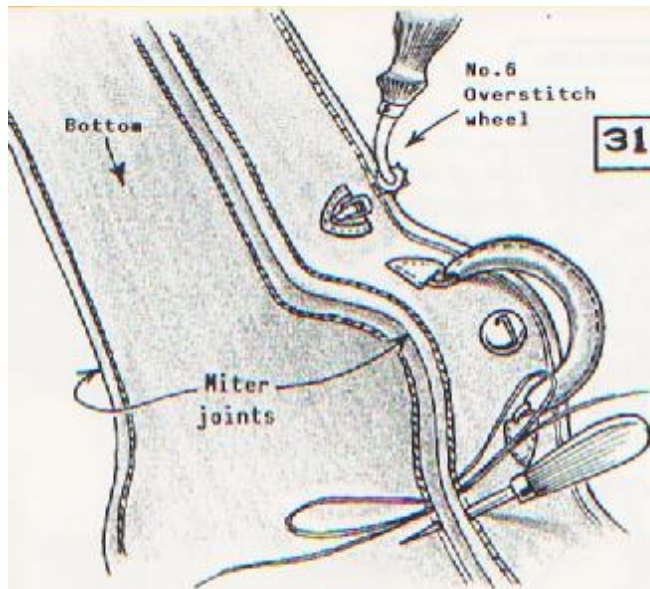
Re-apply cement all over flesh sides and to miter joints of both pieces. Adhere the outer side back in place. The mitered edges *must* be joined properly! The top edges should be flush...but if not, we will level them...see step 30.



30

Trim the ends to butt on the center line and gouge sewing grooves as in step 17. Re-glue the ends in place. If top edges are not even, level them with a piece of broken glass. Now gouge sewing channels on the inside and outside, all around the top edges. Sew the end as shown. The stitches must come out in the grooves...inside case.

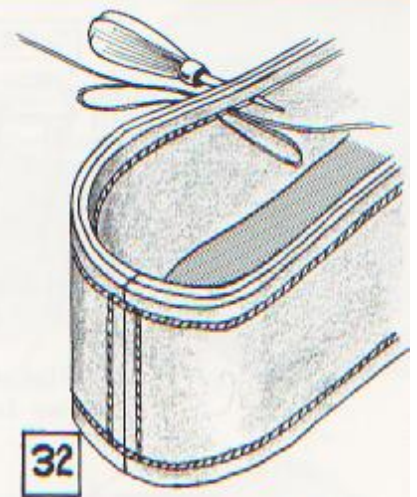
GUITAR CASE - Continued



31

Moisten side piece channels and "wheel". It is not necessary to mark in the bottom channels...as sewing practice insures even stitches. Sew miter joints first. Then round with a large Edge Beveler and burnish.

If you are unsure of how to sew the miter joint, review "HAND SEWING" for this and other phases of hand sewing leather.

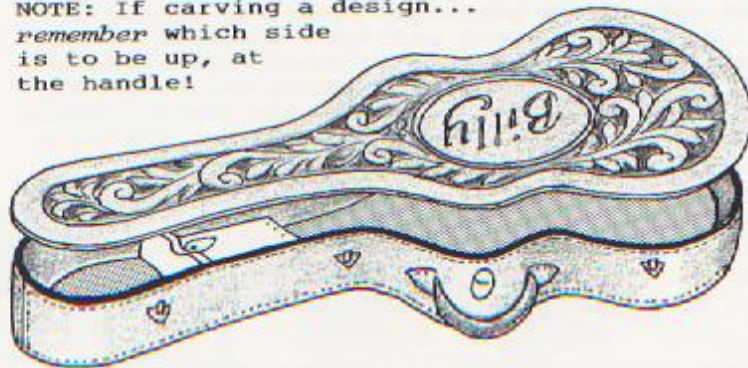


32

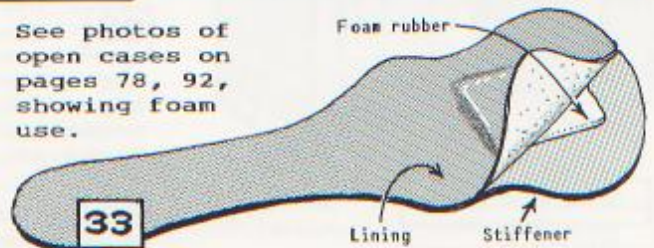
Now sew the top edge, all around the case; burnish.

MAKING the TOP

NOTE: If carving a design... remember which side is to be up, at the handle!



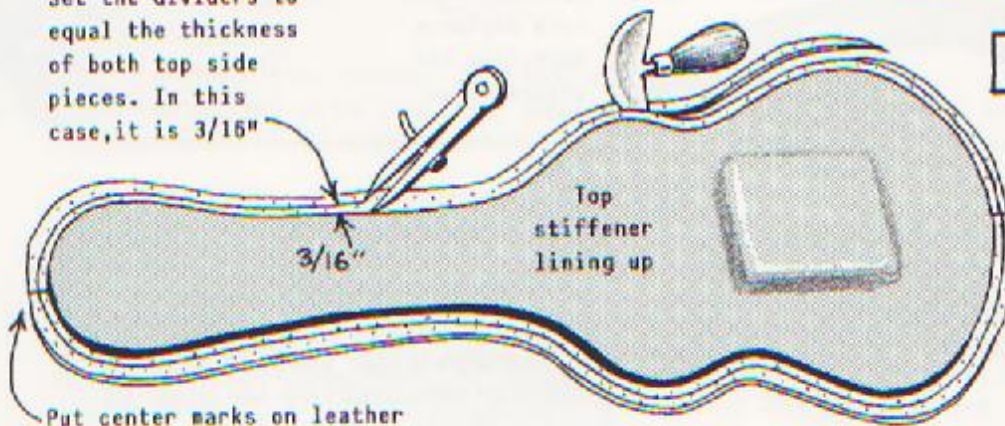
See photos of open cases on pages 78, 92, showing foam rubber use.



33

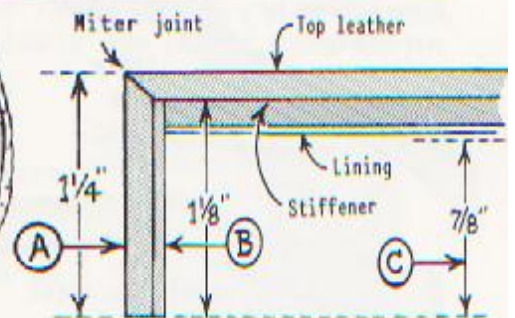
Now glue a lining to the top stiffener as in step 6. Foam rubber can be glued between, to cushion the bridge and/or electric controls of the guitar. Do you remember which side of the stiffener to glue the lining? If not, review step 8. *It is important for proper fit!*

Set the dividers to equal the thickness of both top side pieces. In this case, it is 3/16"



34 Now cut the top leather from 8oz. cowhide exactly as instructed in step 5. After carving your design follow identical instructions as in step 7 to trim the leather to size. In this instance the side piece leathers are cut from 8oz. & 4oz. cowhide. These combined equals 12oz. which is 3/16" in thickness. Trim at this dimension. Now follow steps 9 & 10 for the sewing channel and beveling the edge for the miter. Since the inside top side piece is 4oz. leather (1/16"), the miter bevel will come to within 1/16" of the stiffener edge. Study the edge view at right.

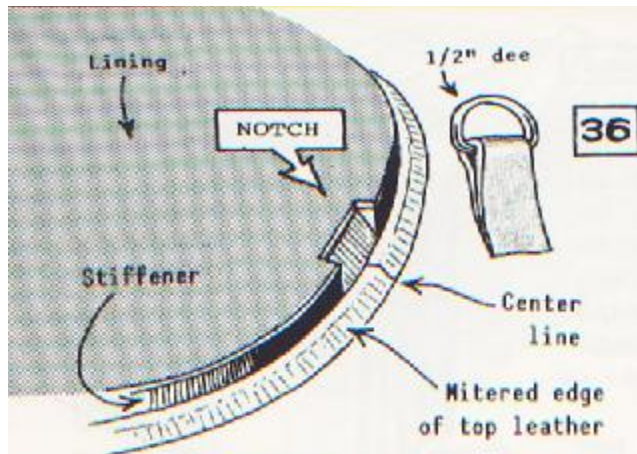
EDGE VIEW BELOW - Actual Size



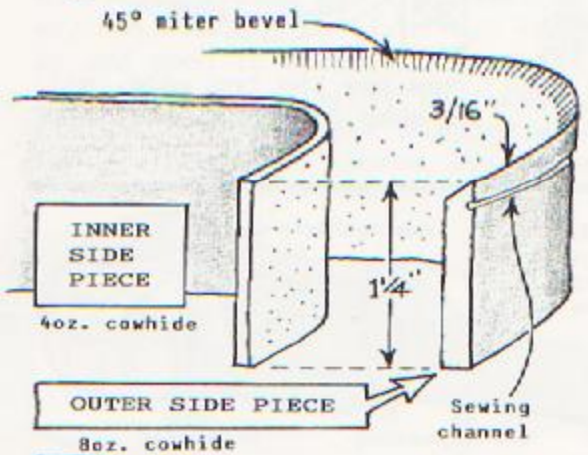
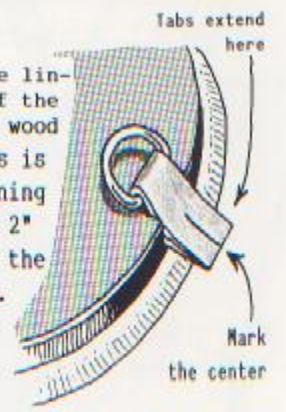
35

(A) Outer side pieces for the lid. (B) Inner pieces are set 1/8" shorter than (A) to allow for the thickness of the top leather. (C) Shows how we arrived at the position of the catches in step 26. You'll notice a slight clearance just under the lining leather which is just about right.

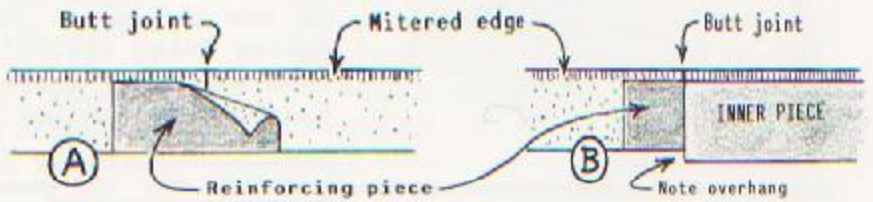
GUITAR CASE - Continued



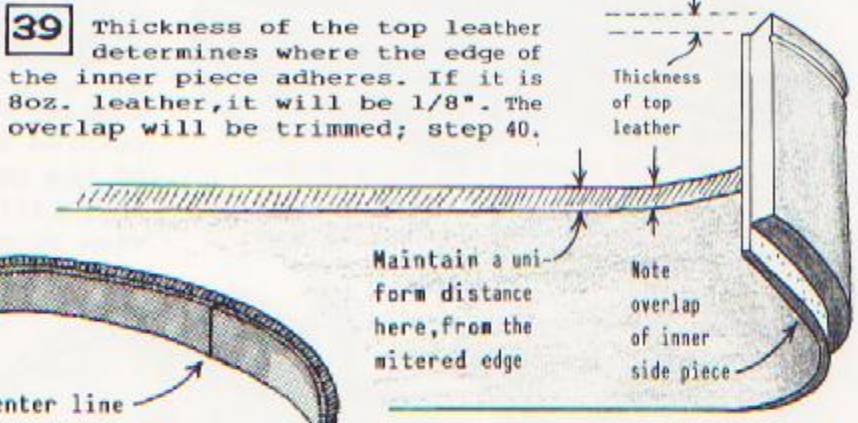
36 Now we must cut a notch out of the lining and stiffener at the center of the large end as shown at left. Use a wood chisel or sharp knife. This recess is for the dee assembly of the retaining strap (page 91). Cut a strip $\frac{1}{2} \times 2$ " of $2\frac{1}{2}$ /3oz. leather to fold around the dee. Skive all edges to a feather. Glue this assembly in the notch (right). This unit will be sewn in with miter joint stitches.



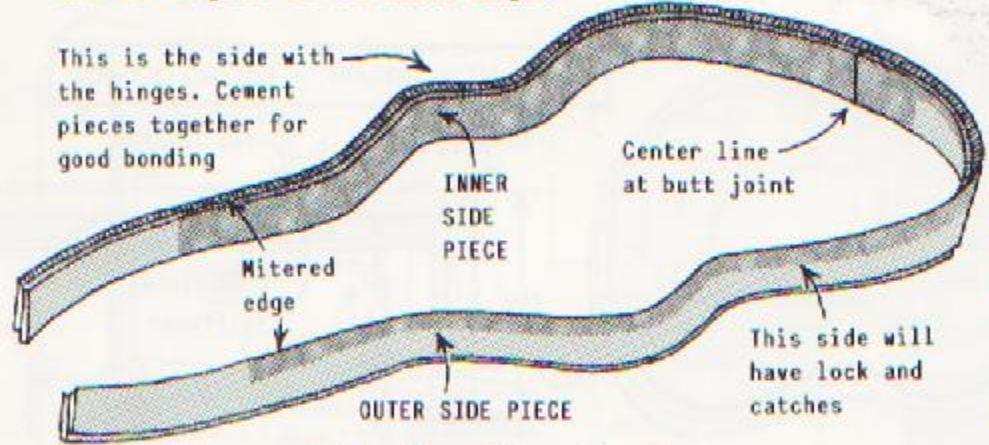
37 Cut the side pieces for the top from the leathers suggested above. Cut both inner and outer pieces $1\frac{1}{4}$ " wide. Gouge the sewing channel in outer piece... and 45 degree bevel that edge.



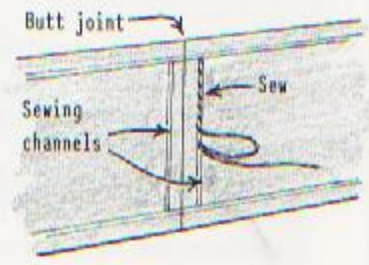
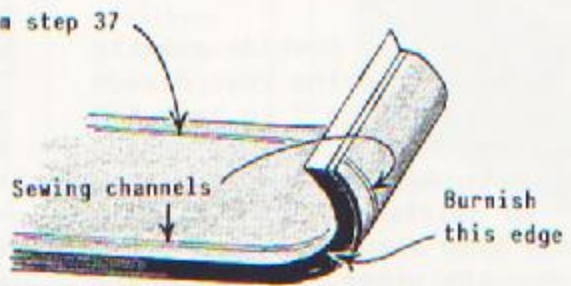
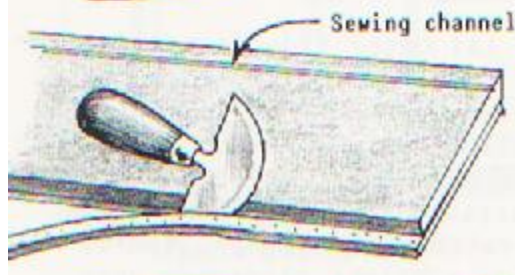
38 Lay the outer side pieces, flesh side up, on your bench. Square each end and butt together. Cement a reinforcing piece over the butt joint (A). (B) Square the ends of the inner side pieces. They will also butt together at the joint and cement to the outer pieces right at the mitered edge. See next step for details.



39 Thickness of the top leather determines where the edge of the inner piece adheres. If it is 8oz. leather, it will be $1/8$ ". The overlap will be trimmed; step 40.



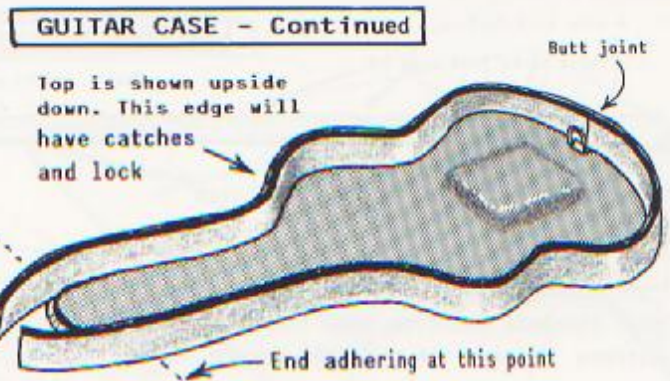
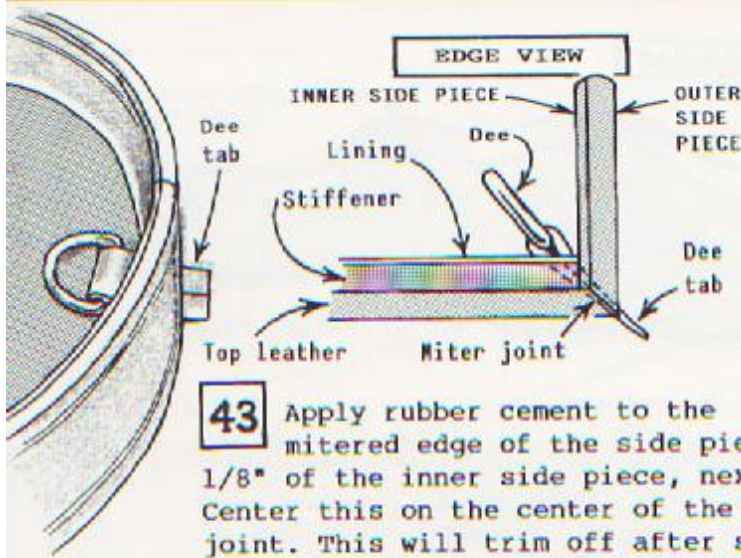
SPECIAL CEMENTING INSTRUCTIONS: The dark shading (left) indicates where to cement for good bonding. Use rubber cement sparingly (light shading) as the leathers must be pulled apart to install the catch parts after fitting in step 43.



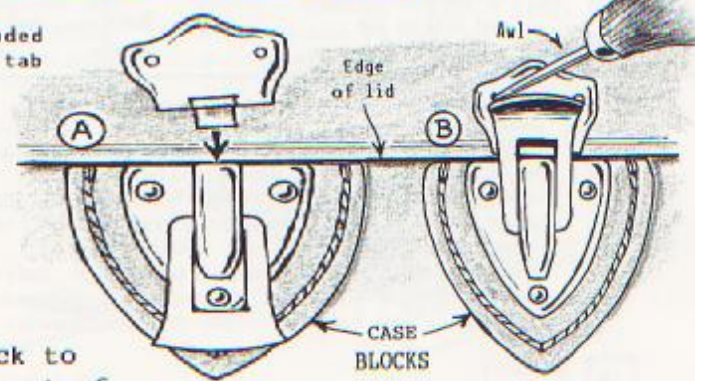
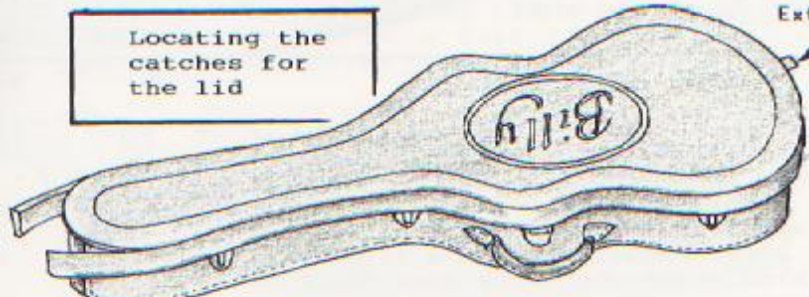
40 Trim off the excess inner side piece.

41 Now gouge a sewing channel on each side of the trimmed edge. Burnish this edge. The catches prevent burnishing later.

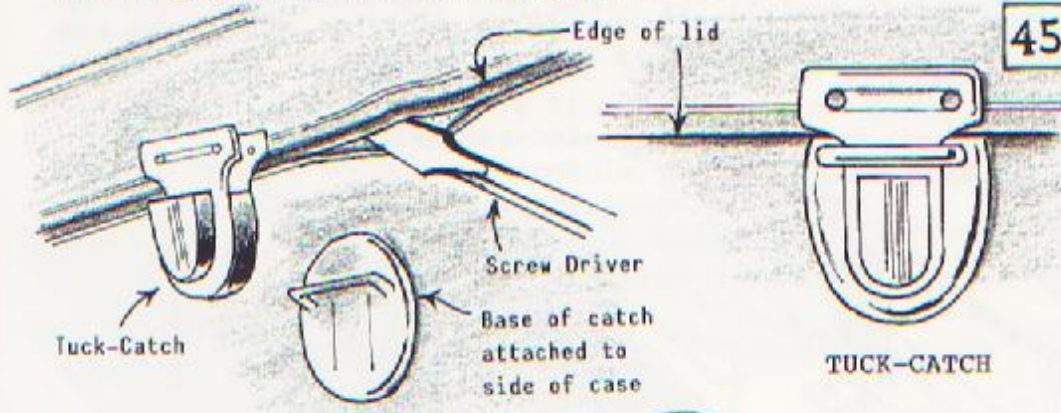
42 Gouge channels at butt joint, and sew.



43 Apply rubber cement to the mitered edge of the side piece and the top. Also cement edge of stiffener and 1/8" of the inner side piece, next to the miter. Begin adhering at the butt joint. Center this on the center of the dee tab. Notice that the tab extends at the miter joint. This will trim off after sewing. Now carefully continue adhering around the top, to the point shown above. Be sure mitered edges fit properly.

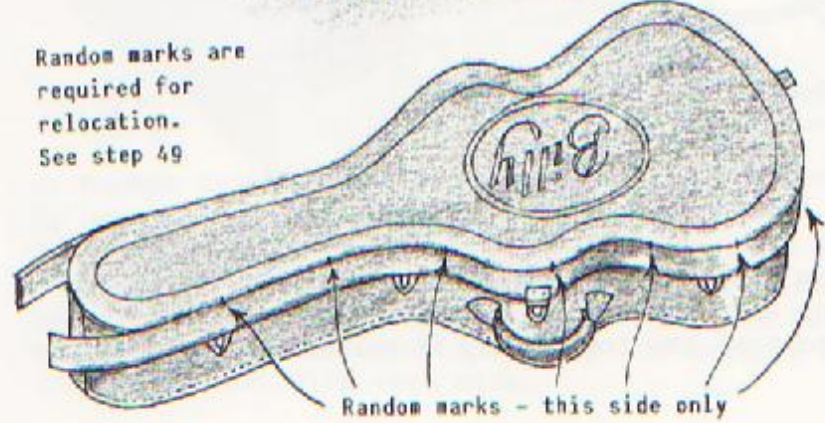


44 Carefully fit the lid over the case. Check to see that it is down all around. The top part of the hinges should be outside of the side piece of the lid. The edge of the lid should set on top of each case block (see illustration above). Open the catch spring (A) and fit the top part in place. (B) Close the spring and mark positions of the escutcheon pins with an awl. Repeat with all four catches.



45 Since the top of the tuck-catch will only accommodate the 8oz. thickness of the outer side piece, leathers must be pried apart here. Lift the lid a bit to gain access and pry the leathers loose as shown at left.

Push the catch up on outer lid leather. The inner part goes between the leathers. Adjust it so when you close the lid the catch properly engages the base. Mark the hole positions with an awl, as shown in step 44.

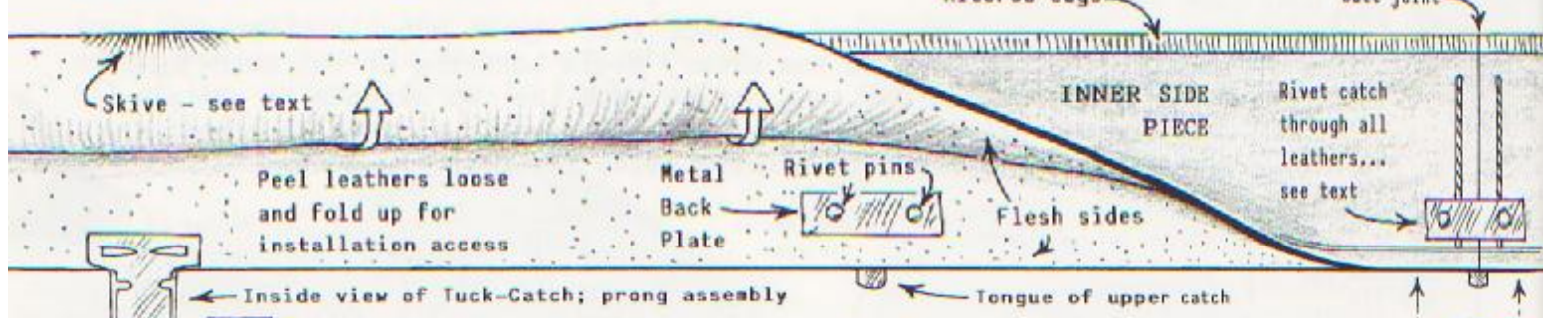


46 With the lid in place, now put random marks on the mitered edge, about every 6". Be sure the top and sides receive a bit of the mark, at the miter.

GUITAR CASE - Continued



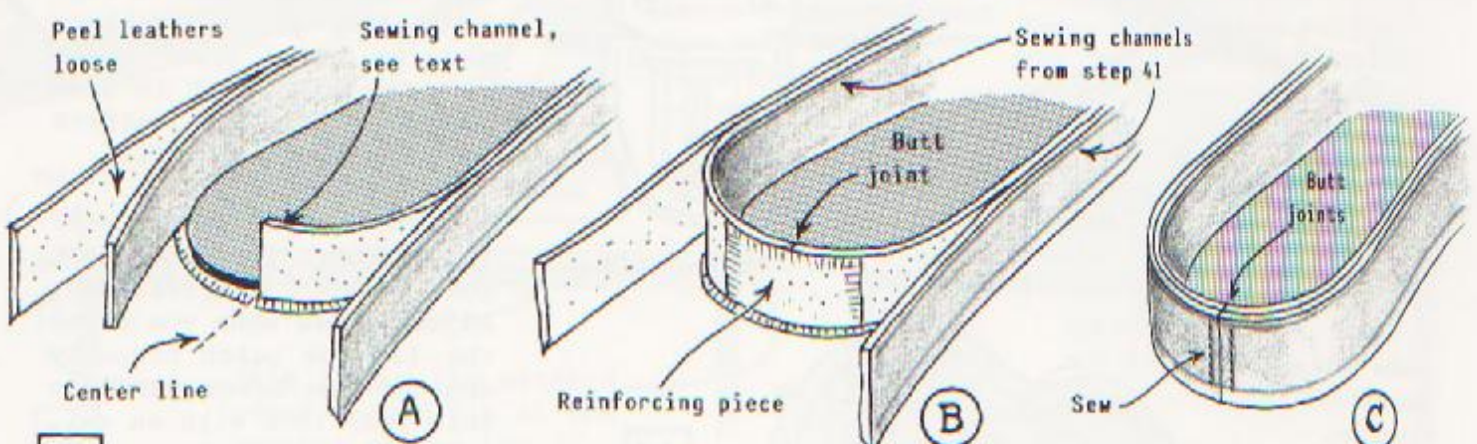
47 Now remove the lid and peel the miter joint loose along the catch edge and past the butt joint so you can install the catches. Observe the sketch above.



48 Turn the loosened side piece so the inner side is up. Lay on the bench and peel the inner piece loose so it can fold out of the way, as shown above for installing the hardware. *DO NOT peel it all loose; only about 1/2 way!* Review our cementing instructions on page 88. Install the parts as indicated. The catch (at butt joint) rivets through all leathers, since they have already been sewn together here. After securing, glue a light leather over the back-plate; skive all edges. Also skive the inner side piece where it covers the top of the Tuck-Catch. It reduces bulk; closure is easier.

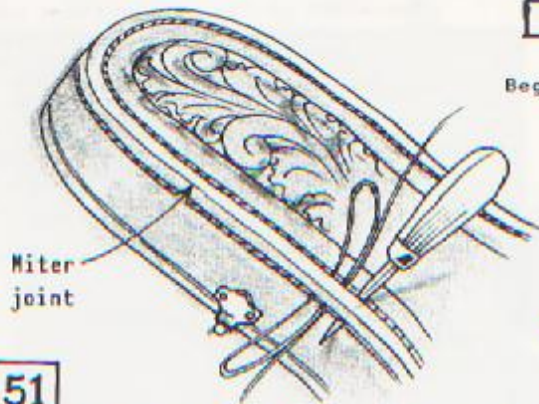
49 Re-apply rubber cement for final bonding to flesh sides, and carefully fold the inner side piece back to its original position. Keep the burnished edges as even as possible. Re-cement the mitered edges. Adhere the side back to the top in its previous position in step 43. When adhering...

the random marks (in step 46) must again be aligned so the catches will be properly positioned. Put the lid back on the case and check to see if all of the catches will engage. If not, peel loose and make the proper adjustments by adhering again. The random marks must be aligned.



50 Now, peel the outer and inner leathers apart (A) and bring the inner pieces around to cut off at the center line (see steps 15 & 16). Gouge sewing channels at the ends (same as step 17). (B) After gluing the leathers in place...glue a reinforcing piece over the butt joint as shown above. (C) Cut the outer side pieces to butt against each other. Gouge sewing channels and glue in place. Sew through all leathers. Stitches should come out in the channels inside. Re-burnish the top edges, if necessary. (continued)

GUITAR CASE - Continued



Miter joint

51

Check the side pieces to see if all adhesions are secure. Now sew at the mitered edge. Use the No.6 Over-stitch wheel. After sewing; burnish.

Begin here with a knotted thread

Begin here with a new thread

Backstitch two; cut off threads

SEWING DIRECTION

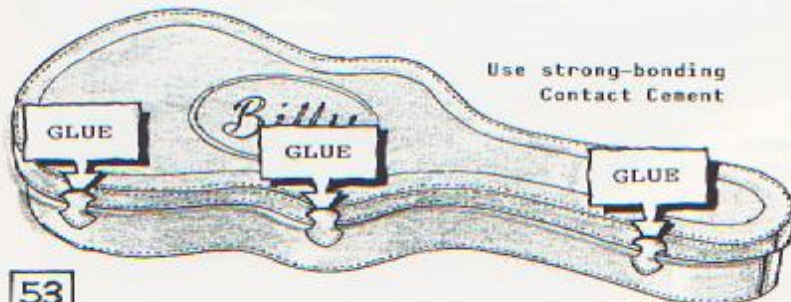
Backstitch two holes

Start with a knotted thread here. Backstitch one hole...continue sewing to next catch

52

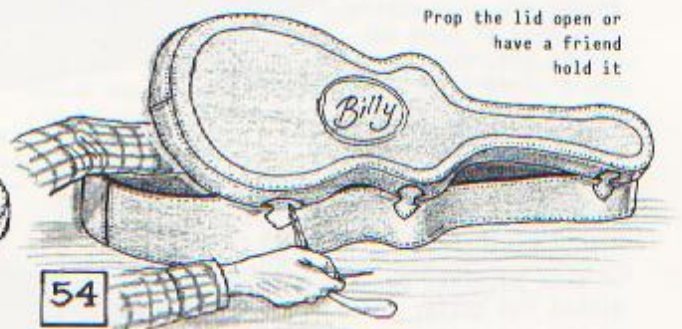
Now sew the edge of the side pieces; above. The stitching will have to end between the catches. For those unfamiliar with proper sewing techniques, study the pages of "HAND SEWING".

APPLY YOUR FAVORITE LEATHER FINISH TO THE LID AND THE CASE BEFORE THE FINAL ASSEMBLY.



53

Fit the top back on the case and fasten the lock and catches. Turn the case to the hinge side and glue the top of the hinges to the lid. The glue will bond better if you skuff off the finish and roughen the leather.



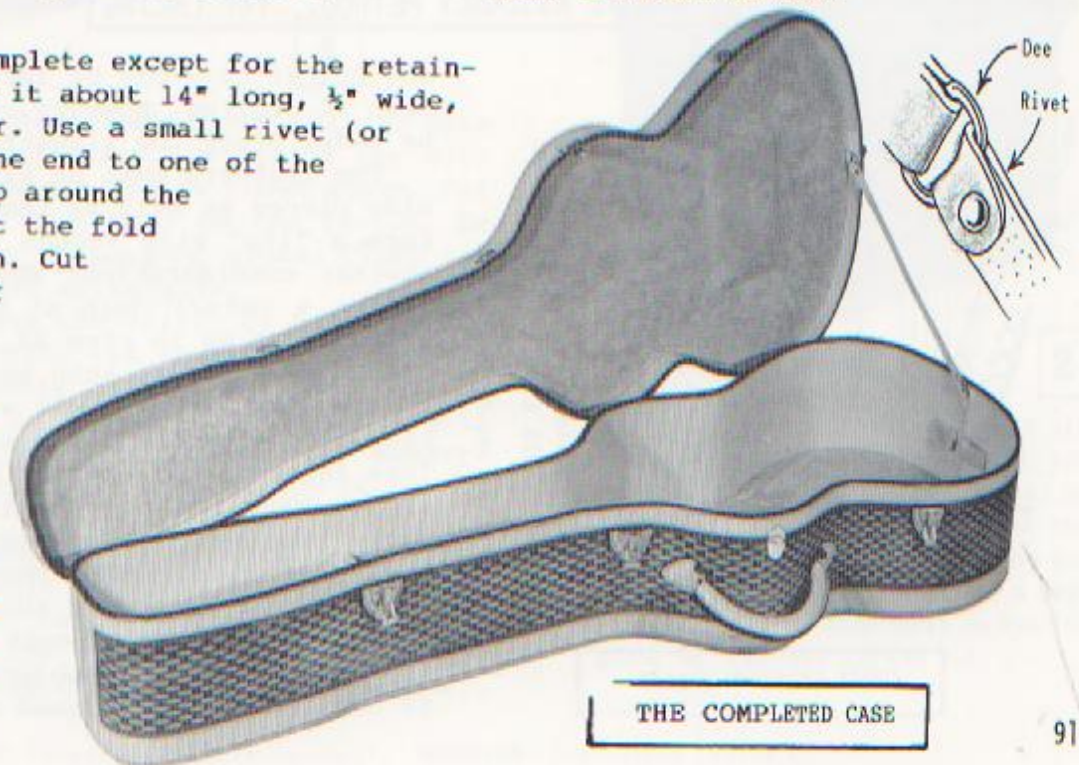
54

To sew the hinges to the lid, you'll have to open it so one arm can reach inside to handle the needles. It will be uncomfortable...but persevere...there are not too many stitches to take.

55

The case is complete except for the retaining strap. Cut it about 14" long, $\frac{1}{2}$ " wide, from $2\frac{2}{3}$ oz. leather. Use a small rivet (or eyelet) to attach one end to one of the dees. Fold the strap around the other dee and adjust the fold to hold the lid open. Cut it off at the proper length and rivet to the dee.

The satisfaction of accomplishing this case will outweigh the expense of much material and/or the feeling of any lost time. It will bring you much praise and admiration and will last a life-time.



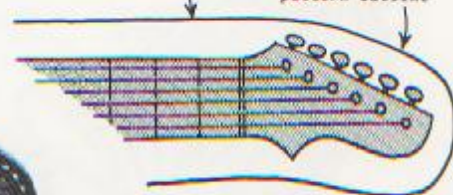
THE COMPLETED CASE

GUITAR CASE - Continued

Handle No.10

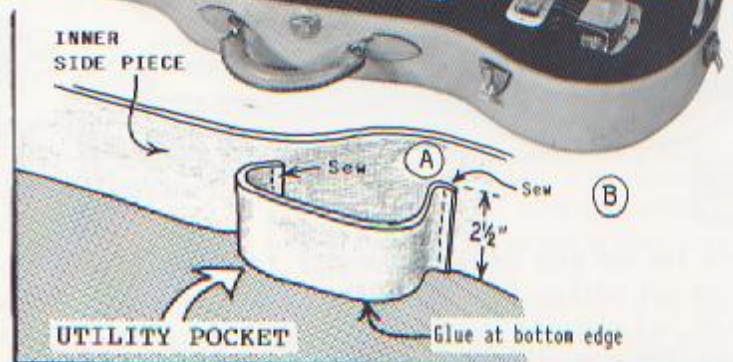
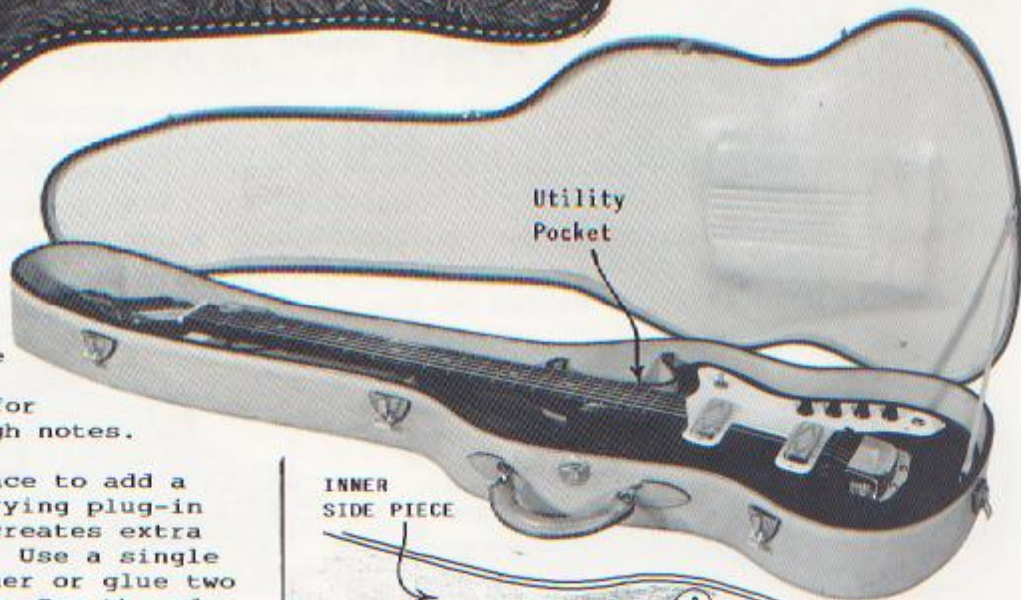


The width of the neck pattern can vary to make a free-flowing pattern outline

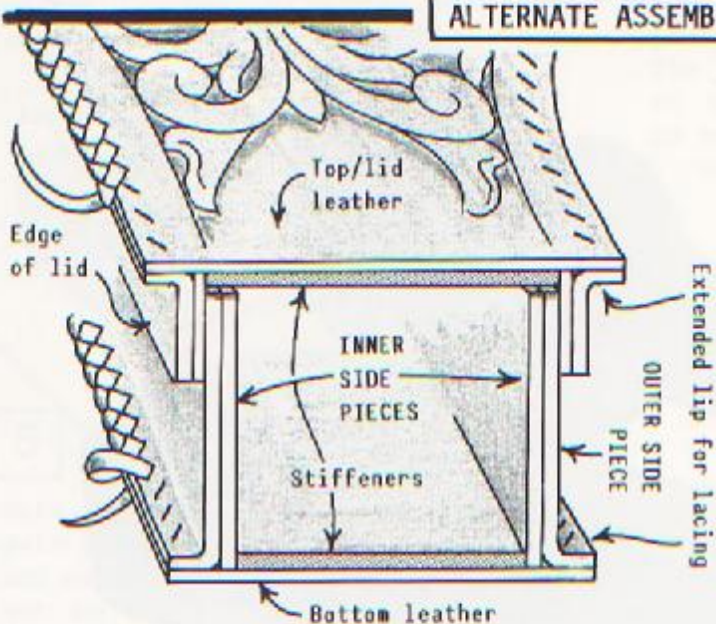


Some Electric guitars have an off-angle head with the tuning keys on one side. The body shapes are also extreme with many of them cut out at the upper neck for easier fingering of high notes.

This makes an ideal place to add a Utility Pocket for carrying plug-in cords, etc. This also creates extra support for the guitar. Use a single thickness of 8oz. leather or glue two pieces of 4oz. together. Sew the edge at top; burnish. Cut the length to fit within the guitar curve. Sew each end to the side piece. First sew edge (A). Fold around; sew edge (B). Moisten the leather first, so it will retain its shape when dry. Glue at the bottom.



ALTERNATE ASSEMBLY METHOD...for LACING



CROSS-SECTION VIEW

The guitar case can be laced rather than hand sewn if desired. However, certain changes must be made. Study the illustration at left.

The leathers must be extended at the outer side pieces as well as the top and bottom, to form a "lip" wide enough to take the lacing. Another consideration: Where the side pieces (inner & outer) join at the top...this edge can be sewn as in step 32, or laced. If laced then you must take into account the thickness of the laced edge. This will alter the position of the catches. You will also have problems installing the upper part of the catches if you want to lace the lid pieces edge. The Back-Plate and riveted pins will be inside of the inner side piece. These must be covered.

We do not recommend this type of assembly, because of the extra cost and time in making the case. Lacing is subject to much wear, and is not as durable as hand sewing.

GOLF BAG

Many golf bags are made with pre-formed top rings, plastic bottoms and vertical support rods to keep the bag upright as most bags are made from very light material. For the general craftsman, the items above may be difficult for them to obtain.

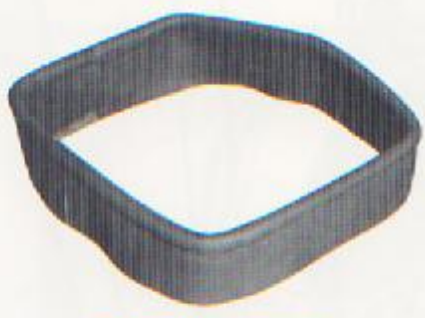
Our bag does not feature any of these items. We must sacrifice a bit of weight with this bag...by using heavier leather but most golfers use carts now to transport their bags over the course.

The construction of this bag is easier...as the materials are readily available. Your only problem may be the iron rods that form the frame for the top and bottom. However, these can easily be made by any machine or welding shop. Give them the PATTERNS that we offer here. The bag holds fourteen clubs, in a special designed container top.

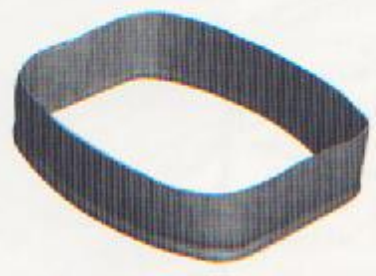


Carving Design*

Be sure you read and understand all of the instructions before cutting any materials!

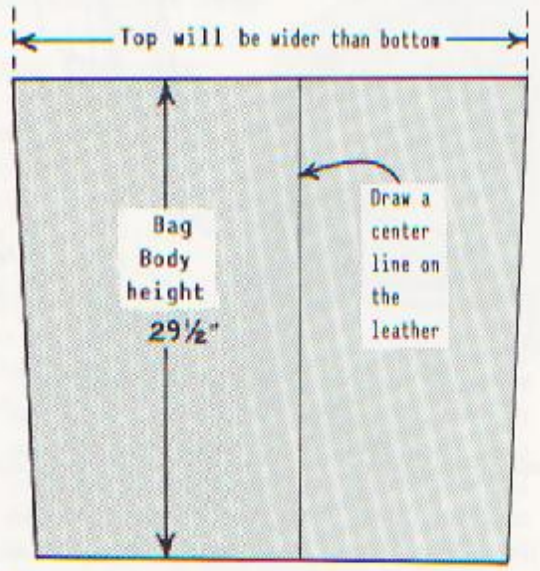


TOP FRAME UNIT



BOTTOM FRAME UNIT

The first step is to make the top and bottom Frame Units...covering the rods with leather. Full size patterns for top and bottom framing rods are given on pages 94 & 95, with instructions for covering them. The patterns for the body of the bag, collar, etc., are determined from these frame unit sizes. Your frames will probably vary in exact size from ours, so you will have to make all measurements from yours. We instruct you how. The measurements we give are for the bag presented here.



Cut the body of the bag from 9/10oz. cowhide. The height (for all bags) is cut to the dimension shown above. The width will vary according to each individual Frame Size. Carefully study all following instructions.

*OAK LEAF: "Inverted Leather Carving".
 EAGLES: "Craftaid" No.6536. "Classic Patterns"- Vol.I "Classic Patterns"- Vol.III.

TOP FRAME
Actual Size

Join and weld

Center line

1/4" IRON ROD

FRONT

(A)

Draw a complete pattern on heavy paper. Bend the rod to fit the pattern, and weld. Bend to fit the side view at right.

(B)

Cut a piece of 4/5oz. cowhide about 32" long and 4 1/2" wide. We used burgundy latigo. Other leathers can be used. Skive edges as indicated. After wetting leather, fold it around the rod as shown at right. The rod should be in the center of the leather. Trim the ends to overlap 1/2". The splice is at the weld (front) of rod. Apply glue to the insides and liberally around the rod. While it is still tacky, begin adhering the sides together.

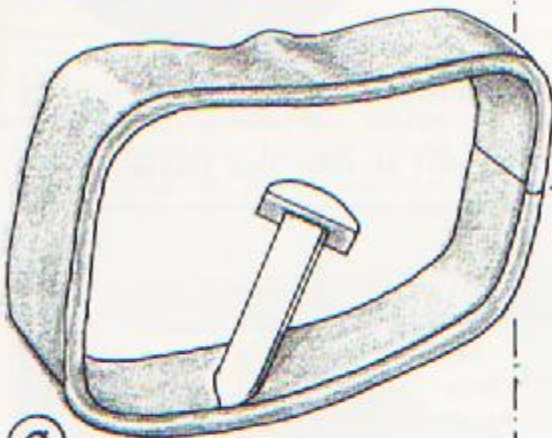
Skive edges

Spread leathers to apply glue

Overlap ends 1/2"

Skive these edges to a feather

Side view showing bend in frame



(C)

Now work the leather up tight against the rod with a bone folder, first on the inside then on the outside so the leathers are centered on the rod. Because of the bend in the frame (shown in side view) the leather will buckle in or out at this area. This is taken care of in step (D).

Splice

Bend in frame

Cut out

Cut out



(D)

Cut a section out at the buckled area as shown in the illustration above. See photo of the finished unit on page 93.

Center line

BACK

GOLF BAG - Continued

**BOTTOM FRAME
Actual Size**

Join and weld

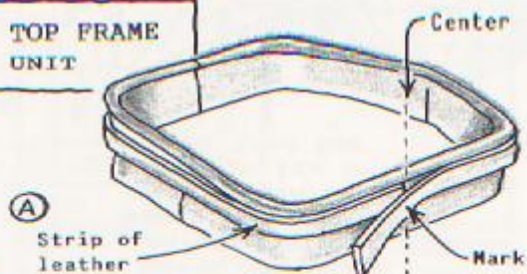
Center line

1/4" IRON ROD

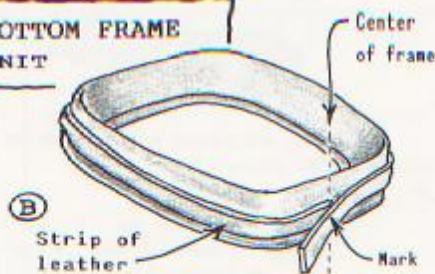
Bend the rod to the shape of this pattern, and weld. There are no bends in the rod, as with the side view of the Top Frame. Cut a piece of 4/5oz. cowhide about 30" long and 4½" wide (same as step B, page 94). Follow the same instructions as with the Top Frame. See the photo on page 93 for the completed unit.

DETERMINING the SIZE of the BODY of the GOLF BAG

**TOP FRAME
UNIT**

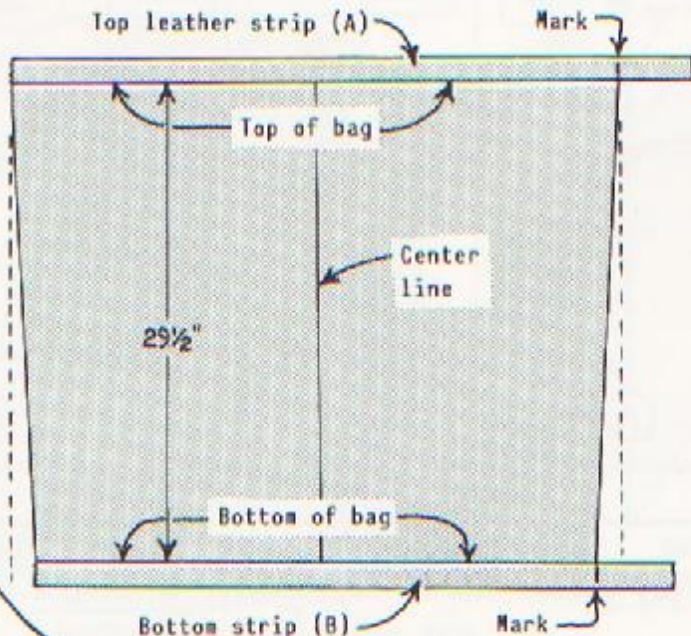


**BOTTOM FRAME
UNIT**



1

To determine the exact measurements to cut the circumference dimensions of the bag, cut a strip of leather from the same leather (thickness) from which you will cut the bag. Hold it at the center of the frame and fold it snugly around as shown above. Put a mark on the strip where the ends would abut.



2

Lay the leather strips out flat and record the measurements of (A) and (B) from the end of the strips to the marks. This will be how wide to cut the leather at the top and bottom. The broken line suggests the top dimension if it were squared, so be sure to equalize the lines at the bottom within this dimension...or the bag will be crooked when assembled.

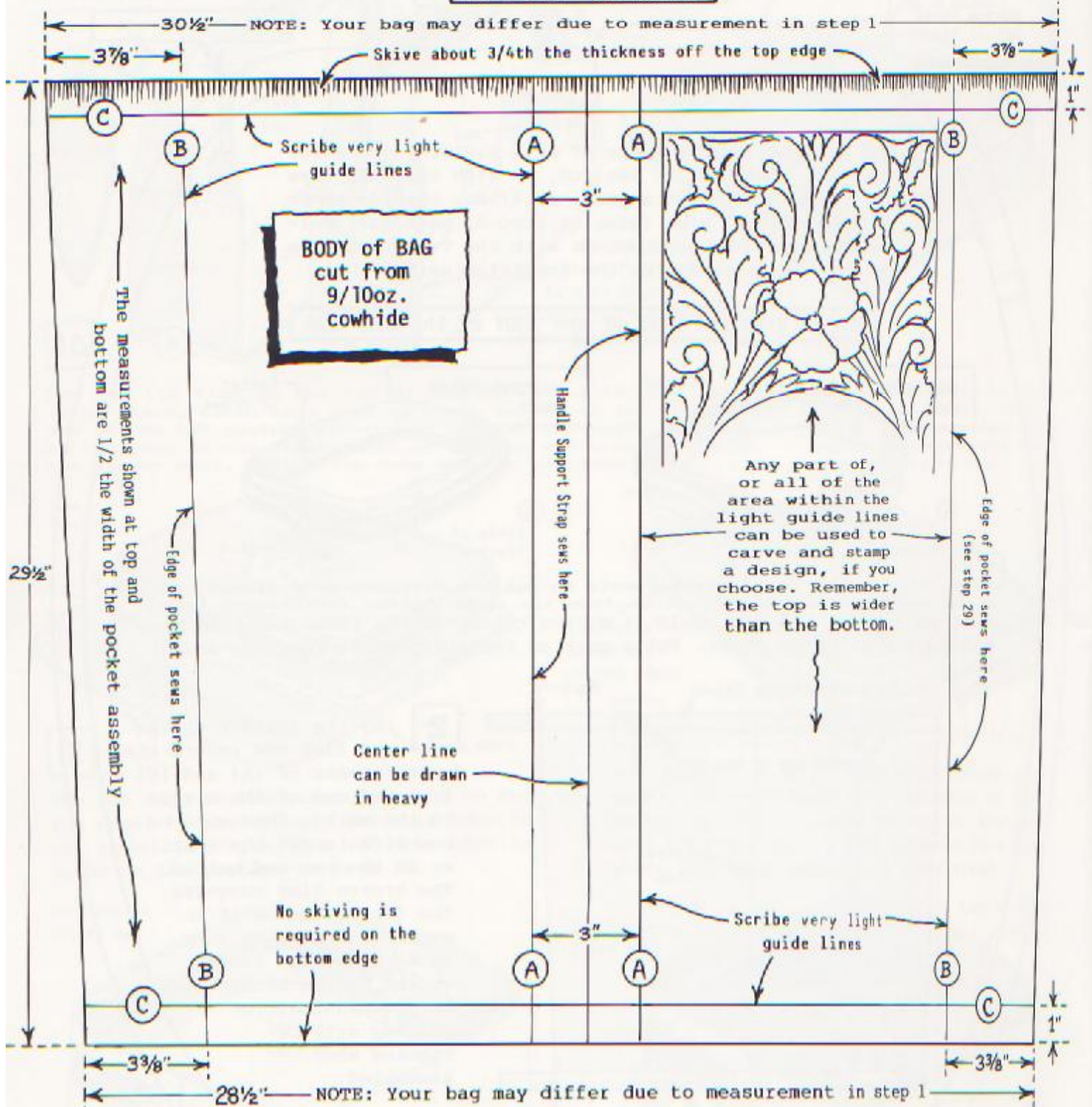
NOTE:

Since the Bottom Frame is symmetrical, there is no distinction between the front and the back.

Center line

Be sure to carefully study all of the instructions that follow.

GOLF BAG - Continued



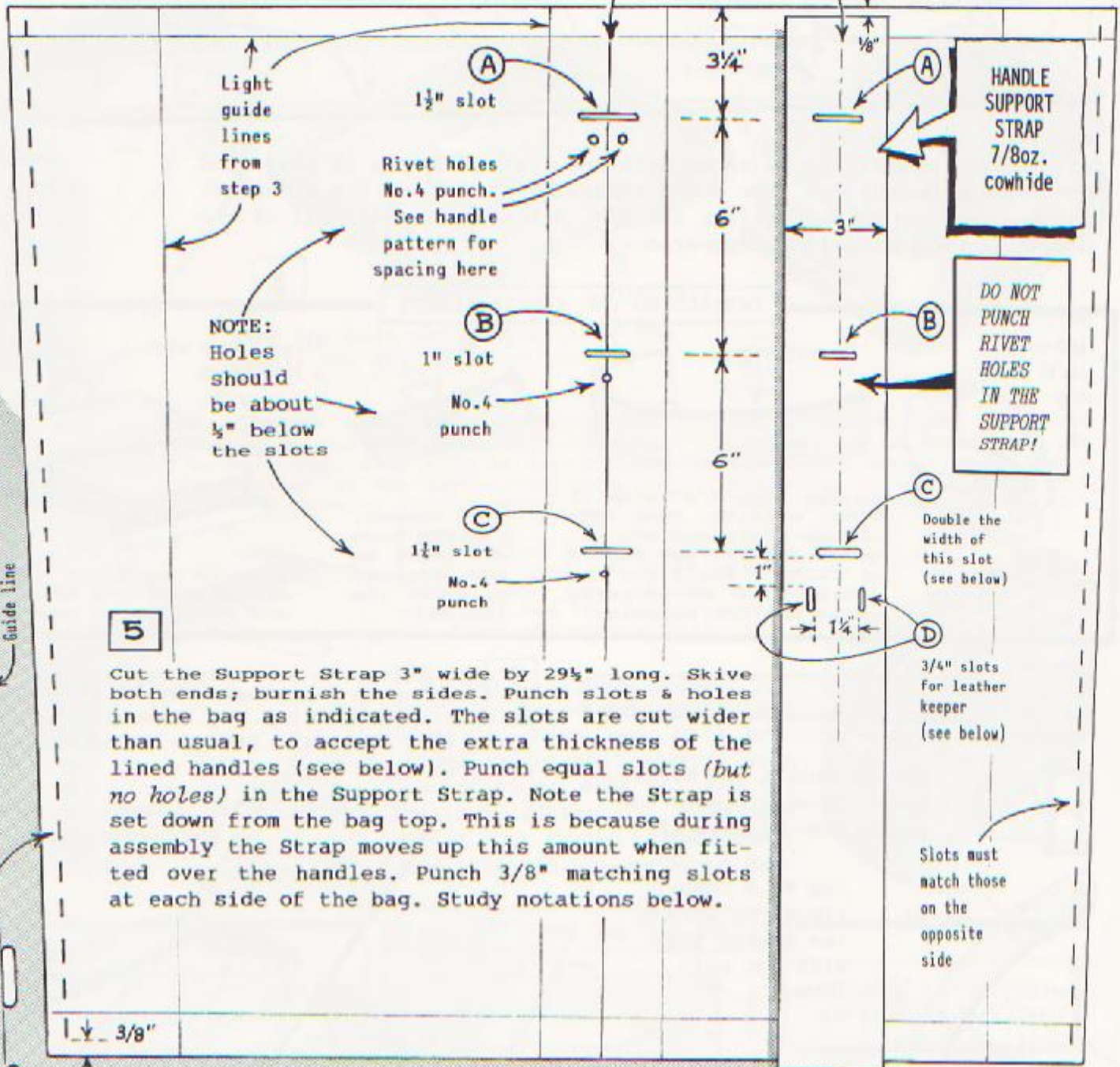
3 Cut out the bag to measurements taken; step 1. Lightly scribe lines as shown above. This will show you the areas you can carve. Cement your leather to cardboard so it does not stretch while stamping. Allow it to thoroughly dry before removing.

4 After stamping, re-check all of your measurements and positions of lines. Make any necessary adjustments. The lines should be straight. Handle Support glues between lines (A). Pocket edges sew at (B) and collar edges sew at line (C).

GOLF BAG - Continued

Center the slots

NOTE: Set the Support Strap down 1/8" here



5

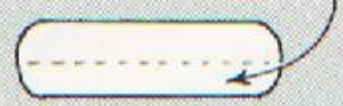
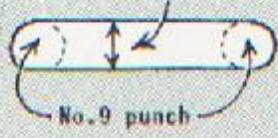
Cut the Support Strap 3" wide by 29 1/2" long. Skive both ends; burnish the sides. Punch slots & holes in the bag as indicated. The slots are cut wider than usual, to accept the extra thickness of the lined handles (see below). Punch equal slots (but no holes) in the Support Strap. Note the Strap is set down from the bag top. This is because during assembly the Strap moves up this amount when fitted over the handles. Punch 3/8" matching slots at each side of the bag. Study notations below.

1/8" 3/8"

Width of slots for bag and strap at A - B - C.

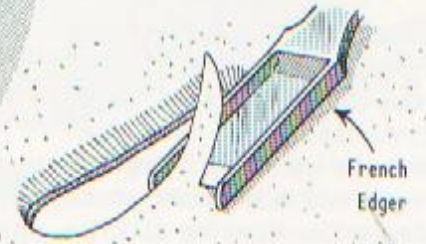
Widen slot C (for Support Strap) on the lower side.

Skive both ends of the Support Strap.

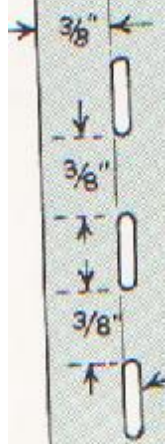


Illustrations here...shown ACTUAL SIZE

Slots for leather keeper. Use 3/4" Bag Punch.

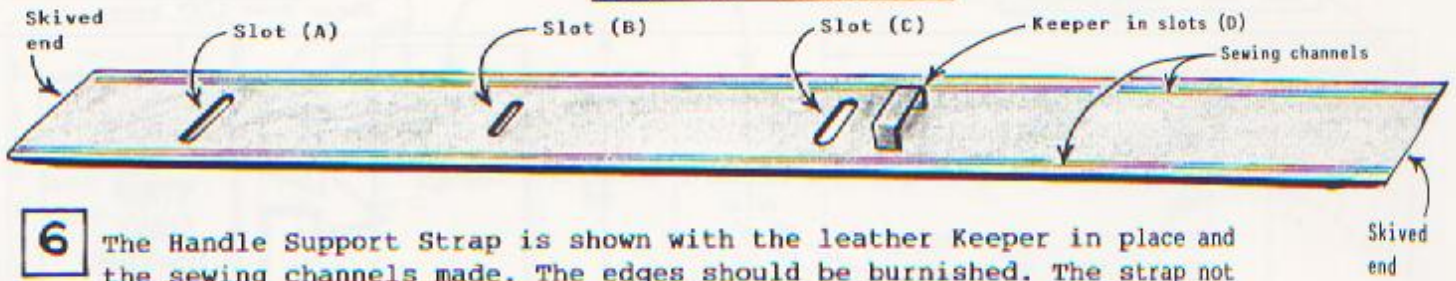


Skive about 1/2 of the leather thickness off at each side of the slots.



3/8" Bag Punch

GOLF BAG - Continued



6 The Handle Support Strap is shown with the leather Keeper in place and the sewing channels made. The edges should be burnished. The strap not only serves as a vertical support for the bag, but also conceals all of the rivets...for a more professional appearance.

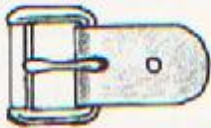
INSTALLING the KEEPER (LOOP)

Cut the loop 3/4" wide of 6/7oz. cowhide. Push ends through slots and sew together (left). See page 9 of "CASES"- Vol.I for the instructions on properly making Leather Keepers.

With hammer, flatten loop and glue to the Support Strap on the inside.

"Block" loop with a loop-stick. See page 79, "TOOLS"

Turn to the grain side up. Moisten the Keeper and block it as shown.



Make the Handle and Buckle Assembly from patterns and instructions on page 112.

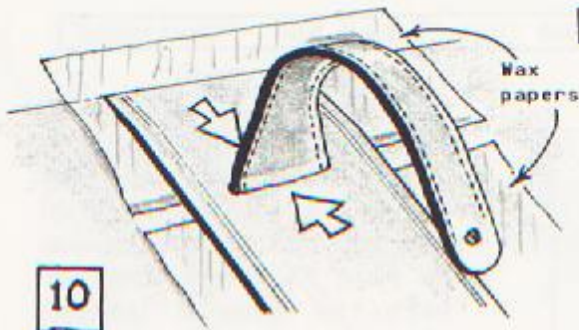
Use No.9 copper rivets to attach the parts. They will not pull loose!

8 Push the top of the Handle through slot (A) and rivet in place. Use wax paper as shown, to keep glue off of the Handle. Riveting will be easier with the washers on grain side of bag as shown. After riveting, apply more glue over rivets and near the slot edge. Rivets, other than copper, may pull loose, which would make repairs difficult after completing bag.

7 To begin the assembly, apply contact cement to the flesh side of the Support Strap and to the bag area within the lines (A), where the strap will adhere... allow to dry.

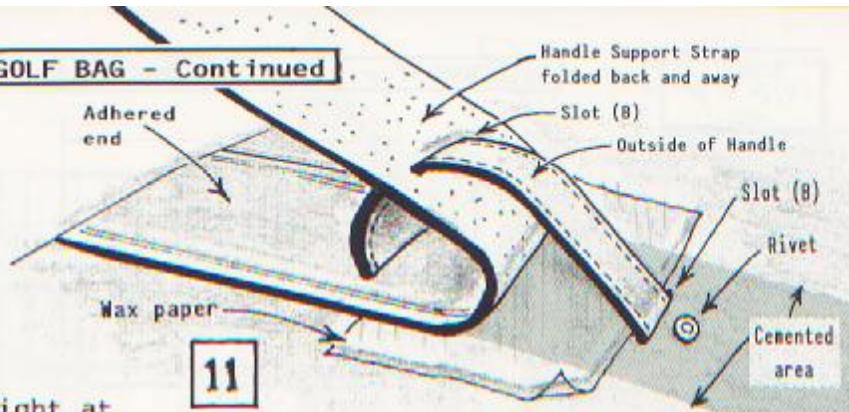
9 Add more wax paper over the glued area of the bag to prevent premature adhesion. Push Handle through slot (A) of the Support Strap...as illustrated above. (continued)

GOLF BAG - Continued



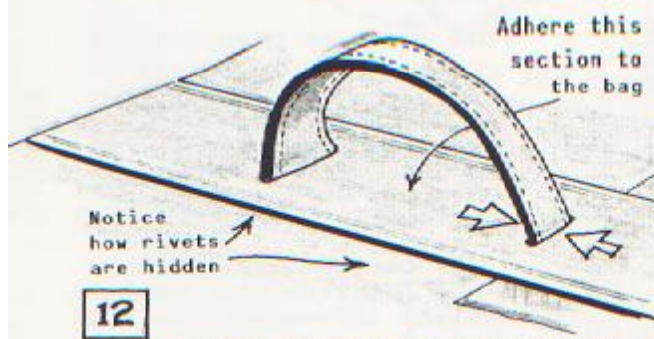
10

Now press the Support Strap down tight at each side of the Handle. If the edges are in alignment with lines (A), then remove the end wax paper and adhere the Support Strap to the bag. Tap with a hammer.



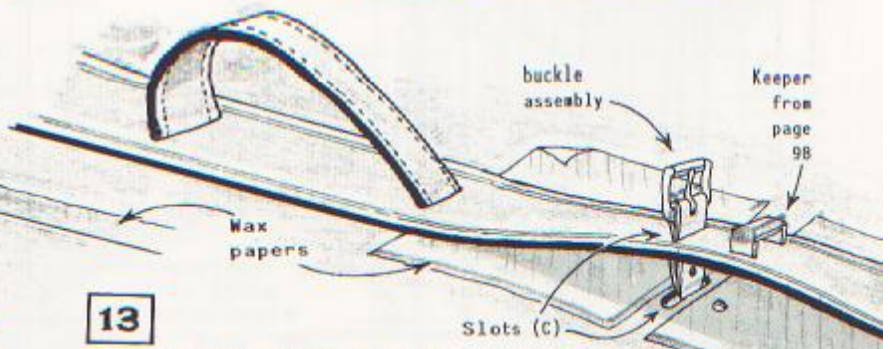
11

Fold Support Strap up and insert Handle into slot (B) and fold strap back as shown. Push end of Handle into slot (B) of the bag, and rivet. Keep wax paper in place as shown.



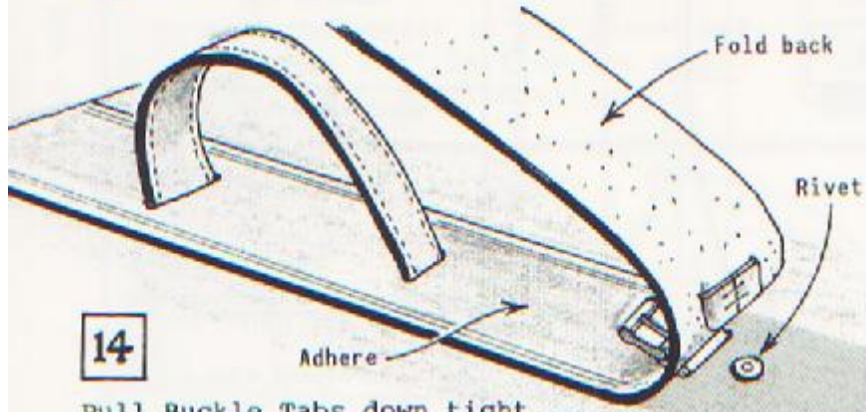
12

Replace wax paper up against Handle. Slide Support Strap down tight near sides of the Handle. If edges are aligned, remove the wax paper from under the Handle; adhere this section.



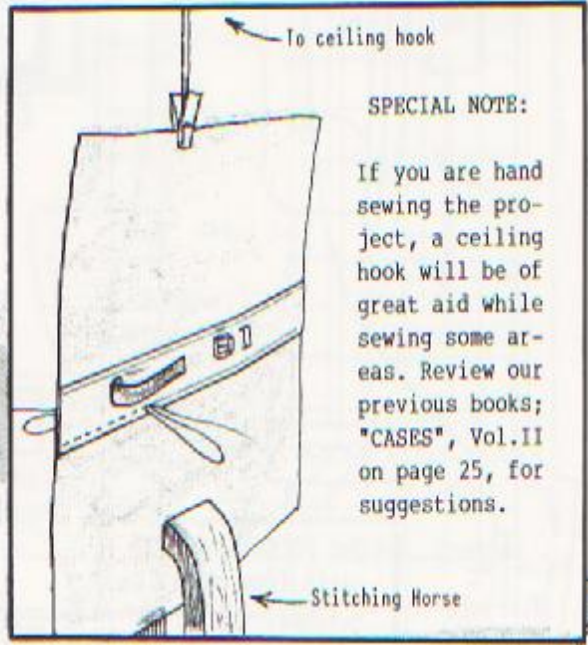
13

Cut a wax paper to fit between the Handle and slot (C). Place another one from the slot to the bottom of the bag. Push the Buckle Tabs through slot (C) of the Support Strap and into slot (C) of the bag. Keep wax papers in place.



14

Pull Buckle Tabs down tight... from inside the bag. Remove the wax paper from between the Handle and Buckle and adhere this section. Fold the Support Strap sharply back out of the way. Remove the other waxed paper and rivet the tabs to the bag.



SPECIAL NOTE:

If you are hand sewing the project, a ceiling hook will be of great aid while sewing some areas. Review our previous books; "CASES", Vol. II on page 25, for suggestions.

15 Now carefully adhere the remainder of the Support Strap to the bag. Tap with hammer for good bonding. Sew both of the edges to the bag.



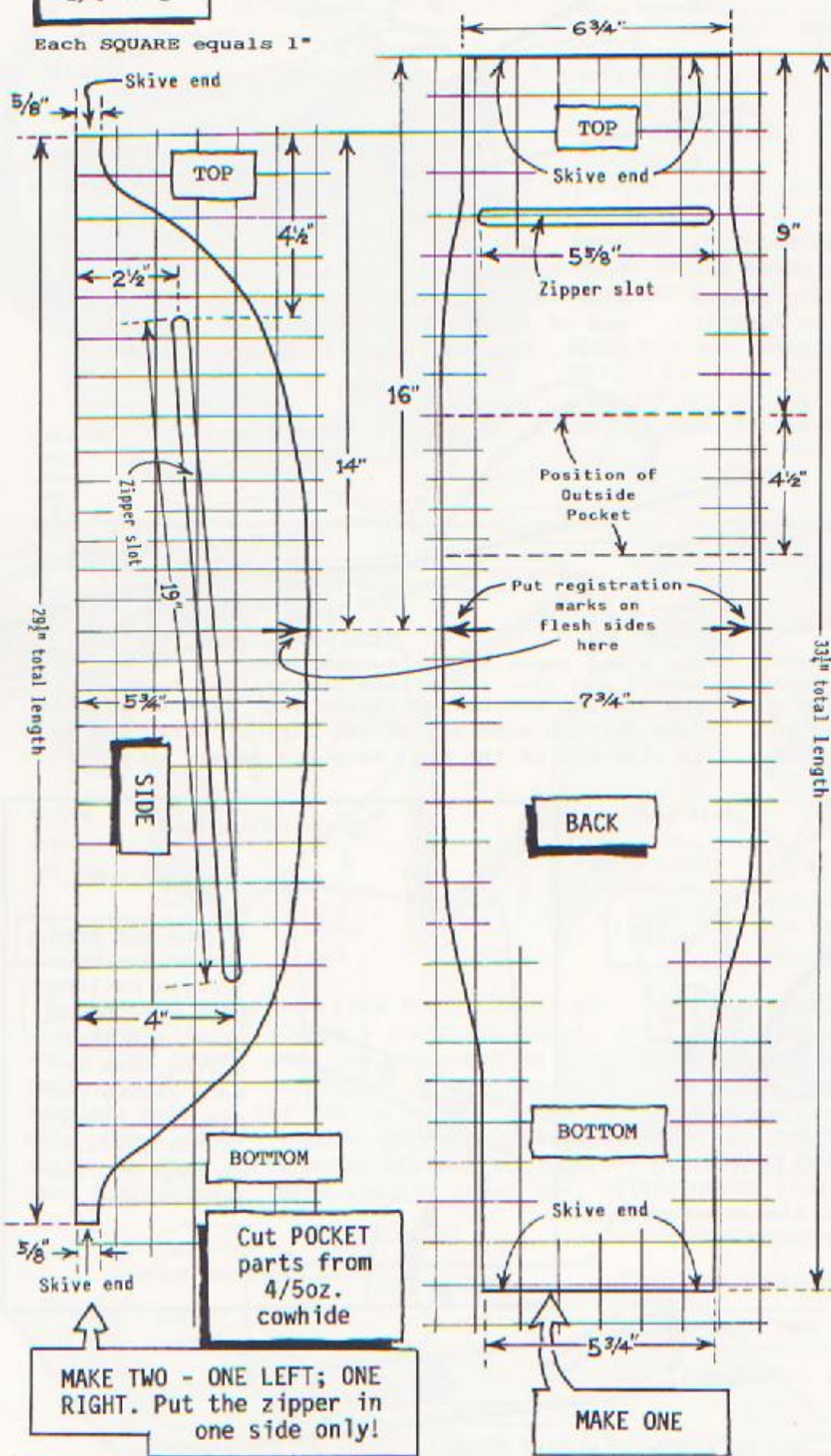
This can be sewn by machine if you have access to a Heavy-Duty Stitcher

SCALE
1/4" = 1"

PATTERNS for the LARGE POCKET

GOLF BAG - Continued

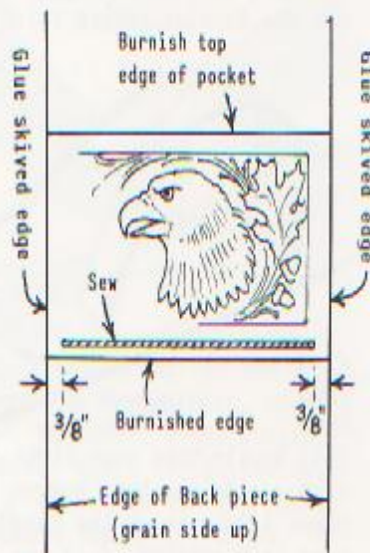
Each SQUARE equals 1"



Two welts are needed. Cut them 33 1/4" long. Make them from 3/4oz. leather. Burgundy latigo was used for our welts, as was used on the Top and Bottom frames on page 94. This contrast with the natural leather gives a pleasing effect. Place registration marks on both of them, 16" from one end so they'll match up, during assembly, with the Back and Side pieces.

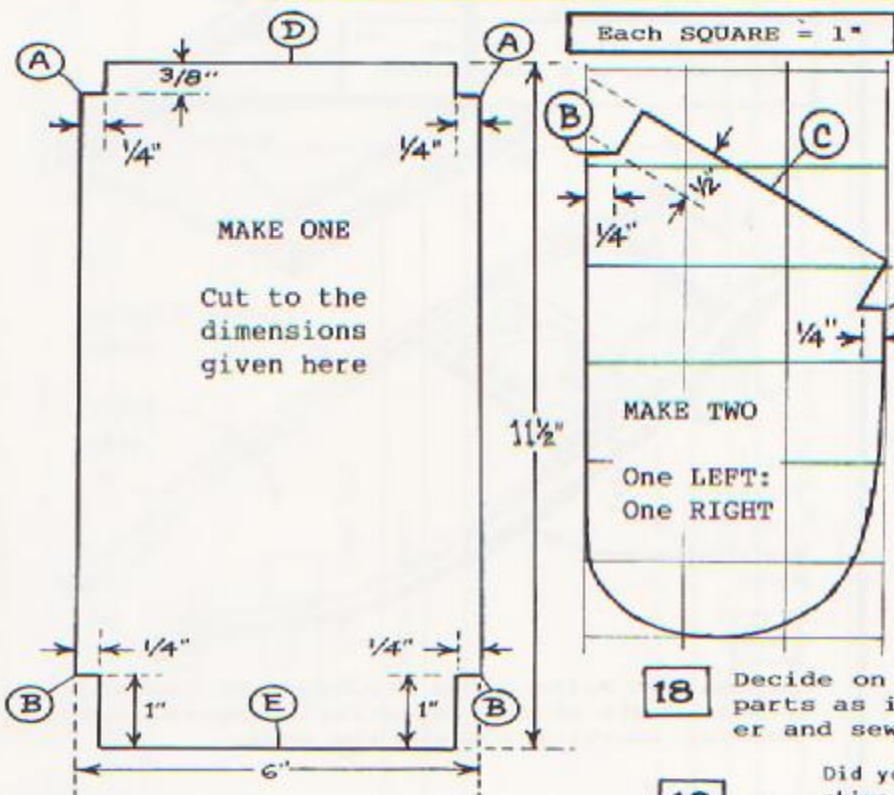
The graph is presented so the proper curves will be achieved when making your pattern. Take note of all measurements given on the graphs. We have made allowances at all edges for the welted seams.

16 Cut the pocket parts out from the leather weight indicated. Sew the zipper in one of the Side pieces. Use a heavy zipper. Do not sew a zipper in the Back piece yet!

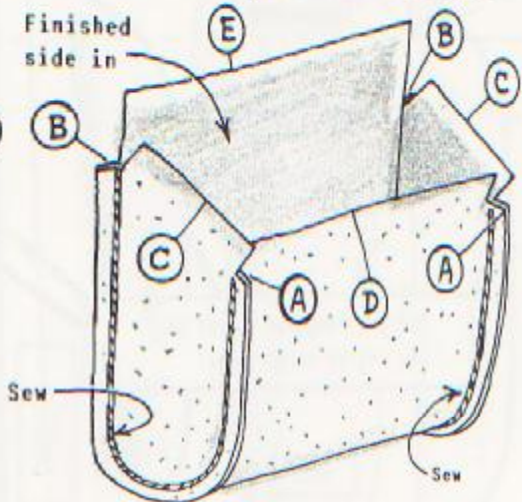


17 From 4/5oz. cowhide, an Outside Pocket is cut 4 1/2" x 7-3/4". After it is carved, skive the side edges and glue the bottom and sides to the Back, as shown above. The position of the pocket is shown on the graph; left. Sew the bottom edge to the Back.

MAKING the SMALL POCKET...for GOLF BALLS and MISCELLANEOUS ITEMS

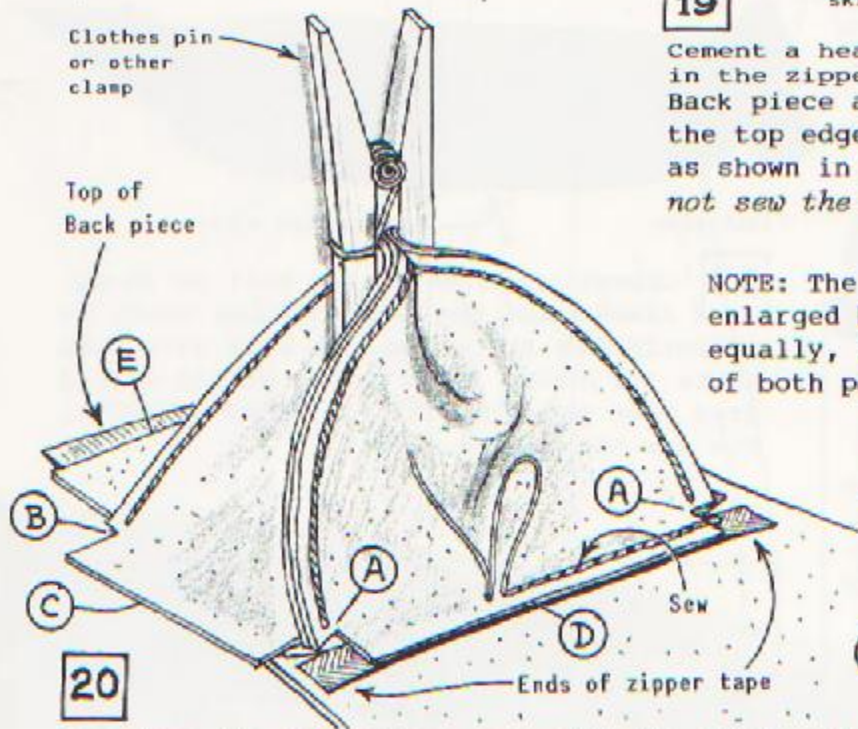
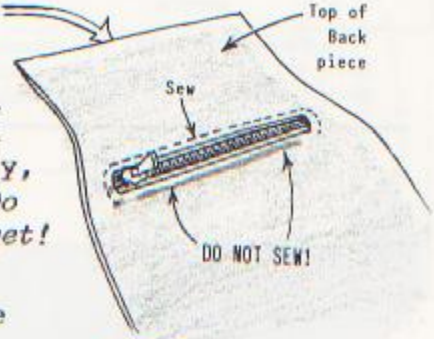


This pocket can be made of vinyl, canvas, or almost any lightweight leather...except skiver! It does not have enough tensile strength.



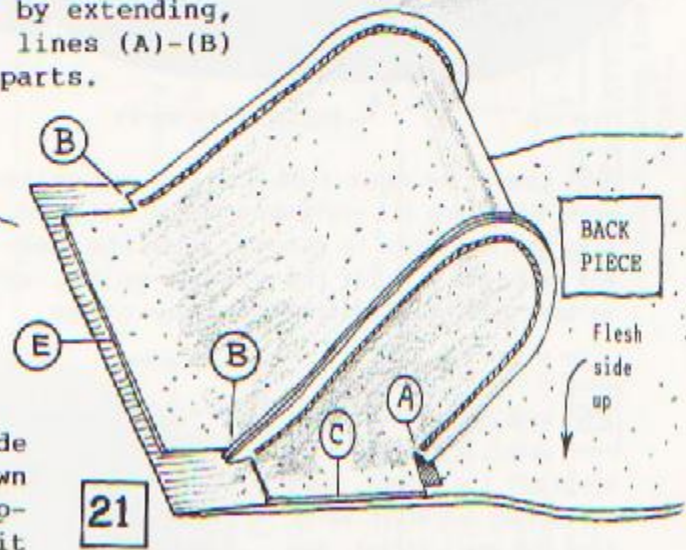
18 Decide on the material to use then cut out pocket parts as indicated at left. Glue the edges together and sew around the pocket edge from (A) to (B).

19 Did you remember to skive this edge?
Cement a heavy zipper in the zipper slot of the Back piece and sew around the top edge and ends only, as shown in the sketch. Do not sew the bottom edge yet!



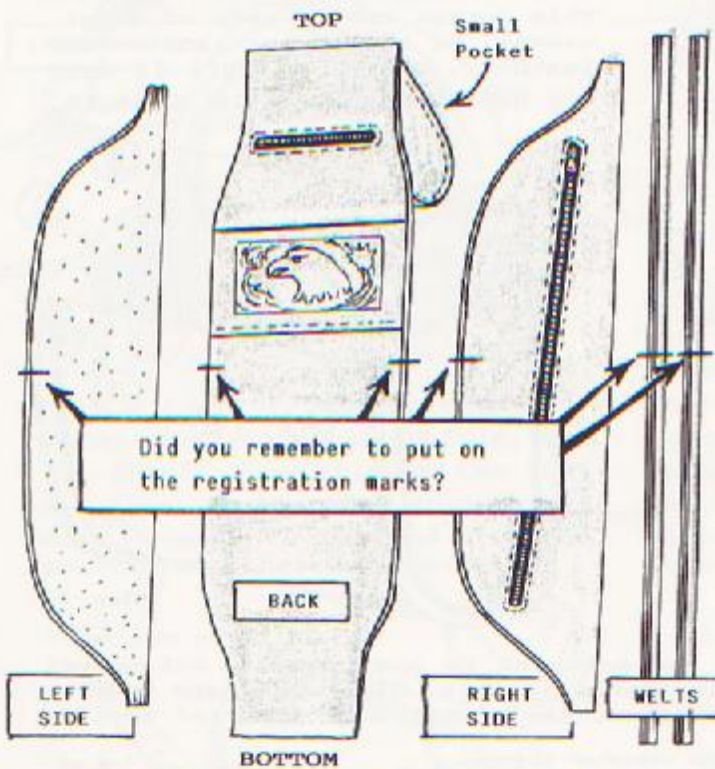
NOTE: The pocket can be enlarged by extending, equally, lines (A)-(B) of both parts.

20 Now turn the Back piece over with the flesh side up. Cement edge (D) of the Pocket to the un-sewn zipper tape; this will be the bottom of the zipper slot. Because of the angle of the pocket, it will have to be folded or crushed in...to create access for sewing this edge. Use whatever method you can to keep the Pocket out of the way. Turn the Back piece around to the front side, and sew the zipper in at the bottom. The stitches secure edge (D) of the Pocket (as illustrated above).



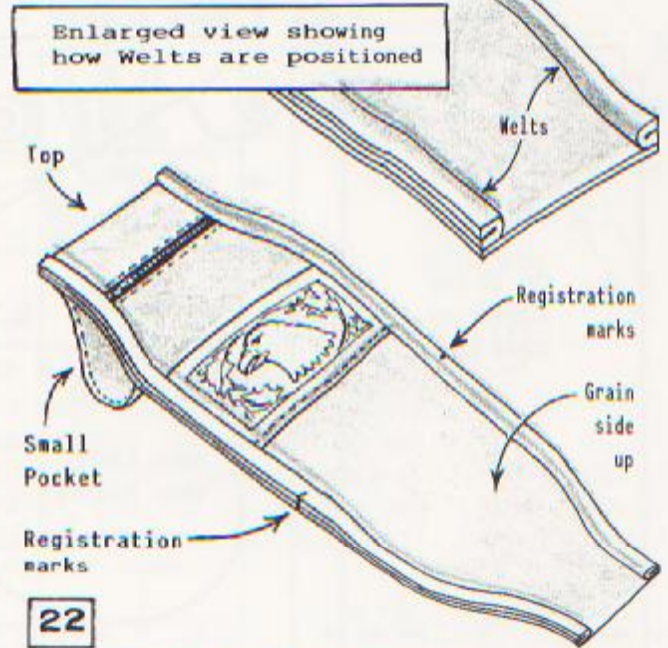
21 Turn the Back piece flesh side up and shape the Pocket to its normal form. Glue edges (C) & (E) in place; above. The edges at (C) will be sewn along with the welts.

GOLF BAG - Continued

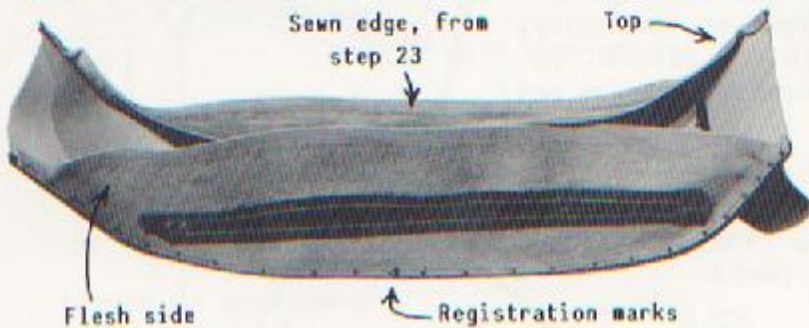


From pages 100 & 101 you should now have all of the parts for the large pocket prepared as shown above.

ASSEMBLING the LARGE POCKET



Cement the Welts along the edges of the Back piece. Begin at the registration marks...and adhere...working towards the ends.

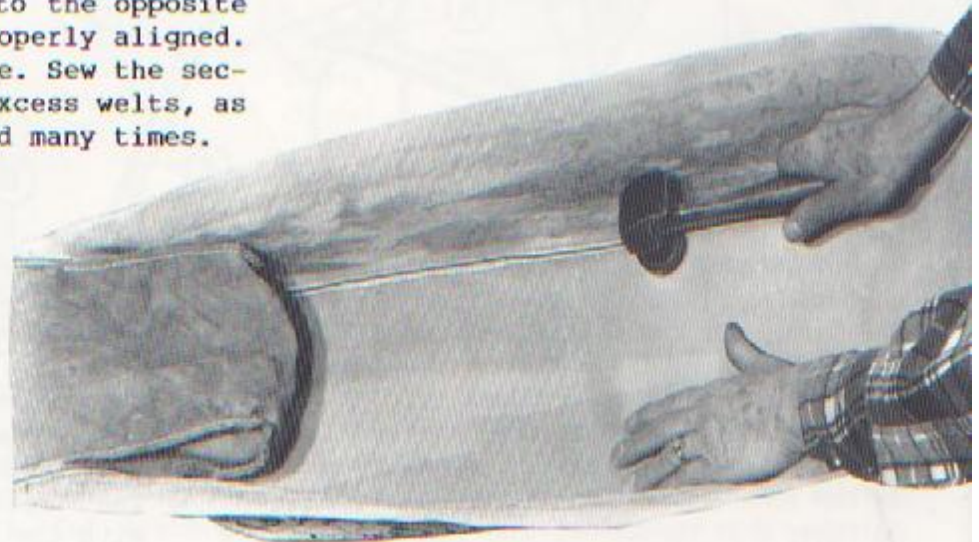


24 Cement the other side to the opposite Welt. Keep all edges properly aligned. Also use the tacks to secure. Sew the second Welt. Now trim off the excess welts, as we have previously instructed many times.

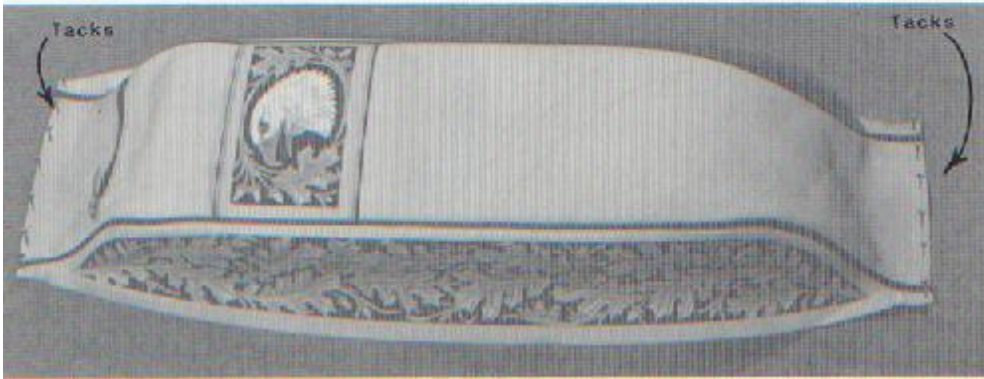
25 Dunk the Pocket under water, a few moments. Drain off the excess. Open the zipper to drain water from the small pocket. Now flatten the Welts as shown at right. Place the Pocket on a smooth surface.



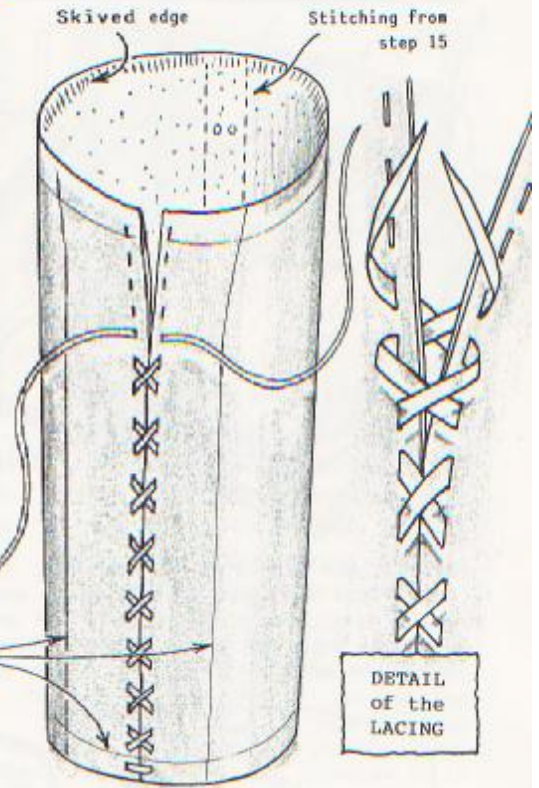
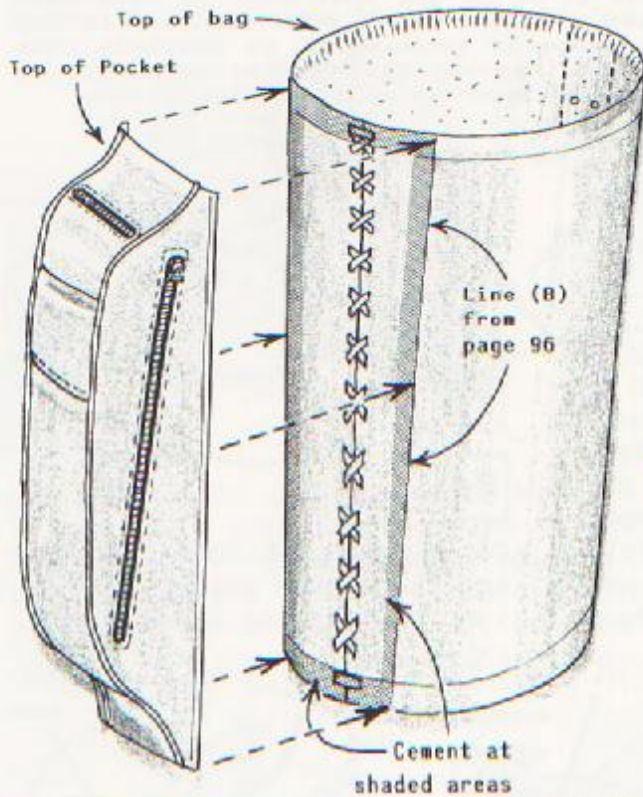
23 Cement one side to the Welt as shown. Always use the registration marks to properly fit the parts. We have also used tacks to insure no slipping at the welted area (see pages 52, 53, of "HAND SEWING"). Now sew the welted seam.



GOLF BAG - Continued



26 Now fill the Pocket with towels or other soft material and place it on your bench. Shape it with your hands and straighten any wrinkled areas. Tack the ends down and allow it to dry in this position.

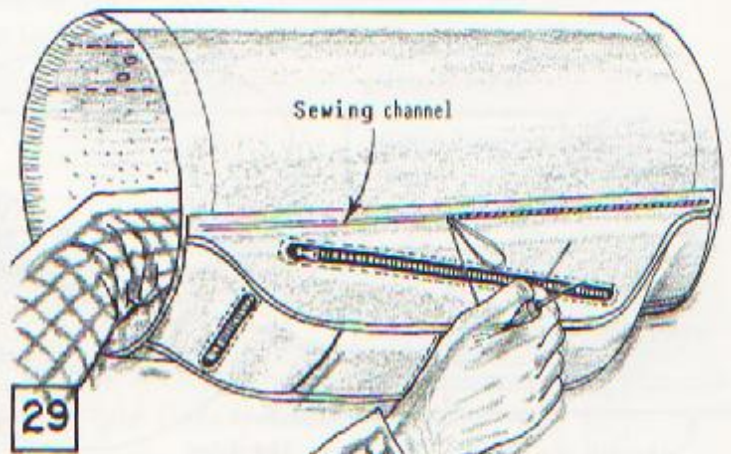


27

Make two thongs about 5ft. long and 3/8" wide. Cut from 4/5oz. latigo, indian-tan, or other firm but pliable leather. Bevel the edges and splice the two thongs together. See page 6 of "HOW to MAKE HOLSTERS" for beveling instructions. Lace the bag together as shown above.

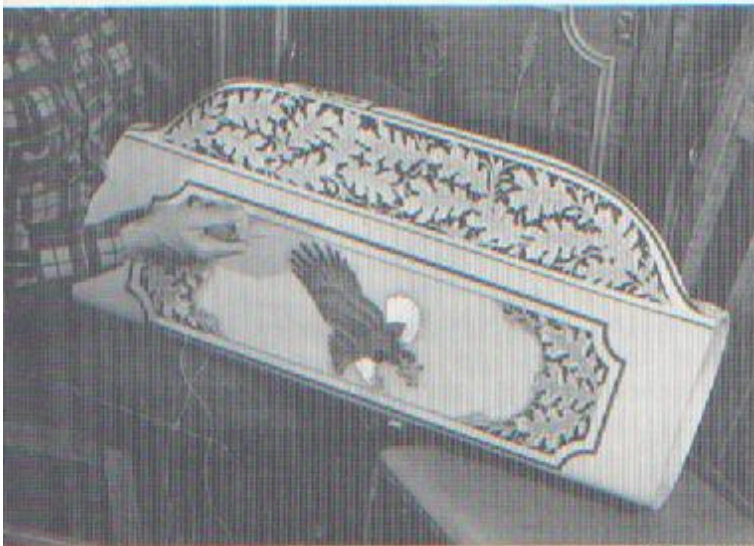
28

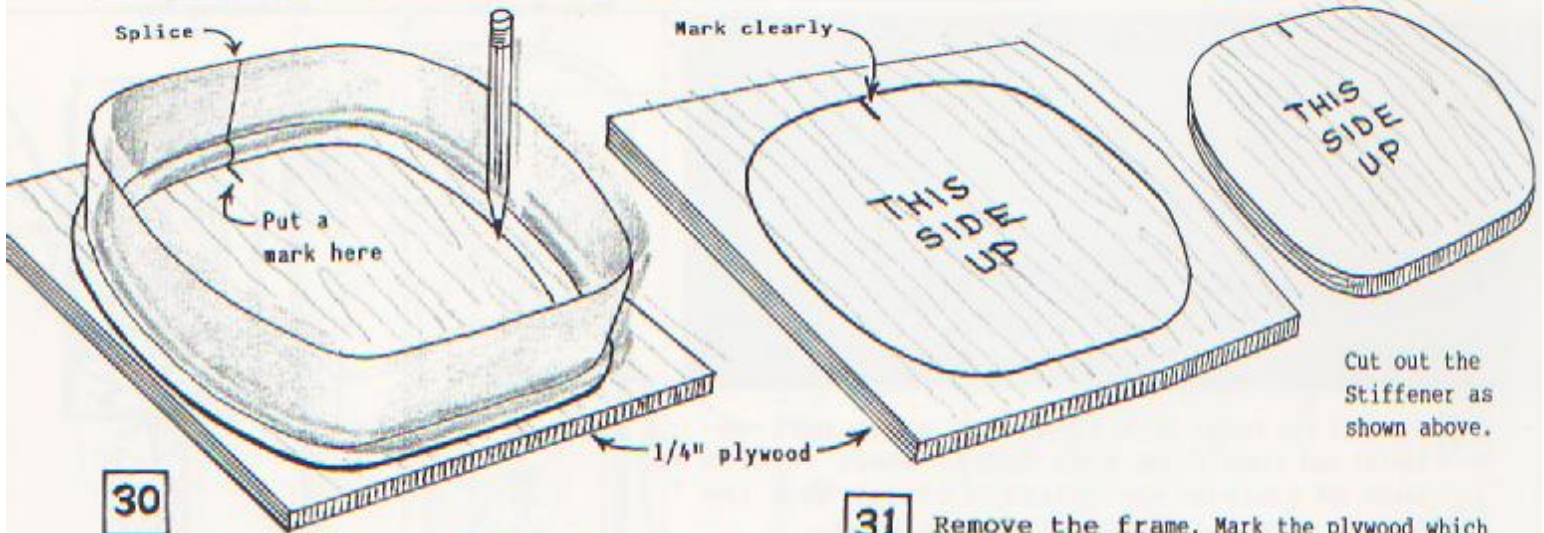
Now cement the Pocket to the bag. Cement at shaded areas; sides, top and bottom. Open the long zipper if necessary to assist in keeping the edges even.



29

Make sewing channels on each side; wheel. One hand must reach inside the bag, to sew it. Sew about half way (as far as you can reach), then turn the bag around to complete the stitching. Ann Stohlman (left) shown sewing the pocket.





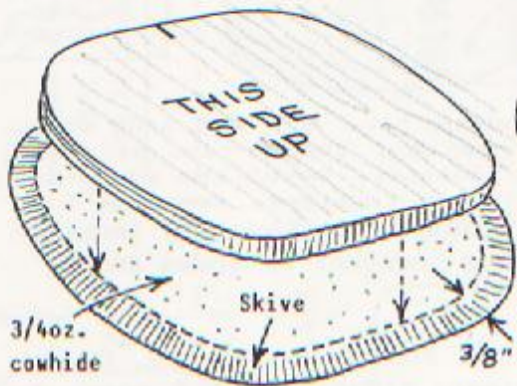
Cut out the Stiffener as shown above.

30

We must now make a Stiffener for the bottom. Place the unit on plywood and carefully draw inside the frame to mark the plywood. Hold the pencil perpendicular around the perimeter. Mark at the splice.

31

Remove the frame. Mark the plywood which side is to be up. This must go back into the frame in this exact position, or it may not fit properly because it is unlikely that the frame is exactly the same at each side or end. The mark must go at the spliced end.



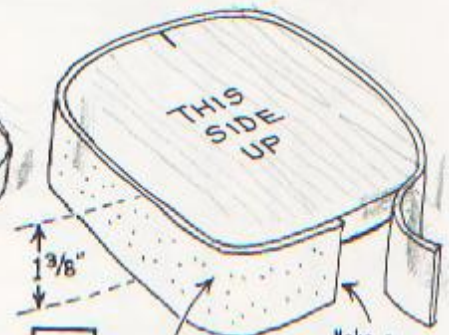
32

Cut a leather 3/8" oversize. Skive the edges and glue it to the bottom of the Stiffener.



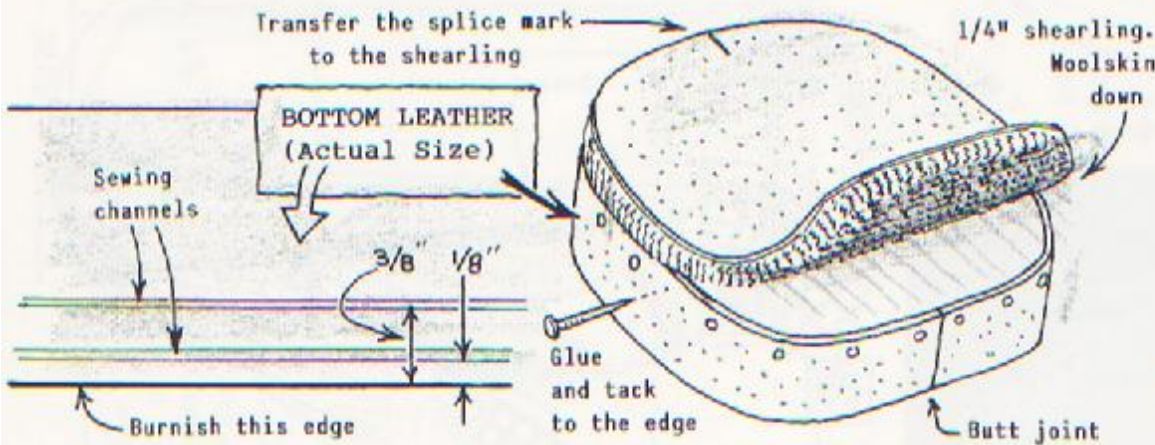
33

Moisten edge. Apply glue to the edges of plywood and leather. Fold up tightly to adhere at the edge.



34

Cut a piece of 7/8oz. cowhide to fit tightly around the bottom. Cut off for a butt joint.



35

Gouge two sewing channels only on one edge; above.

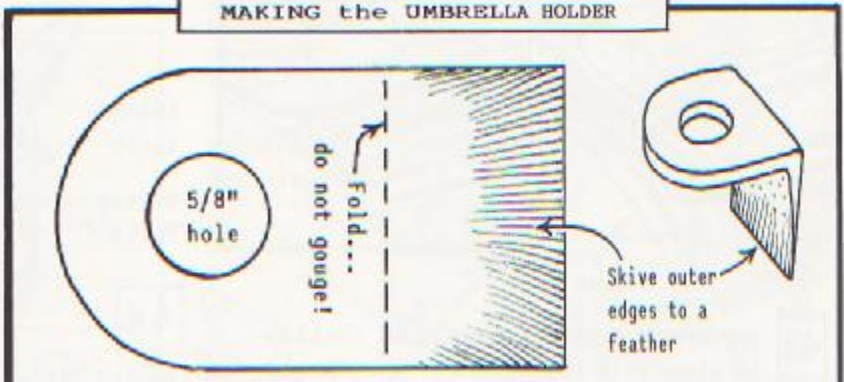
36

Now cut a piece of shearling the same size as the plywood unit and glue in place. Gluing the leather side up will cushion the handles better.

37

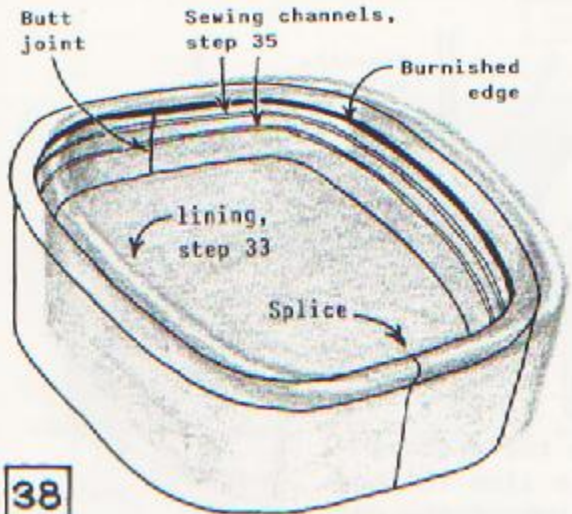
Apply glue to the inside of the frame unit and to plywood unit. Push down into the frame unit before the glue "sets".

MAKING the UMBRELLA HOLDER



PATTERN - Actual Size

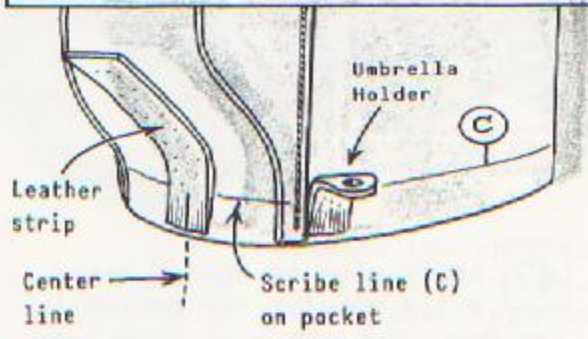
Cut the Umbrella Holder from 9/10oz. firm cowhide. Punch a 5/8" hole as indicated. Skive as suggested above. Burnish the edges. Wet the leather at the fold area. Put in a vise (protected with heavy paper on both sides) and hammer the fold with force, to make a right angle. Remove, and allow to dry.



38

Bottom view of the units properly positioned. Force the plywood unit (step 37) down to the frame rod as shown above. Allow the glue to set. The bottom now is ready to install in the bag.

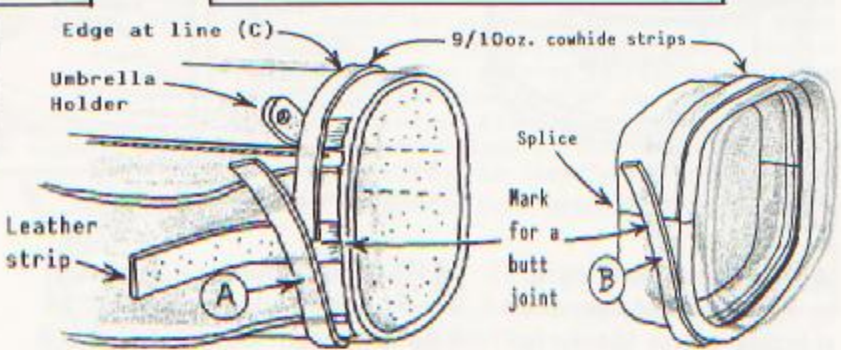
PREPARING the BOTTOM for the COLLAR



39

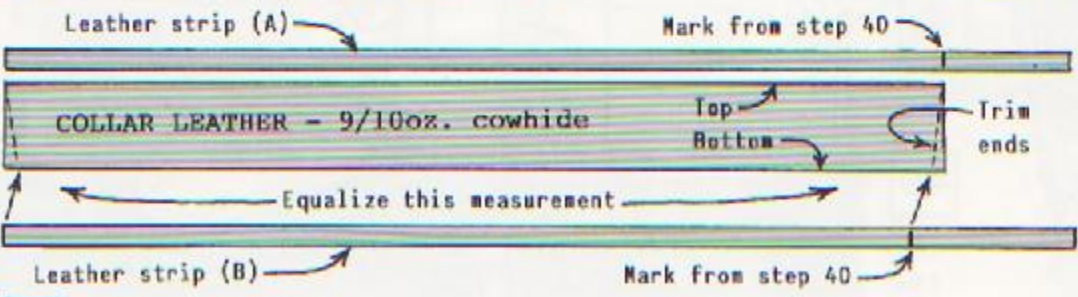
Cut a strip of 6oz. cowhide 1" wide by over 5" long. Burnish edges and skive one end. Glue skived end at center of Pocket. Glue Umbrella Holder right at the edge of the Pocket. Be sure the fold (underside) is above line (C), so the edge of the Collar leather can glue on line (C).

DETERMINING the COLLAR LENGTH



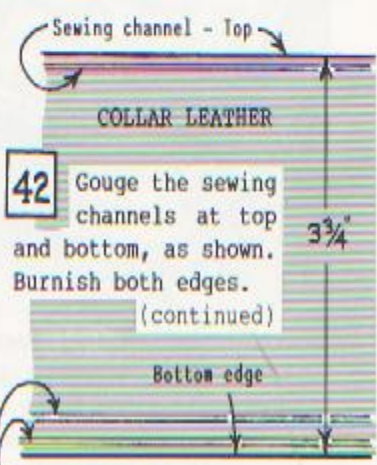
40

The bottom Collar is cut from 9/10oz. cowhide, so cut two strips from same leather. Fold them around the bag and the bottom as shown. Measurement (A) is going to be longer than (B). Be sure the edge of strip (A) is right on line (C), all around the bag. Pull up snug, and mark.



41

Measure the length of strips (A) & (B) to the marks put on them in step 40. (A) Will be the longest. Cut the leather for the Collar 3-3/4" wide and to the length of (A). Square the ends. Now measure (B). If, for example, (B) is 1" shorter than (A), then 1/2" will have to be taken off of each end at the bottom edge of the Collar. Cut the ends on the broken line; above.



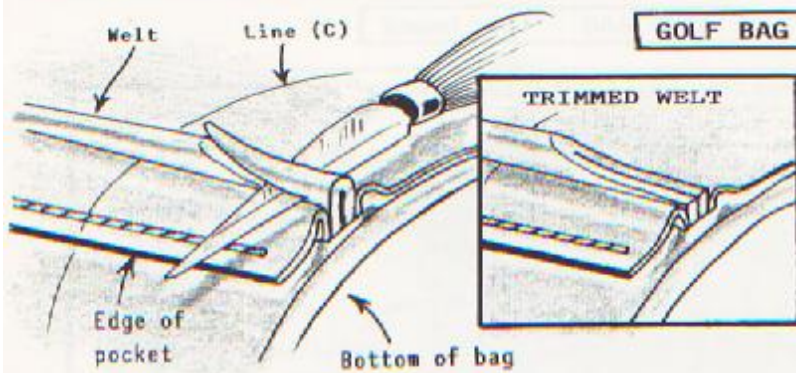
42

Gouge the sewing channels at top and bottom, as shown. Burnish both edges.

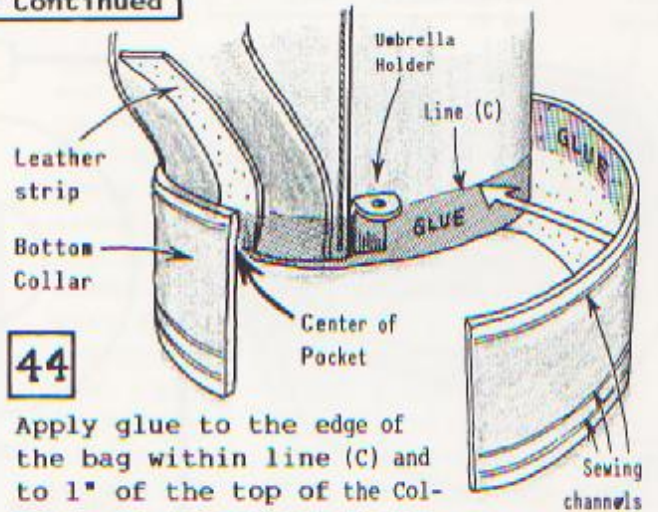
(continued)

Sewing channels... exactly as step 35

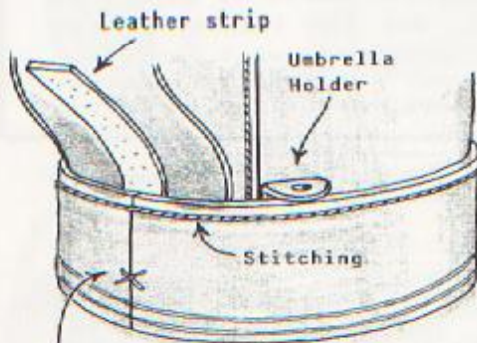
GOLF BAG - Continued



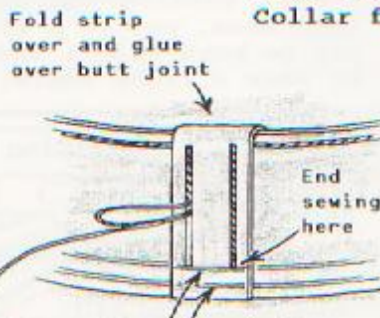
43 IMPORTANT! Before gluing the Collar in place, trim the ends of the Welts as shown...to reduce bulk at the edge of the bag. Stay within line (C) so Collar will cover the trimmed area.



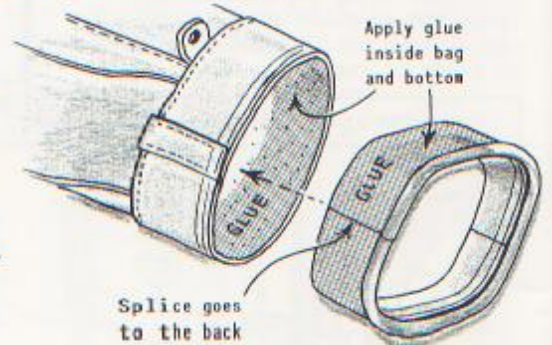
44 Apply glue to the edge of the bag within line (C) and to 1" of the top of the Collar, on the flesh side. Allow to dry. Begin adhering as shown. The top of the Collar fits right on line (C).



Tie butt joint together here, to keep from spreading



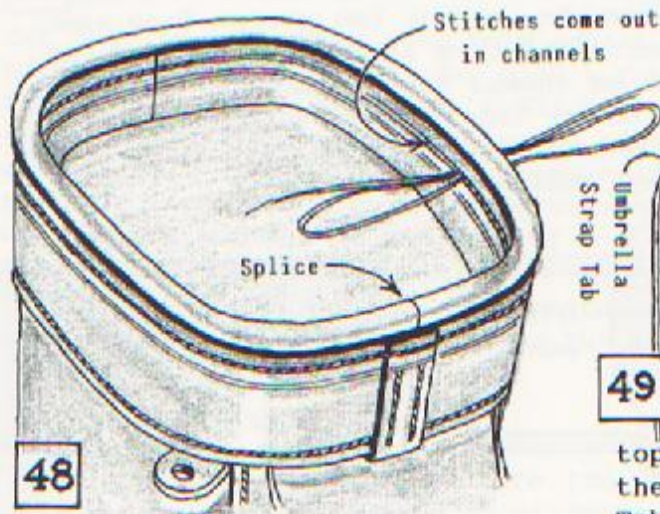
Make sewing channels to match those of the Collar



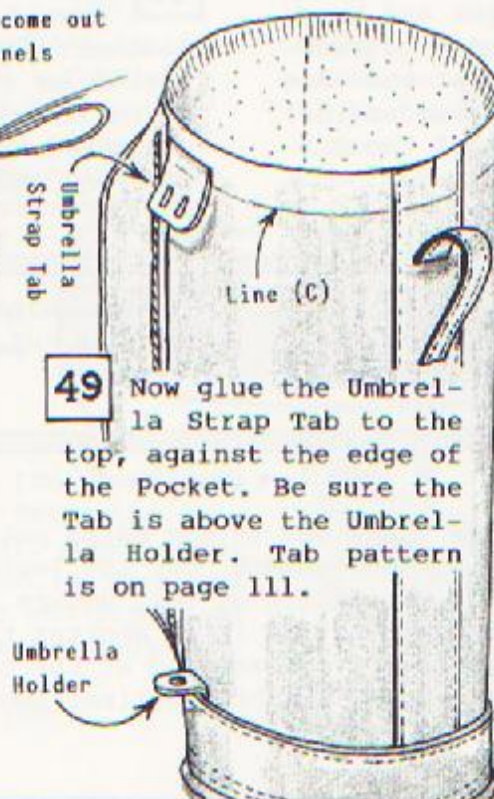
45 Complete adhering to the bag and sew. The stitches secure the strip and the Umbrella Holder.

46 Glue the strip down; above. Trim flush at the bottom; burnish. Make channels. Sew as shown.

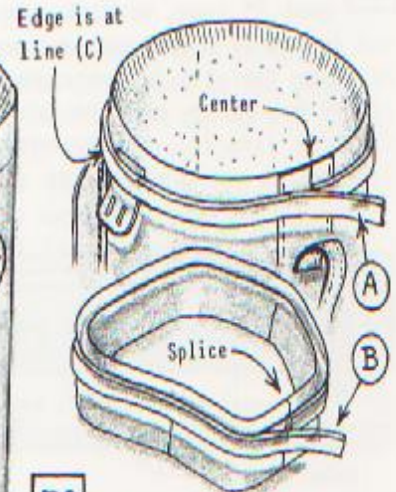
47 Apply glue to shaded areas. While wet, fit the bottom in the bag. The bag will form into the shape of the bottom unit.



48 Force the bottom unit down in the bag until the Collar fits snugly against the frame rod. Allow glue to set. Sew the unit in both channels.



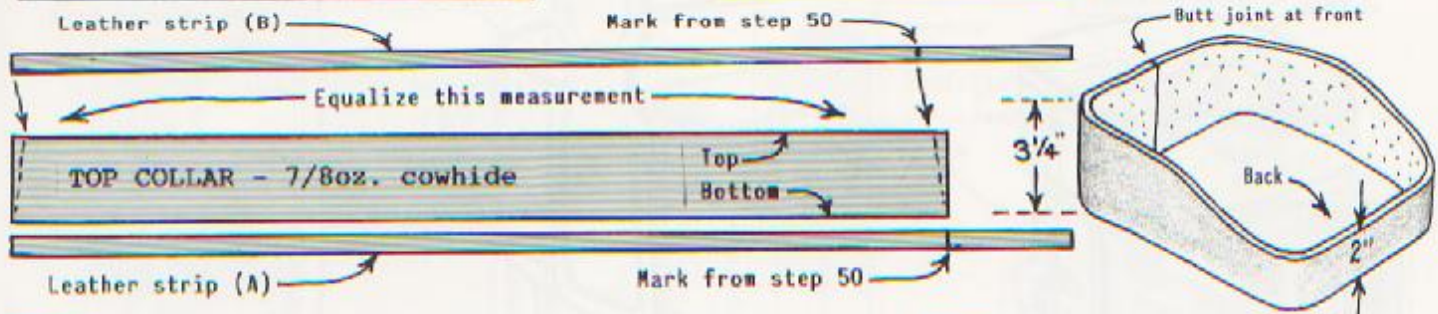
49 Now glue the Umbrella Strap Tab to the top, against the edge of the Pocket. Be sure the Tab is above the Umbrella Holder. Tab pattern is on page 111.



50 Now we must determine the length to cut the Top Collar. Use 7/8oz. leather strips and follow step 40. The Top Collar is cut from 7/8oz. cowhide. Use the top frame unit here.

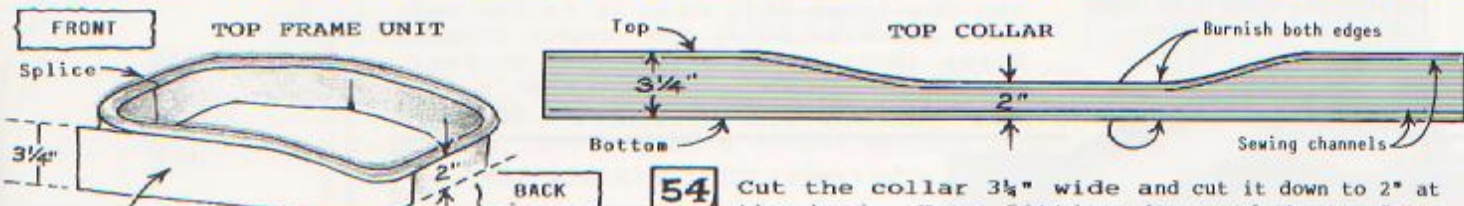
The TOP COLLAR DIMENSIONS

GOLF BAG - Continued



51 The Top Collar measurements will be in reverse of the bottom (step 41). Here, strip (B) will be the top of the collar. Strip (A) will be at the bottom that fits around the bag. This is usually longer than measurement (B), at the top frame. Re-read instructions in step 41. Reverse them here.

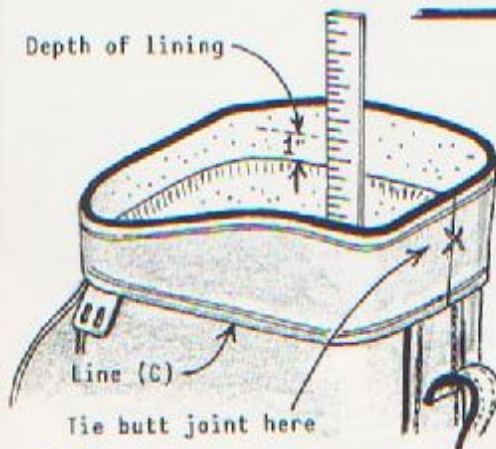
52 In addition, the Top Collar is dipped down at the back, conforming with the angle of the top frame. The collar will butt joint at the front of the bag. This is at the center of Handle Support Strap.



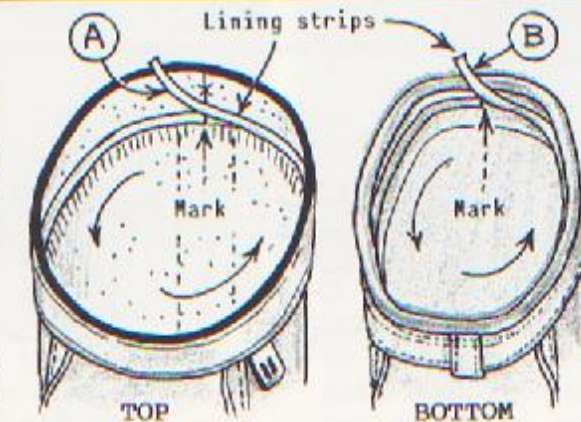
Cardboard or scrap leather.
Keep trimming to fit

54 Cut the collar 3 1/4" wide and cut it down to 2" at the back. Keep fitting it around the top frame until it fits at the rod and abuts at the splice, at the front. The length of the collar is determined in steps 50, 51. After fitting, burnish edges and gouge sewing channels. Follow usual procedures for carving.

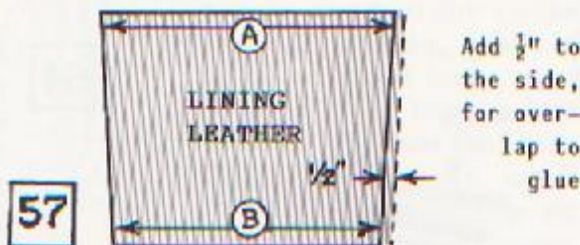
53 Obtain the curve of the Collar as suggested above.



55 Glue the collar to the bag. If you are going to line the bag do not sew the collar yet. Stand a ruler in the bag to ascertain the depth of the lining. Cut it about 1" above the edge of the bag. This edge of lining will be skived to reduce thickness. The lining in our bag was made of dark green garment leather.

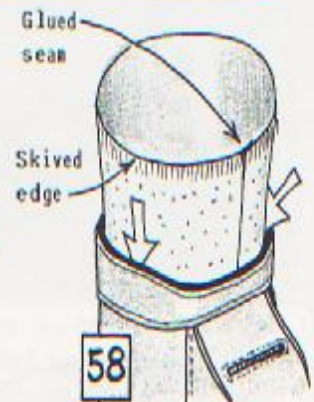


56 Cut two strips of lining leather and fold around inside the top and bottom to determine width to cut the lining. Mark the strips to identify Top (A), Bottom (B).



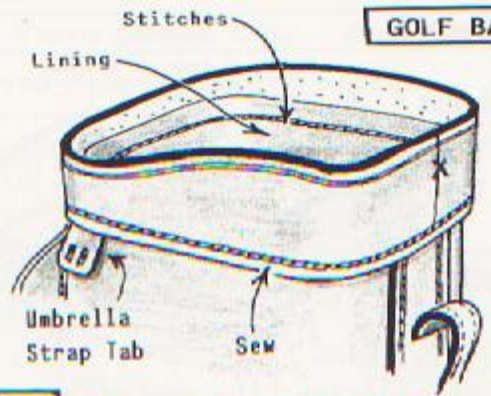
57 Cut out the lining from measurements taken in steps 55, 56...plus 1/2" at side.

LINING the BAG

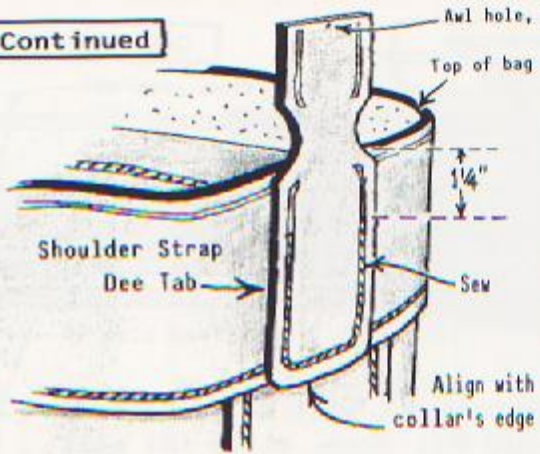


Now glue the lining together at sides; overlap 1/2". This forms a tube. Apply glue to about 2" of the top edge and to inside of the bag. While glue is still wet slip the lining into bag. Adhere in position. Stitching the collar secures the lining. Bottom hangs free.

GOLF BAG - Continued



59 After the lining has been glued in place, sew the bottom edge of the collar to the bag. Stitches secure Umbrella Tab and the lining, as well as the top of the large pocket.



60 Make the Shoulder Tab Dee, using the pattern at right. This covers the butt joint as well as the splice on the frame. It also aids in securing the dee (step 66). Glue it to the collar, centered above the Handle Support Strap (butt joint may be off-center). Sew to within 1/4" of the collar's top, as shown above. *DO NOT* sew to the top!



TAB for SHOULDER STRAP DEE
7/8oz. cowhide

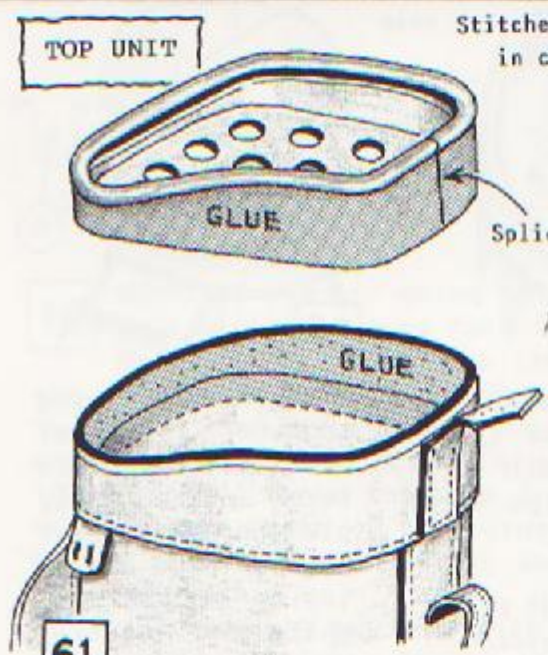
ACTUAL SIZE



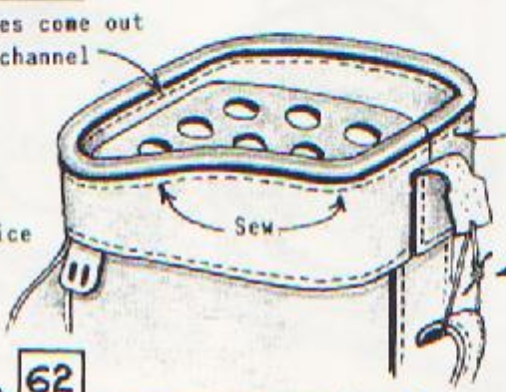
COMPLETED CONTAINER TOP

The photo at left shows the top unit ready for installing in the bag. Instructions for making this unit begin on the opposite page.

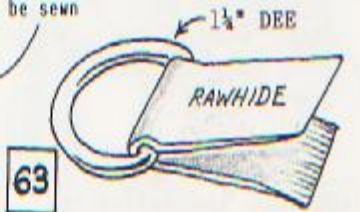
TOP UNIT



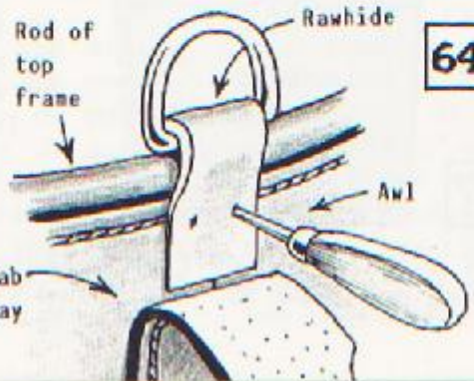
61 Apply glue to shaded areas. While wet, fit the top into the bag. The bag will shape to the frame.



62 Force the top inside the bag until the collar is snug against the rod. Let glue set then sew the top edge of the collar.



63 Cut a piece of heavy rawhide 1 1/4" x 4". Soak in water and skive the ends. Fold around a 1 1/4" solid dee, as above.



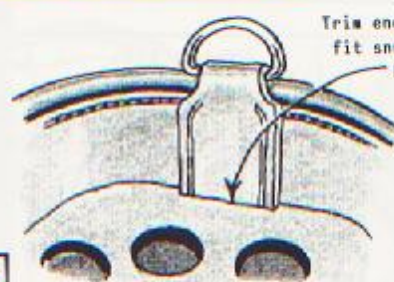
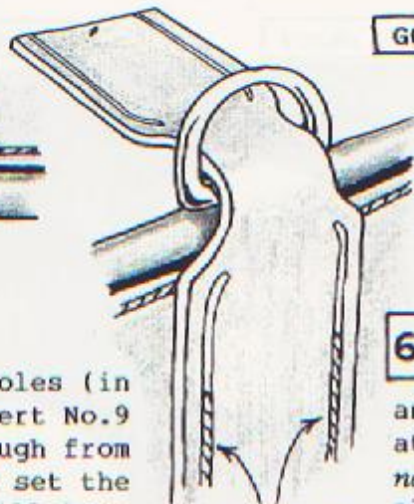
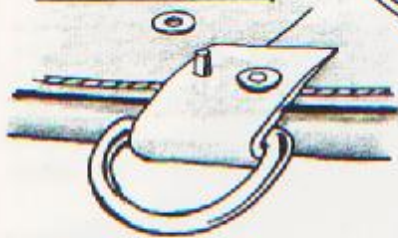
64 Fit the dee unit over the rod (center on dee tab) and pull rawhide down tight. Stab two holes through rawhide and all leathers for rivet positions. If the rawhide is too long at skived ends (at folded back dee tab), cut some off.

Fold the Dee Tab back, out of way

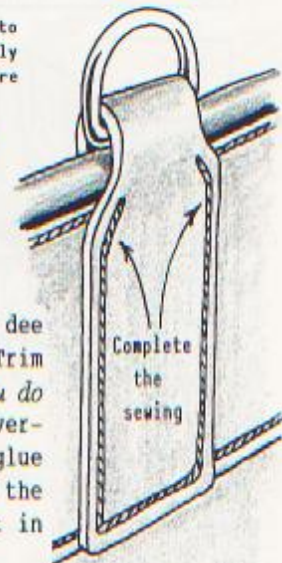
(continued)

INSIDE VIEW

GOLF BAG - Continued



Trim end to fit snugly here



65

Punch rivet holes (in awl marks) and insert No.9 copper rivets through from the front side. To set the rivets, the bag will have to be placed on the bench edge, with a slim riveting iron underneath.

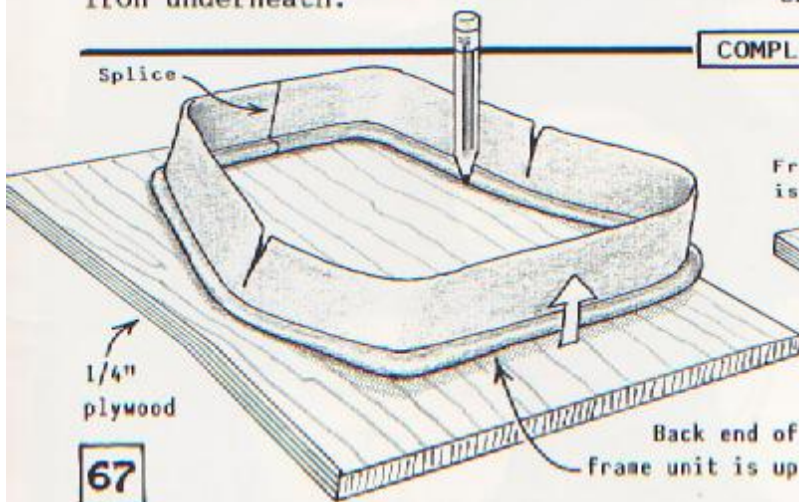
Stitching From step 60

66

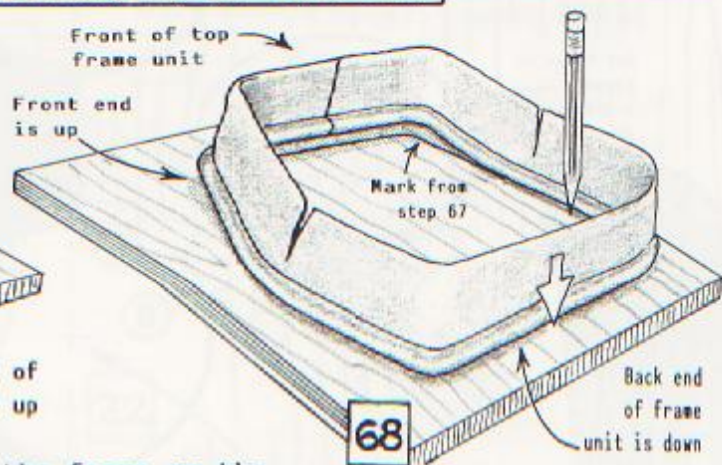
Push the Tab through the dee and fold tightly around it. Trim at the bottom. *Use care so you do not cut off too much!* Make several trimmings if needed. Then glue the Tab in place and complete the sewing. The stitches come out in the inside channels.

Complete the sewing

COMPLETING the TOP FRAME UNIT



67



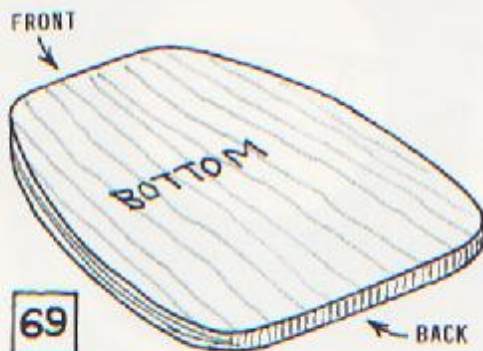
68

As with the bottom unit (page 104) place the frame on the plywood and draw inside it as before. Since the frame is bent, you must do this in two steps. First, hold the front down and draw around this area, up to the bends. Hold the pencil straight up. The back end will be off the plywood.

Now hold the back end down firmly and complete the pattern by drawing around it. *DO NOT let the frame slip!*

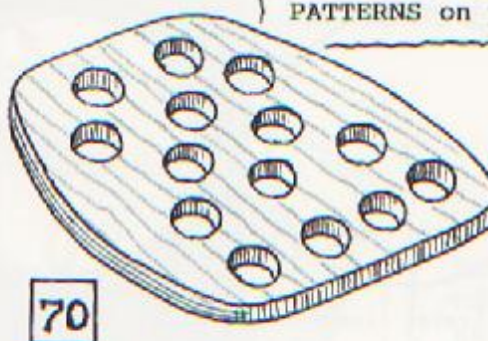
PATTERNS on page 110

Continued page 111



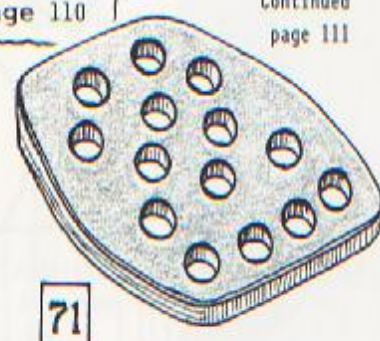
69

Cut out the plywood. There is no need to identify the ends, as the front is narrowest. Be sure to mark the bottom...as this side must be down, when installed in the frame.



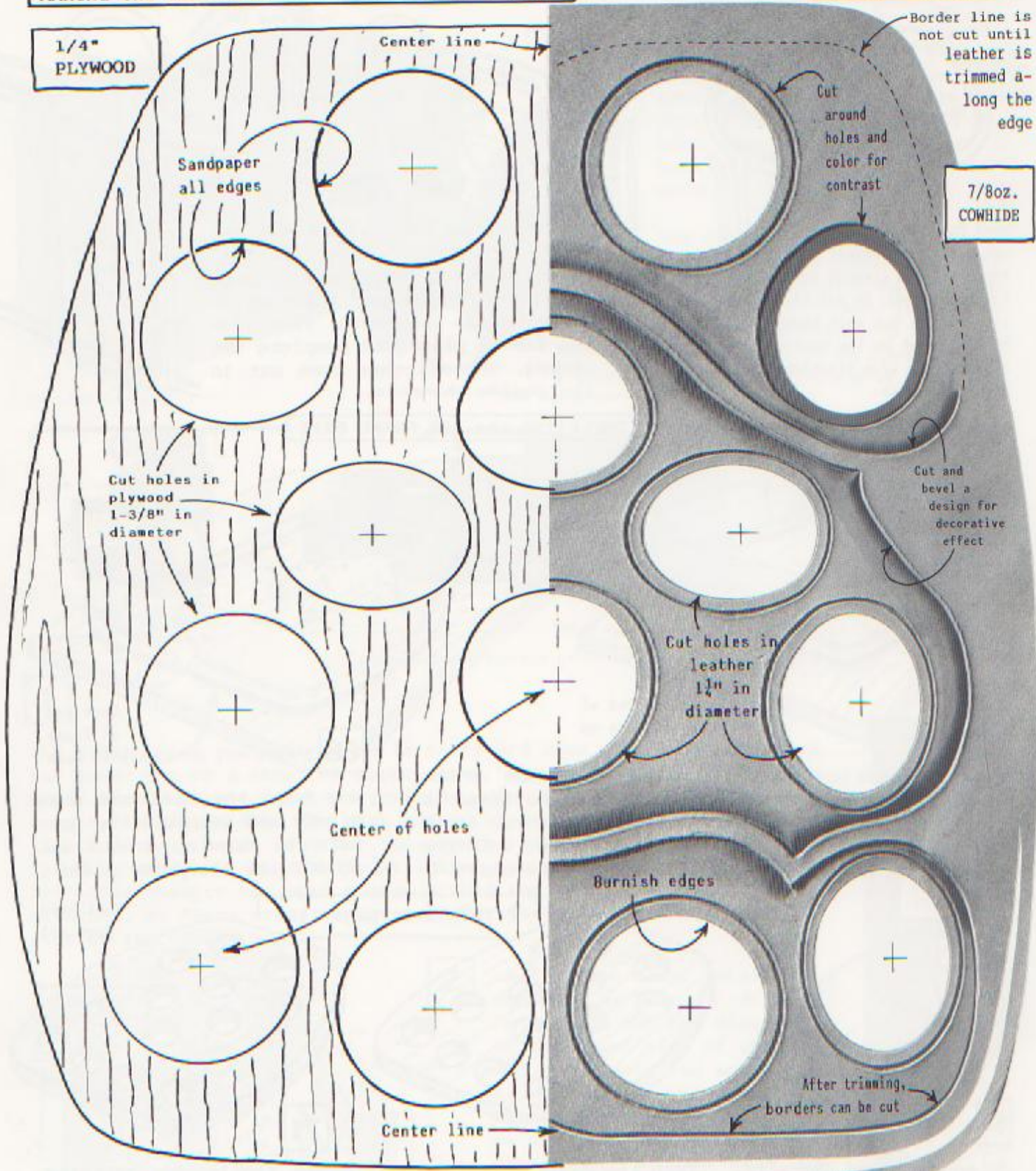
70

Turn the plywood over so the bottom side is down. Cut out holes, in proper locations. Sandpaper them smooth. Apply two or three coats of water resistant finish.



71

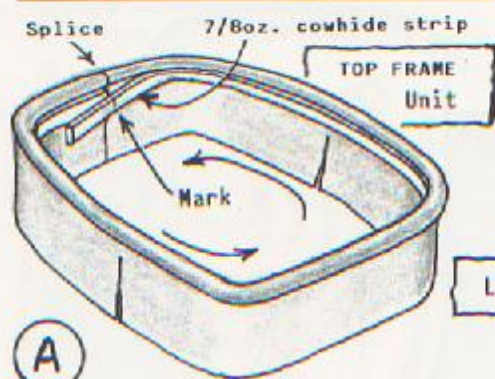
Cut the leather oversize. Cut out the holes; burnish their edges. Now put on leather finish. Glue to the plywood, centering over the holes.



After cutting out plywood (step 69), draw a center line on it. Transfer the pattern on this page to the plywood. Position the holes carefully (center marks); cut them out. Use your plywood as a pattern for

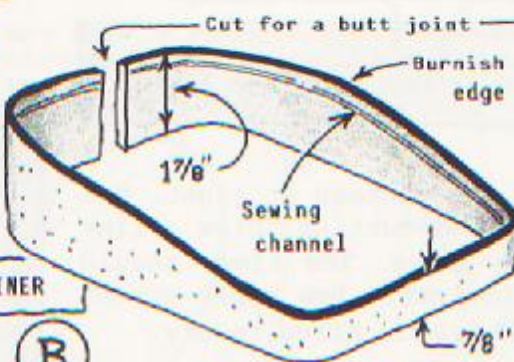
the leather. Cut the leather oversize as shown above. From a center line, mark all hole positions. After gluing to plywood (step 71), trim off the excess flush with the plywood.

COMPLETING the CONTAINER TOP



A

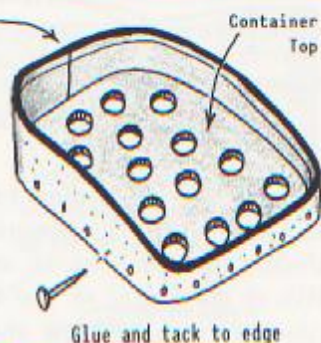
Now we need a liner for the top frame. This will be cut from 7/8oz. cowhide. Length is determined by using the strip *inside* the frame.



B

Cut the liner to the dimensions above. To fit curve of the frame, read instructions in step 53. Gouge a sewing channel at top edge; burnish.

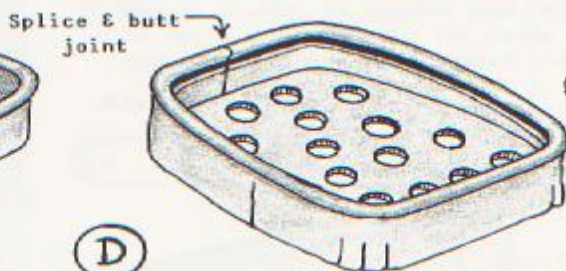
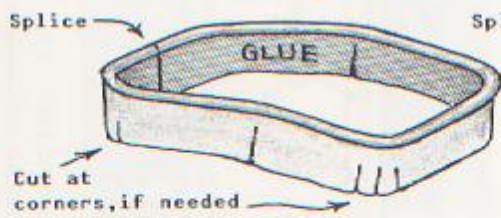
GOLF BAG - Continued



C

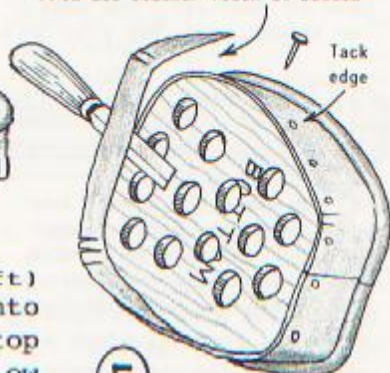
When properly fitted, glue the bottom edge of the liner to the container edge and nail to secure. Be sure the bottom edges are even.

Trim all leather flush at bottom



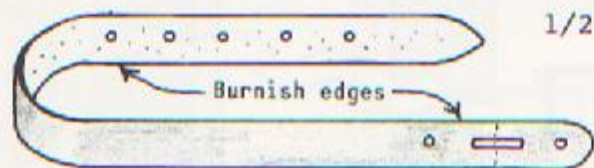
D

Apply glue to the parts (left) and push container unit up into the frame until the liner top is snug against the rod. Allow the glue to set.



E

The UMBRELLA STRAP TAB - Actual Size

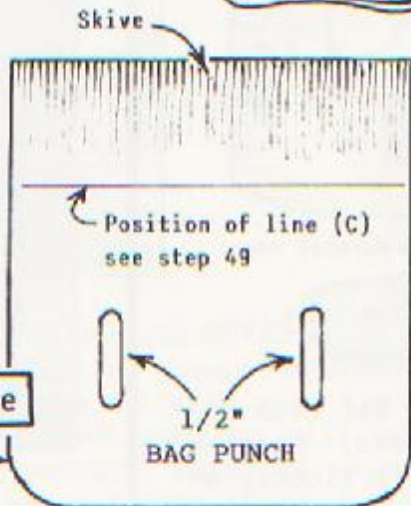


1/2" ROLLER BUCKLE



Cut a strap about 12" long by 1/2" wide, from 6oz. cowhide. Sew or rivet the buckle on.

Cut the Tab to dimensions at right. Skive end to a feather and punch the slots. Mark line (C) on the tab.



Cut from 6/7oz. cowhide

Burnish edge

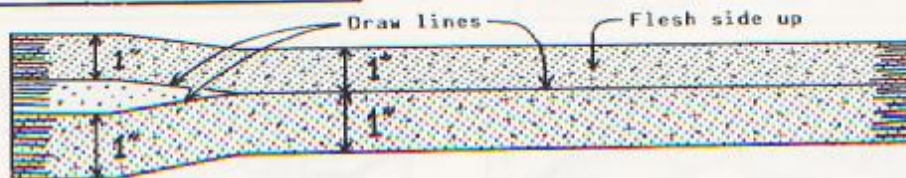
BAG PUNCH

Now cut off all of the frame cover leather flush with the plywood all around. Tack or screw all around the edge to secure the container. The photo below shows the complete unit. Turn to page 108 and follow steps 61-66 to complete the bag.

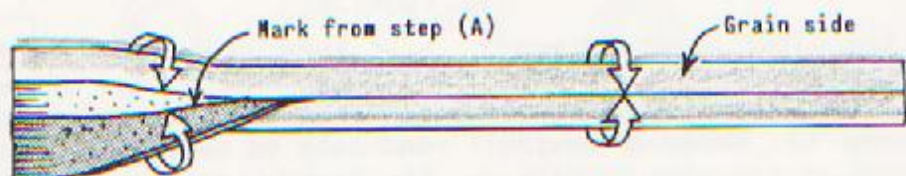


The CONTAINER TOP

GOLF BAG - Continued



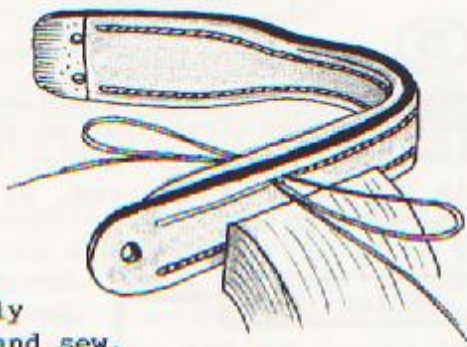
A Cut out the lining from the pattern at right. Use care with your measuring and cutting. Draw a line 1" in from each edge as shown above. The lines should join at the center of the narrow part. Now apply cement liberally to all of the shaded areas. Allow to dry.



B Fold sides in and adhere the edges at lines drawn in step (A). The edges abut on the center line of the narrow part. Tap flat with hammer for good bonding.

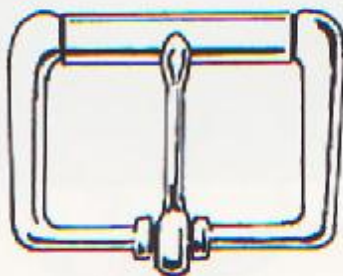
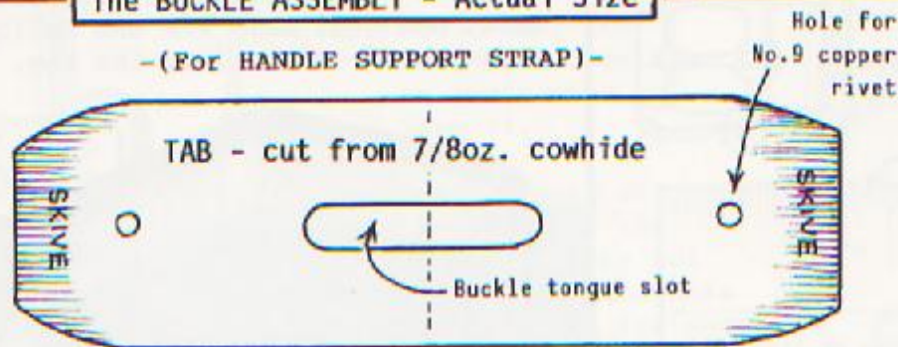


C Prepare the handle for assembly. Apply cement to the flesh side of handle and to the inside of lining and adhere the two together as above. Keep all edges in alignment. Tap with hammer.



D Clamp the Handle Assembly in the stitching horse and sew.

The BUCKLE ASSEMBLY - Actual Size

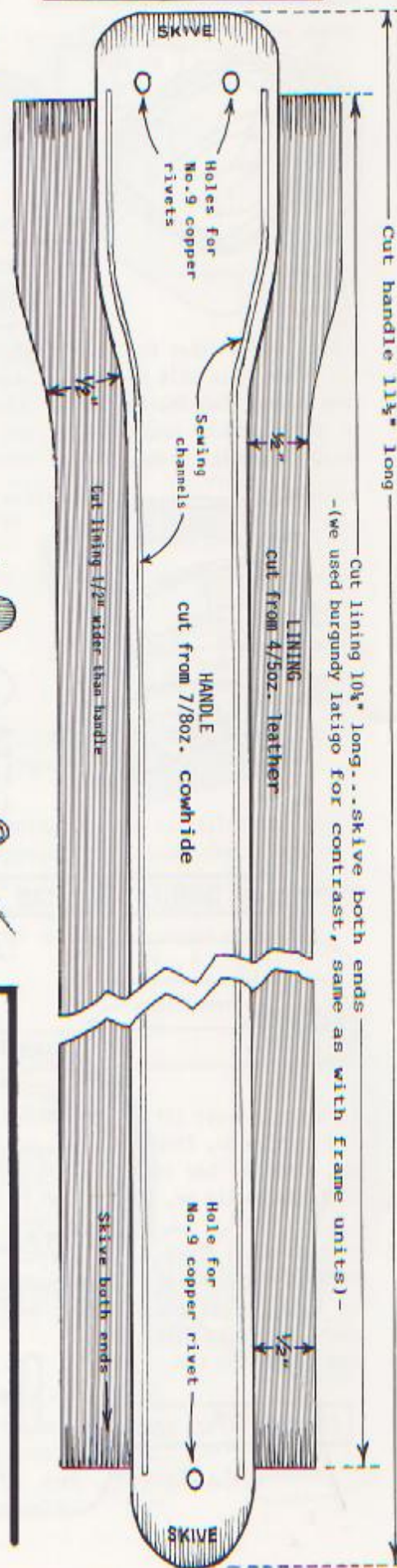


1 1/4" ROLLER BUCKLE



Prepare the Tab from notations above. Moisten fold and form tightly around buckle, then glue.

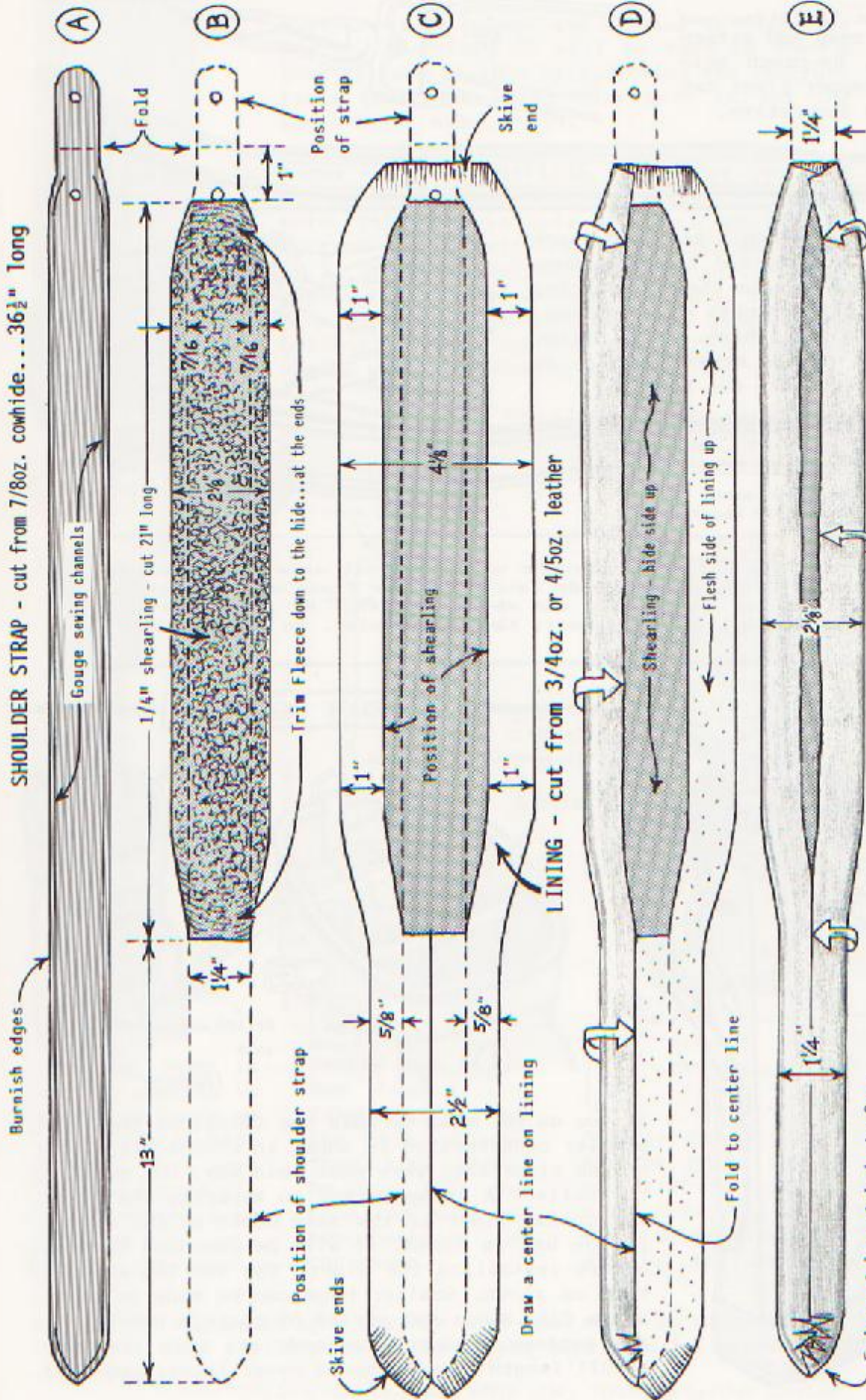
The HANDLE - Actual Size



Cut handle 1 1/2" long

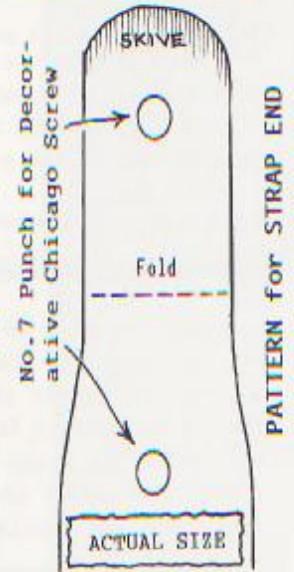
Cut lining 10 1/2" long...skive both ends
 -(we used burgundy latigo for contrast, same as with frame units)-

SHOULDER STRAP - cut from 7/8oz. cowhide...36 1/2" long



Ends must be notched, to form

ASSEMBLY PROCEDURES: Prepare the strap as indicated in step (A). Cut a piece of 1/4" shearling to the dimensions shown in step (B). Other materials could be used: 1/4" foam rubber or felt. Trim the ends as suggested. (C) make your pattern for the lining by drawing the positions of the strap and shearling on a sheet of paper. Increase the outside dimensions for the lining to the measurements given. (D) Cut out the lining, skive the ends. Draw the positions of the strap and shearling, on the flesh side. Draw a center line as indicated. Now glue the shearling in position, wool-side down. Apply cement to shearling (hide) and lining and begin adhering; folding the lining up. (E) Complete adhering as shown. Tap with a hammer to insure the bond. (continued)

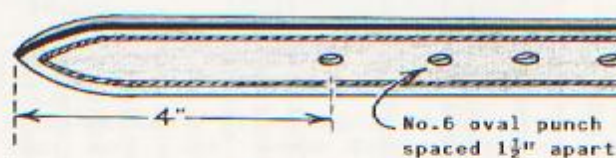
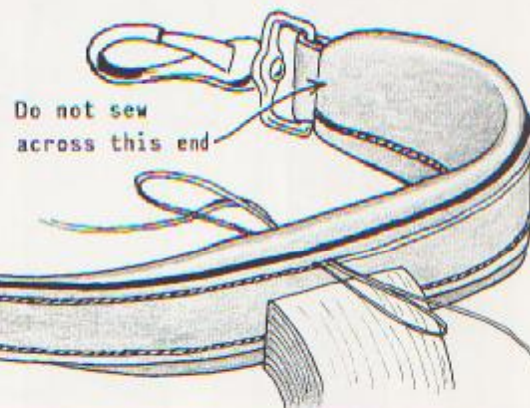


MAKING the SHOULDER STRAP - Continued

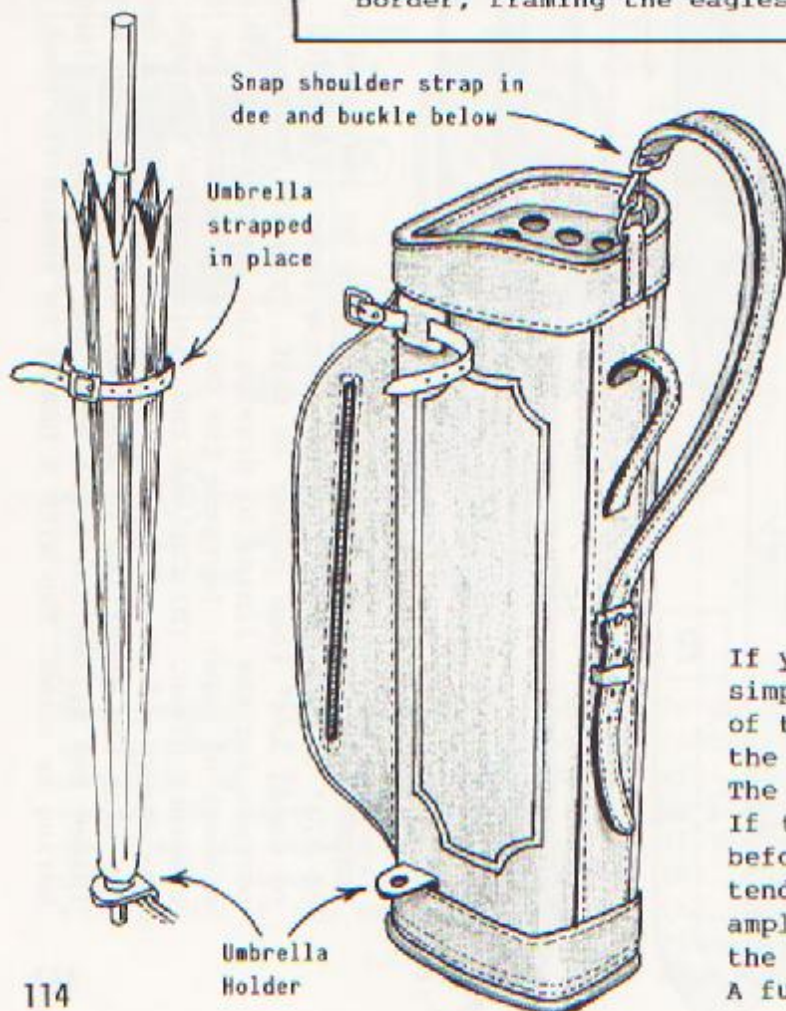
- F** After step (E) put the strap end through a swivel snap and attach with a chicago screw. Re-punch hole if necessary. A No.9 copper rivet can be used, but is not as decorative.



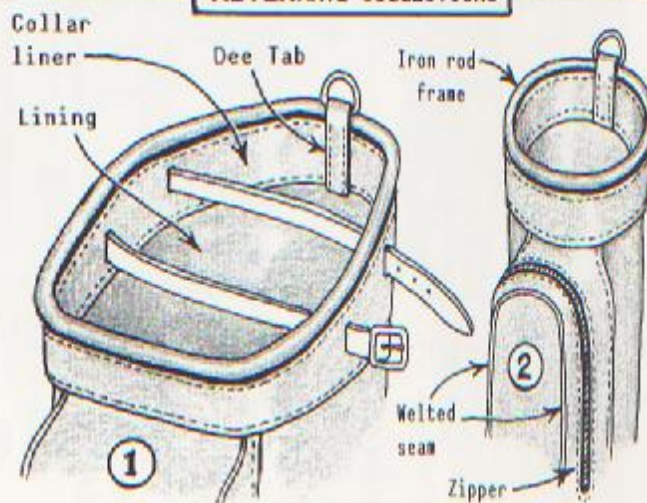
- G** Lay the strap on the padded lining and check the edges of the billet, and the tip. Some adjustments may be required (in the lining) for the tip to conform to the contours of the strap. Now cement the strap to the lining. Align billet sides. The padded area should extend equally at each side. Sew together...punch the holes.



Notice how the color photographs on the covers show the pleasing contrast by using the burgundy latigo for the frame covers, welts, and linings for the handle and shoulder strap. We also dyed the border, framing the eagles, with this same color. *Be imaginative!*



ALTERNATE SUGGESTIONS



If you do not wish to make the Container Top, much simpler construction is shown in example (1). Most of the older bags were made this way. Cut slots in the collar. A strap serves to separate the clubs. The collar liner is the same depth as the collar. If the bag is lined, it will be cemented in place before installing the liner. The Dee Tab will extend as shown. Smaller bags can be made as in example (2). Sizes and styles of pockets can vary to the extreme. Assembly methods are much the same. A full length pocket should cover laces; page 103.

(continued from page 2)

BURNISHING EDGES:

"CASES"- Vol.I, page 12. Also "TOOLS", page 69.

GLUE and CEMENT:

"CASES"- Vol.II, page 26. The terms are used to save space in our copy. Vol.II explains the differences in the two.

OILING:

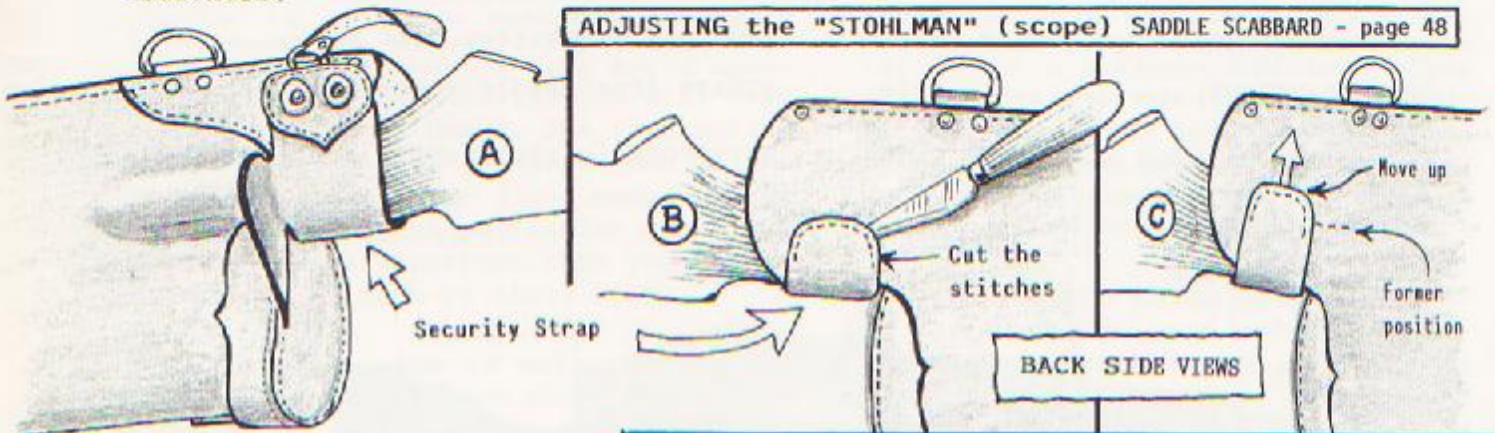
"CASES"- Vol.I, page 120. Not too much has been said about oiling leather. Vol.I should help you in determining when and how much oil to use. Gun scabbards (especially saddle scabbards) and other leather cases that are subjected to a lot of outdoor use in varied weather, should periodically be oiled. "COLORING LEATHER", page 49, also includes information on oiling and other leather conditioners.



Ann Stohleman sewing the miter joint on the lid of the guitar case.

All of the cases in this book were completely sewn by hand...all by Ann! When sewing on large or bulky projects, you have to get yourself in the most comfortable position by whatever means is at your command. Use any props that are necessary (as with the chair above).

ADJUSTING the "STOHLMAN" (scope) SADDLE SCABBARD - page 48



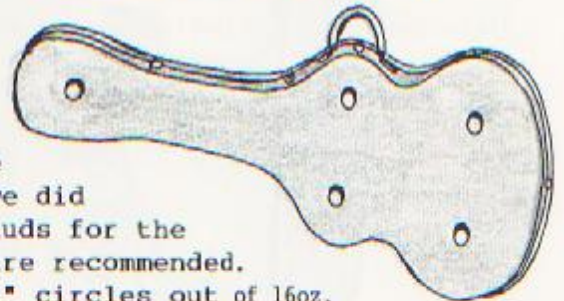
When using saddle scabbards in rough country for long periods of time in troublesome weather (especially soaking rain), the leather will stretch. If your Security Strap (A) stretches, it may allow the scope to ride on the leather. This is simple to correct.

Cut the strap loose (B) on the back side. Remove the severed threads from the holes. Fold the strap tightly around the stock (C); mark position. Follow step 22, page 57. Re-sew.

ADDING STUDS to the BOTTOM of the GUITAR CASE

In our instructions for making the guitar case, we did not mention studs for the bottom. Five are recommended.

We punched 3/4" circles out of 16oz. cowhide and glued them in place. If you use metal studs, they must be put in the bottom (step 7 page 81) before it is glued to the stiffener. Metal studs make it more difficult to assemble the case, especially when fitting the side pieces. Leather studs will not mar furniture surfaces.



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Handle No.4



This is another version of the Video Camera Case on page 8. It differs in the end construction, as in the sketch on page 10, step 9. The ends are not mitered, as with the case on page 8.



Colored views of most of the rifle scabbards and gun cases in this book.

The first Stohlman designed scabbard for carrying scope upside down.





