

Work Sheet for repairs/upgrades

updated 02/01/16

NO RETURNS or EXCHANGES - All work is considered out of manufacturer warrantee

Finished pair of panels: Come assembled, backer and foam layers.	Retail Price	Quantity	Total
22.77" panels (11.5 to 12" inside mounting)	\$500.00		
23.77" panels (12.5 to 13" inside mounting)	\$500.00		
24.77" panels (13.5 to 14" inside mounting)	\$500.00		
25.77" panels (14.5 to 15" inside mounting)	\$500.00		
Mounting Parts			
SS Bolt @ (need 4)	\$.90 = \$3.60		
Insert @ (need 4)	\$26.00 = \$104.00		
Long insert – each at	\$27.00		
SS & bronze Washer @ (need 8)	\$4.25 = \$34.00		
Stirrup Hanger Bar (pr.)	\$50.00		
Encasement (Pr.) for panels that will not be inserted into a saddle's skirting	\$100.00		
Using your western skirt new fleece and filler	\$150.00		
New leather skirt complete– no tooling	\$300.00		
Tooling:			
Slide and lock rigging	\$30.00		
Off billet	\$20.00		
Latigo	\$30.00		
Girth keeper	\$5.00		
Latigo Keeper	\$5.00		
Performance rigging	\$80.00		
Billets one pair.	\$50.00		
Rigging protector flap - pair	\$30.00		
Saddle Sox –synthetic	\$150.00		
Saddle Sox –Merino wool	\$250.00		
Blocking: each at	\$30.00		
New Seat (+ for cantle binding)	\$400.00 +		
New Flaps (No blocking) or Fenders (pair)	\$350.00		
Stirrup hobbles	\$20.00		
Pair of Blevins buckles	\$25.00		
New Skirts/flaps – with blocking	\$500.00		
Hardware: Dee's – Rings - pair	\$5.00		
Strings- Pair	\$20.00		
Safety Inspection:	\$50.00		
Rivet Replacement -one side only.	\$50.00		
Spring Steel Ware Plate – one side with rivets (ware plate alone \$45.00)	75.00		
One side only re-work existing panel includes sanding minor layer replacement – including rivets.	\$75.00		
Over Haul: Includes safety inspection, cleaning, re-dieing, oiling, conditioning and luster shine/waxing. (Includes rivet replacement)	\$150.00		
LABOR @ \$60 per hour			
Cleaning	\$50.00		
MISC.			
Name/Address/contact numbers:	Sub Total		
	Shipping		
		tax/ra#	
		Grand Total	

What size panel will fit on what size saddle? TO BE USED AS A GUIDE LINE ONLY.

Western Saddles with 20 to 21 inch bars for seat sizes 14 to 15 inch require 22.77-inch panels; saddles with 21.5 to 22-inch bars for seat sizes 16 use 23.77 inch panels and saddles with bars over 22.5 use 24.77inch panels. Bars longer than 23 inches or seat sizes over 18-inch require 25.77-inch panels.

Endurance Saddles (saddles with a fork but no horn): that have 20 inch bars for seat sizes 14 to 15 inch require 22.77 inch panels. Saddles with 21 to 22 inch bars (seat sizes 16 to 17 inches) require 23.77 and 24.77 panels. Bars over 23 inches as with seat sizes 18 and over require 25.77.

English Saddles with 20-inch bars for seat sizes 16 to 17.5 require 23.77-inch panels. Bars longer than 21 inches require panels 24.77 inches.

Cutback Saddles with 20-inch bars for 16 to 17.5 inch seats require 22.77-inch panels. 21-inch bars and 18.5 inch seat sizes and over require 23.77 panels.

CONFIRM FIT by checking your saddletree: below by each panel size is length on the bar for the mounting spacing. This spacing must line up to the saddle's pommel/fork and cantle for attachment. Also note that the saddles gullet must be wide enough for the proper spacing between the panels. So between the front inserts on western and endurance saddles this must be 9 inches and on an English saddle this is 8.4. Remember – the panel function is ONLY as good as the saddletree to which they are mounted. Panels cannot be put on inferior soft wood trees, nylon or ralide trees, crooked trees, treeless saddles etc., and remember that traditional saddletrees ARE NOT designed to fit the panels but to fit a horse's back so bare this in mind when deciding to purchase panels.

DRILLING to put in INSERTS: Use a 9/16th inch drill bit for inserts. - You may have to drill out and plug old hole with hard wood dowel and glue. Then re-drill.

THE SADDLE TREE: The saddletree must be of strong wood. The gullet and flair opening must be wide enough to accommodate the spacing of the panels – any tree originally designed for panels will be sufficient. Center panels on tree.

TO MOUNT THE PANEL: The spacing; on encased panels, space panels so that there is a no less than a one-inch gap between front panels when panels are flattened out. On western panels that have a skirt, this gap cannot be any closer than ½ inch. To get this spacing use the following spacing as a rule. Western and endurance trees the front spacing should be 9 inches between front inserts and the rear is 8". For all English trees front spacing between the front inserts should be 8.5 to 9 inches (for cutback models use smaller measurement) and 8 inches for the rear. On the bar; position the inserts on the same side so as the rear insert will position the panels bolt to the front ¼ of the slot in the panel. This way the panel can dip and move in the slot to allow the panel to conform to the sway in the horse's back. The following spacing is to be used as a guide for drilling the inserts: For 25.77-inch panels space inserts 14.5 to 15 inches apart on center; 24.77 inch panels space inserts 13.5 to 14 inches apart on center; 23.77 inch panels space inserts 12.5 to 13 inches apart on center; 22.77 inch panels space inserts 11.5 to 12 inches apart on center.

TO PUT ON THE PANEL: Using a 3/16 Allen key find the hole in the panel. Starting with the rear mount *first*. Place the washer onto the bolt so that the beveled edge is toward the insert and the smooth side of the washer is next to the panel slide. Put two drops of "Loctite Red ®." into the insert (female end) and CAREFULLY screw in the bolt – so that you start correctly. Continue to screw down tightly while wriggling the panel as to lock down the washer over the domed top of the insert. Then BACK OUT *the bolt ½ turn (with Evolutionary saddle tree) to ¾ of a revolution for other trees*. Repeat this procedure for the front mounts. Go by feel, as these are guidelines making sure each side moves equally. You want the panels to move freely but not sloppily. This is the proper setting for the system X panel.

TO REMOVE THE PANEL: Starting with the FRONT mount first insert your Allen key into the panel under where the pedestal is located and carefully unscrew the bolt from the mount. You may need to hold the mount with 3/4 inch hex nut wrench or pliers while turning with the Allen key to break the locktight - This will be hard and you may need a helper to hold the wrench steady. Be careful not to damage the threads on the mount and do not lose any of the washers. You may hear a loud crack or pop, this indicates that the "Loctite Red ®" bond has been broken. Please note that the washers are beveled and the beveled side must be against the cone part of the insert-mount. Then repeat this process for the rear mounts sliding the panel so that the Allen key lined up with the mount.

TO REMOVE (or put on) ENCASEMENTS ON THE ENCASED PANELS: Unzip and fold panel nearly in half so that the zipper area is on the outside of the bent curve. Starting with the large end of the panel slide off one side and then the other of the encasement. To put back on the encasement, slide the small end of the panel in the encasement and then fold panel away from you and slide the large side of the panel in, working each side of the encasement until the panel is in, making sure all fingers with foam rubber are in place. Zipper shut.

Mounting of panels to saddle tree

