

FLOR

PRODUCT CATALOG

Saddle Tree Company

Serving The Saddle Industry For Over 100 Years



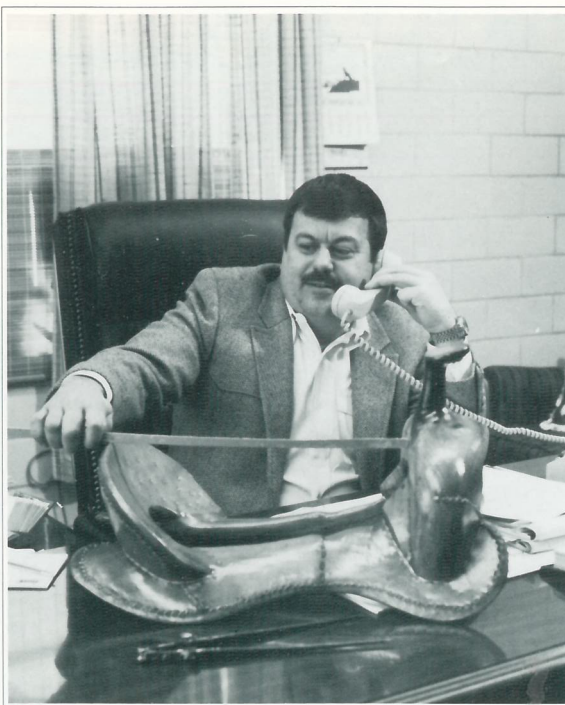
FLOR Saddle Tree Company

A MESSAGE FROM THE GENERAL MANAGER...

Dear Saddlemaker:

Flor Saddle Tree Company, Inc. (formerly the Edward Flor Company) was established in Demorest, Georgia in 1879. Having been in this community for well over one hundred years, Flor Saddle Tree has developed a dedicated and experienced work force. Many of our current employees are third and fourth generation saddle tree craftsmen. At their disposal are some seven hundred different saddle tree patterns.

This catalog contains some of the most popular styles of trees currently being manufactured at Flor Saddle Tree Company. Additionally, Flor has the flexibility to alter these existing patterns to suit your particular needs, and to create totally new saddle tree designs



for our customers as styles change within the industry.

Flor Saddle Tree Company has recently acquired Ruwart-Simpson Saddle Tree Company of West Yellowstone, Montana. The combining of these two well established firms certainly gives Flor Saddle Tree Company the broadest base of knowledge and experience in saddle tree manufacturing in the industry.

Flor quality is second to none. This enables us to assure each saddle maker total satisfaction with all Flor Products.

If I may assist you in any way with your saddle manufacturing needs, please feel free to call.

Sincerely,

—HISTORY of FLOR SADDLE TREE COMPANY—

Founder, Edward Flor, emigrated from Germany in 1866 and settled in Indianapolis, Indiana. Trained as a musician, he was not able to find a position in this field and began making saddles—first in Atlanta and then in Buford, Georgia, where he worked for the Bona Allen Company.

Mr. Flor was later transferred to the saddle tree shop where solid blocks of wood were hand shaped into forms for the leather craftsmen to use. Around 1879, Mr. Flor developed the system of saddle tree parts (bars, swell and cantle) that is in use today. Soon after this, Mr. Flor went on his own and established the Edward Flor Saddle Tree Company in Demorest, Georgia, near the site presently in use. The city of Demorest granted the new company 160

acres for this operation, which included a large stand of virgin timber. In 1883 Flor sold only to Bona Allen, but soon began selling trees to other saddle manufacturers starting up in the Chattanooga, Tennessee area at that time.

Flor's son, Oscar, joined the firm in 1905, which, by this time, had grown to be the largest saddle tree manufacturer in the country. The elder Flor died in 1921, and the son continued the building.

Oscar had two daughters and a niece (who married a Mr. Frank Nelms—Nelms joined the business in 1948). The three ladies actually owned the business, hiring Mr. Nelms to run it for them. This arrangement did not prove successful, and the

ladies closed the business for a short time in 1972. At this time, Wofford Saddle Co. was their largest customer; Wofford decided to operate Flor Saddle Tree under a lease arrangement with the Flor heirs.

In 1975, Joe Barefoot came to work for Wofford as Sales Manager, soon transferring to the saddle tree operation as General Manager. He expanded the business and regained its position as a major supplier to the many saddle manufacturers in the industry.

In 1978, Barefoot bought the building and land from the original Flor heirs, and ran the business until selling it to P.I. Inc. of Athens, Tennessee in July of 1987.

FLOR Saddle Tree Company

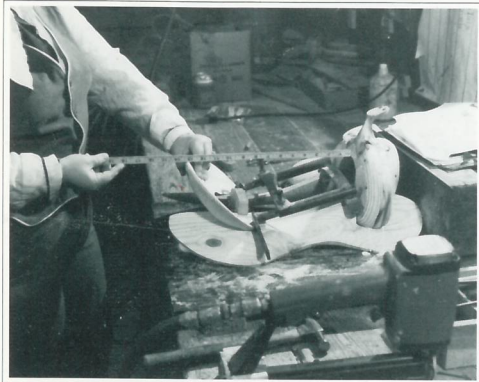
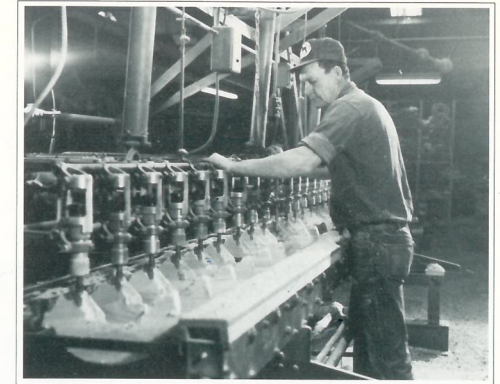


HIGH SPEED DUPLICATING

The high speed Zuckermann duplicating lathe turns out perfect bars from precision masters and patterns. A minimum amount of hand work is required on parts produced on this unique machine.

SPINDLE CARVING

We have two 18 inch spindle carving machines which are used for the manufacture of swells and cantles. These carvers will faithfully duplicate the master pattern being used.

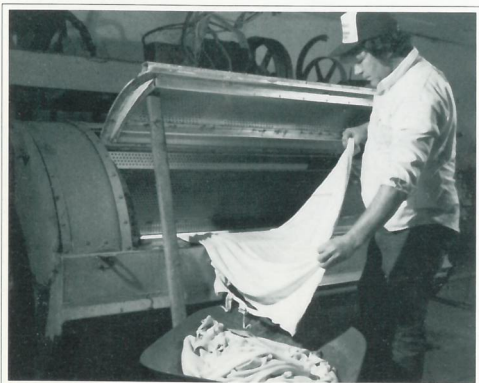
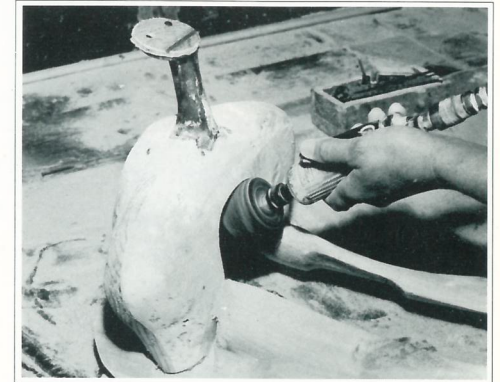


SPECIAL JIG ASSEMBLY

After sanding and inspecting each part carefully, the tree is assembled on a special jig to insure correct dimensions and customer specifications. Horns are installed with rivets which run through the fork and into a formed plate on the bottom of the gullet.

SANDING, SEALING & COVERING

Prior to covering, each tree is hand sanded and inspected to insure smooth joints in areas where the rawhide must fit perfectly. Trees are dipped in a special solution which seals the wood and provides a foundation for the rawhide application.



QUALITY PROCESSED HIDES

All hides are processed at Flor's plant to insure quality and consistency, using only first class hides in various weights, depending on the type of tree being covered.

STITCHING & VARNISHING

Stitching is done by experienced workers, many having been with the company for over twenty years. Finished trees are air dried and then varnished according to customer specification.



FLOR Saddle Tree Company

All Flor horns are installed with four rivets that go through the swell and into a special, formed plate on the bottom of the gullet. Additional screws are used on working saddles to insure a strong attachment of the horn to the swell.

All horns shown on trees in this catalog are installed in their normal way for that particular

style of tree. We can, however, give you any degree of tilt that you may require.

Rawhide braiding is available on special order.

In addition to the eleven styles of horns shown on this page, we can also provide any of the fifteen styles available from our Ruwart-Simpson custom saddle tree division.

HORN STYLES AVAILABLE

If you would like a Ruwart-Simpson catalog for your custom needs, please let us know.

All Flor and Ruwart-Simpson horns are cast to our quality specifications from high tensile, malleable iron—the best metal for saddle horns.



	<p>#2 Pelican H = 3" C = 2-3/4"</p>	<p>#211 Post Roper H = 4" C = 2-1/4"</p>	<p>#791 Special Roper H = 3" C = 2"</p>
<p>#8 Western Pleasure H = 3-1/4" C = 2-1/4"</p>	<p>#300 Extra Tall Cutting H = 4-3/4" C = 1-3/8"</p>	<p>Dally H = 3" C = 2-1/4"</p>	<p>#787 Short Post H = 3-1/4" C = 2-1/2"</p>
<p>#30 Cutter H = 3-1/4" C = 1-3/4"</p>	<p>High Mex H = 4" C = 2-5/8"</p>	<p>F-10 Boy Horn H = 3" C = 1-3/4"</p>	<p>#100-F Straight Tall Cutter H = 4-1/4" C = 1-1/2"</p>

FLOR Saddle Tree Company

All of the trees shown in this catalog are standard styles, available to all customers, and can usually be produced and shipped within 3-4 weeks. We have listed the horn used, seat lengths and cantle heights normally available—so you can get an idea of scale and proportion from the photo.

We can install any of the horns shown on page 2 on any tree, and will position the horn to your specification (again, we have listed the

horn used in the photo).

Seat lengths listed by the photo are normal for the particular style of tree and its intended use. Usual cantle height is also indicated, but both of these dimensions may be changed if you wish. Extreme variations from our normal sizes might result in added costs, and will take longer to produce than the stock sizes. For example, longer seat lengths require longer bars to maintain correct proportion and pro-

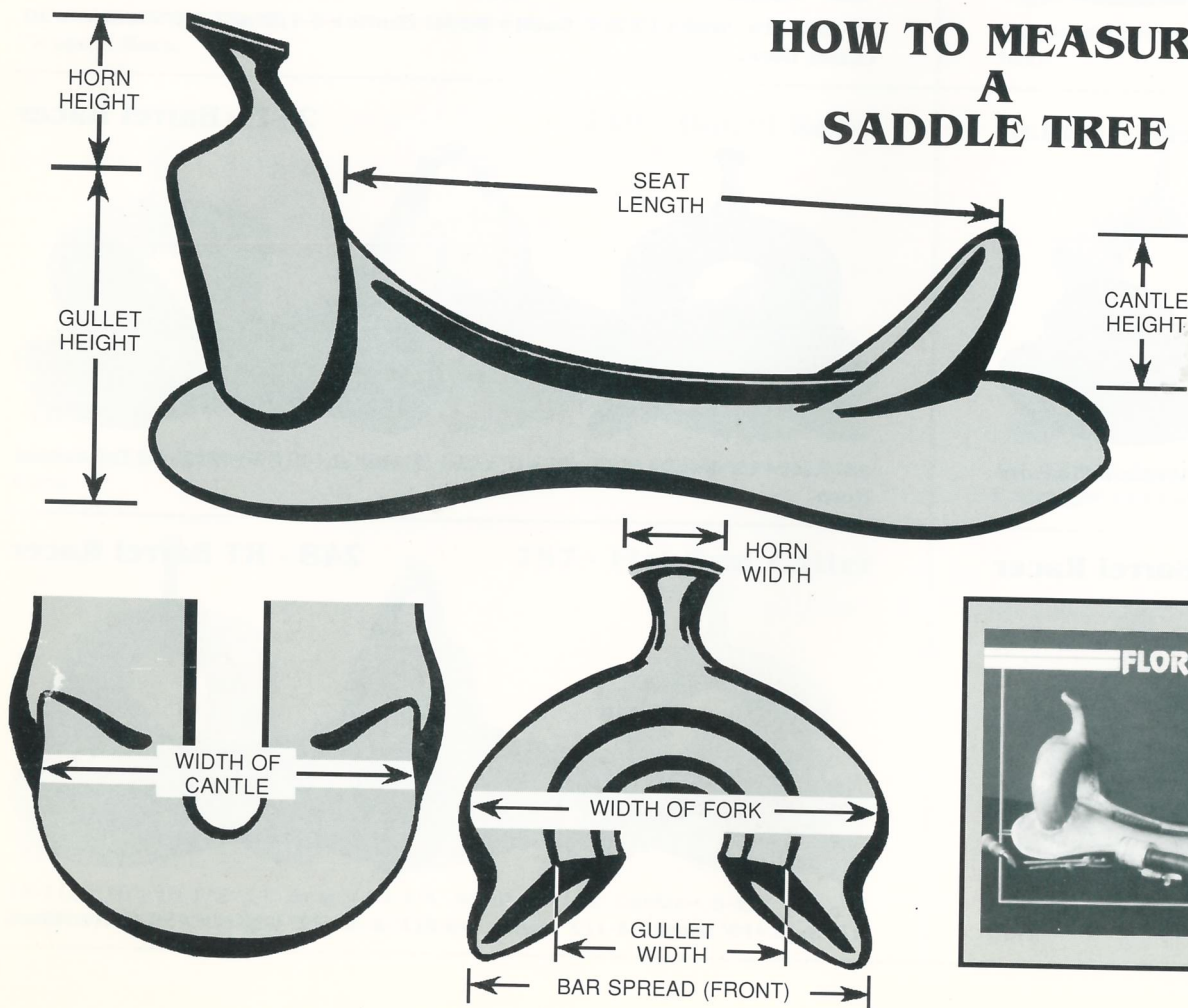
SELECTING YOUR SADDLE TREE

vide enough material behind the cantle to attach rigging.

Trees have been grouped according to their design and intended use. We will build any tree you require, and can usually meet any particular specification you might need. We will not, however, build a tree that, in our opinion, will not provide the end-use customer with a dependable and satisfactory product.

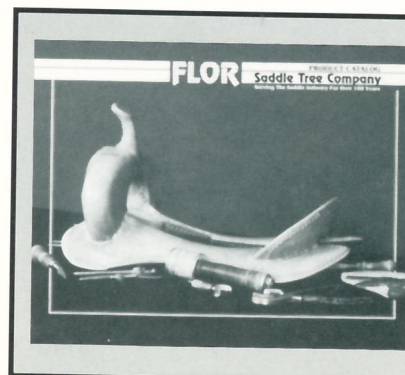


HOW TO MEASURE A SADDLE TREE



Any of our full size adult trees can be ordered with from 14" to 16-1/2" seats in 1/2" increments. Kids' pony trees normally are from 10" to 13"; however, we have built special trees as small as 8".

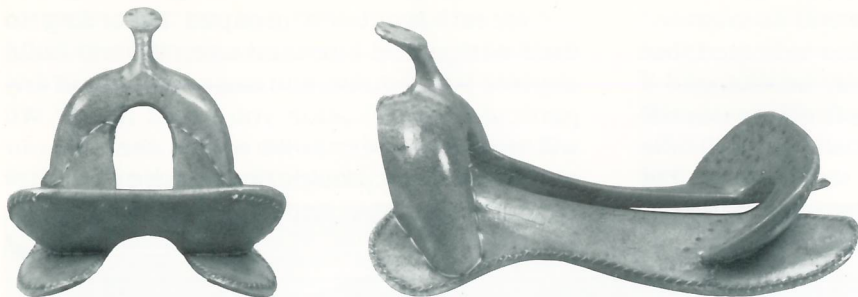
Today, it is fairly common to get requests for saddles with up to 18" seat length, especially from some of the cutting horse people. Anything over 16-1/2" usually requires special longer bars to keep the tree in proportion—for this reason, we make a small price increase for these longer lengths. Bear in mind that special consideration must be given when building saddles with extra long seat lengths, so that the horse's back can handle the oversize bars.



ABOUT THE COVER

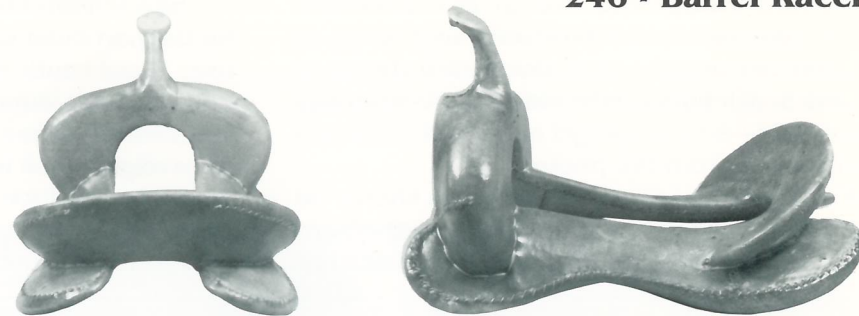
The tree on the cover of this catalog is a new High Front Cutter. Seat lengths available are 15-1/2" to 17-1/2" with a 12" swell, 3-1/2" cantle and 6-1/4" x 7-1/2" gullet. #300 Extra Tall Cutting Horn. This tree was designed by one of the top reining horse competitors in the country.

1561 - Flor Arabian



15", 16" Seat • 9-1/2" Swell • 2-1/4", 3-1/4" Cantle • 6-1/2", 7" Gullet • #8 Western Pleasure Horn.

246 - Barrel Racer



13-1/2", 14" Seat • 12-3/4" Swell • 3-1/4" Cantle • 6-1/2" x 7-1/2" Gullet • #30 Cutter Horn.

1562 - Modern Arabian



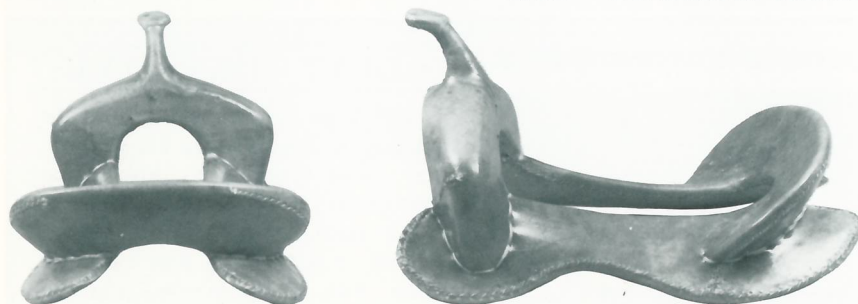
15" Seat • 9" Swell • 2-1/2", 3" Cantle • 6-1/2" x 7" Gullet • #8 Western Pleasure Horn.

247 - Barrel Racer



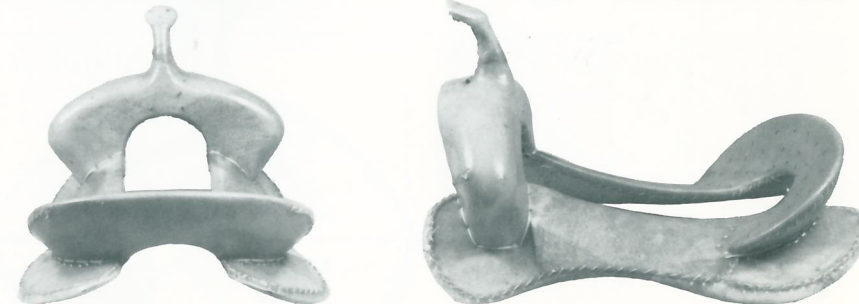
14" Seat • 12" Swell • 4" Cantle • 6" x 7-1/4" Gullet • #100-F Straight Tall Cutter Horn.

245 - CC Barrel Racer



14" Seat • 12-1/2" Swell • 3-1/2" Cantle • 6-1/4" x 7-3/4" Gullet • #30 Cutter Horn.

248 - RT Barrel Racer



14" Seat • 13" Swell • 3-1/2" Cantle • 6-1/2" x 7-1/2" Gullet • #30 Cutter Horn.

MOST POPULAR TREE STYLES

235 - Flor Barrel Racer



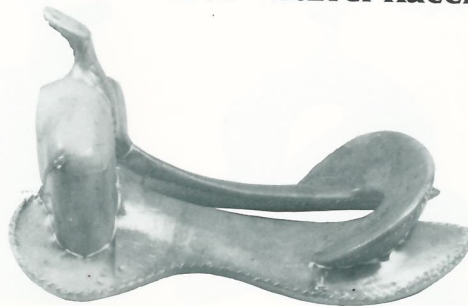
14" Seat • 12-1/4" Swell • 3-1/2", 4" Cantle • 6" x 7-1/4" Gullet • #8 Western Pleasure Horn.

**721 - Cutting/
Performance**



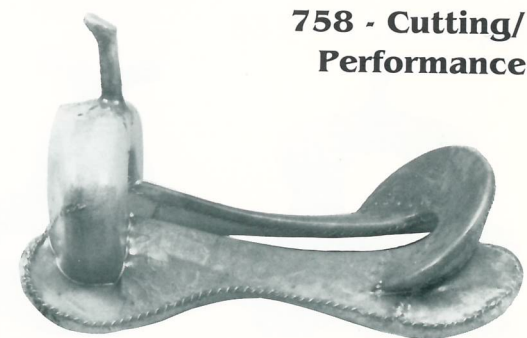
15", 16" Seat • 13" Swell • 3-1/2" Cantle • 6-1/2" x 8-1/2" Gullet • #211 Post Roper Horn.

249 - Barrel Racer



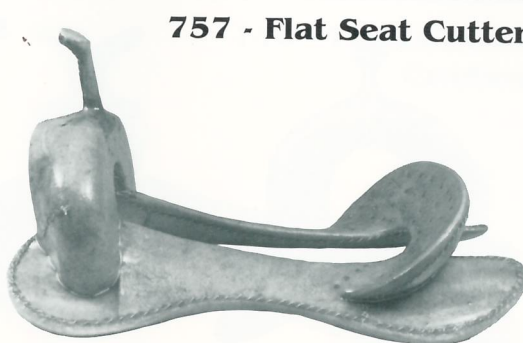
14" Seat • 12-1/2" Swell • 3-3/4" Cantle • 6 x 7-1/2" Gullet • #8 Western Pleasure Horn.

**758 - Cutting/
Performance**



16", 16-1/2" Seat • 12-3/4" Swell • 3-1/2" Cantle • 6-1/2" x 8-1/2" Gullet • #100-F Straight Tall Cutter Horn.

757 - Flat Seat Cutter



15-1/2", 16", 16-1/2" 17" Seat • 12-3/4" Swell • 3-1/2" Cantle • 6-1/4" x 7 3/4" Gullet • #100-F Straight Tall Cutter Horn.

990 - Pleasure



15" Seat • 13" Swell • 3-1/4" Cantle • 6-1/2" x 8" Gullet • #8 Western Pleasure Horn.

790 - Back Yard Special



15" Seat • 12" Swell • 3" Cantle • 6-1/2" x 7-1/4" Gullet • #F-10 Boy Horn.

802 - Saginaw



15", 16", 16-1/2" Seat • 12-1/2" Swell • 3-1/2" Cantle • 6"x7-1/2" Gullet • #8 Western Pleasure Horn.

791 - Pleasure



15" Seat • 12" Swell • 3" Cantle • 6-1/2" x 7-1/4" Gullet • #F-10 Boy Horn.

450 - Western Pleasure Special



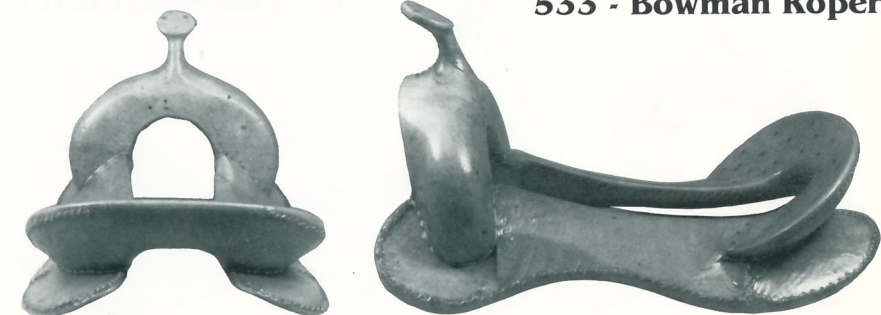
14", 14-1/2", 15", 15-1/2", 16" Seat • 12-1/4" Swell • 3", 3-1/2", 4" Cantle • 6" x 7-3/4" Gullet • #8 Western Pleasure Horn.

699 - California Western Pleasure



15" Seat • 12-1/2" Swell • 3-1/2", 4" Cantle • 6-1/2" x 8" Gullet • #8 Western Pleasure Horn.

533 - Bowman Roper



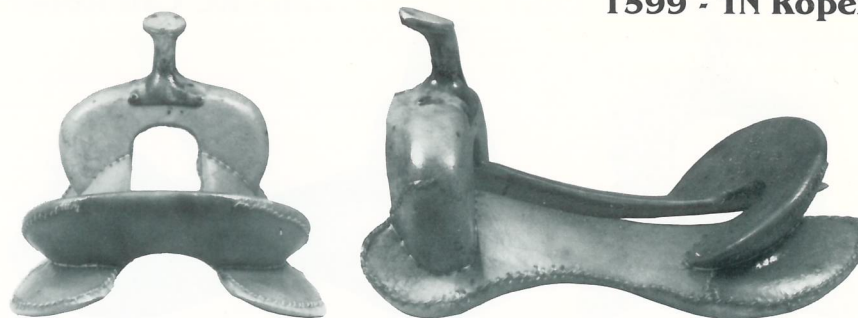
15", 16" Seat • 12", 13" Swell • 3-1/2" Cantle • 6-1/2" x 8-1/4" Gullet • #211 Post Roper Horn.

555 - Toots Mansfield Roper



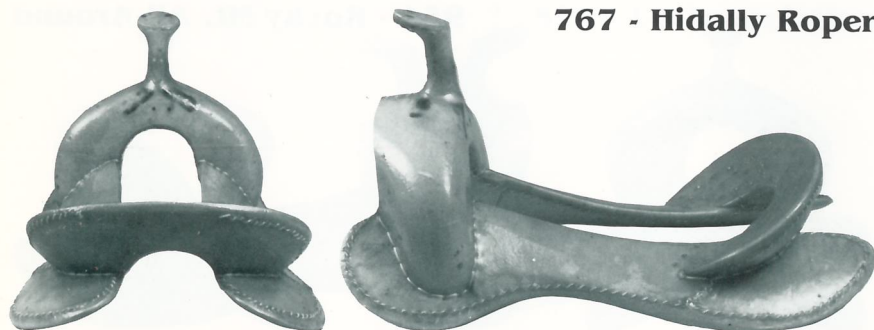
15", 16" Seat • 13" Swell • 3", 3-1/2" Cattle • 6-1/2" x 8-1/4" Gullet • Dally Horn.

1599 - TN Roper



15", 15-1/2", 16" Seat • 12" Swell • 3-1/2", 4" Cattle • 6-3/4" x 8" Gullet • #211 Post Roper Horn.

767 - Hidally Roper



15-1/2", 16" Seat • 12" Swell • 3-1/2" Cattle • 6-1/2" x 8-1/4" Gullet • #211 Post Roper Horn.

535 - Texas Roper



15", 15-1/2", 16" Seat • 12-1/2" Swell • 3-1/2" Cattle • 6-1/2" x 7-1/2" Gullet • #211 Post Roper Horn.

**140 - Professional
Cowboy**



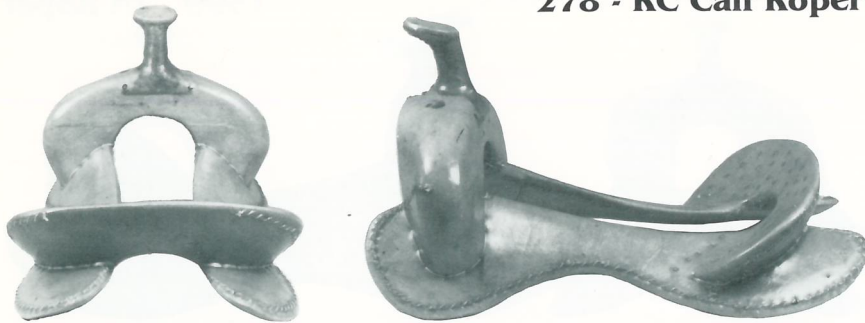
15", 16" Seat • 12-1/4" Swell • 3-1/2" Cattle • 6-3/4" x 8-1/4" Gullet • #787 Short Post Horn.

100F - Centennial



15", 15-1/2", 16" Seat • 12-1/4" Swell • 3-1/2", 4" Cattle • 6-1/4", 7-1/2" Gullet • #787 Short Post Horn.

278 - RC Calf Roper



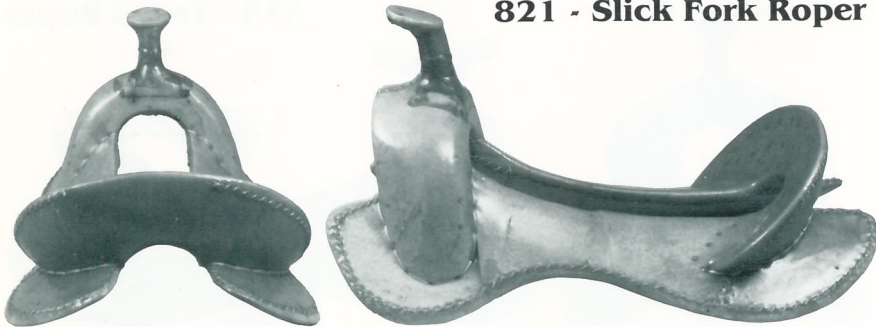
14-1/2", 15", 15-1/2", 16" Seat • 13" Swell • 3" Cantle • 6-1/2" x 8" Gullet • #787 Short Post Horn.

1062 - Low Moose



15", 16" Seat • 13", 14" Swell • 3-1/4" Cantle • 6-1/2" x 7-3/4" Gullet • Dally Horn.

821 - Slick Fork Roper



15", 16" Seat • 9-1/2" A Fork Swell • 3-1/2" Cantle • 6-1/4" x 7-1/4" Gullet • #211 Tall Post Horn.

951 - Rocky Mt. All-Around



15-1/2" Seat • 13" Swell • 3-1/4" Cantle • 6-1/4" x 8" Gullet • Dally Horn.

852 - BR All-Around



15", 16", 17" Seat • 13" Swell • 3-1/2" Cantle • 6-1/2" x 7-3/4" Gullet • Dally Horn.

135 - Canadian All-Around



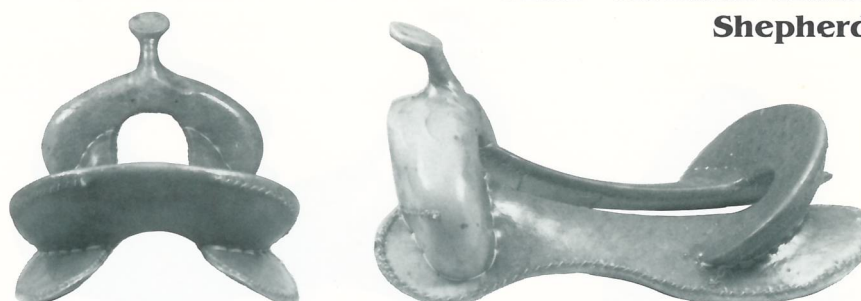
15-1/2", 16" Seat • 12" Swell • 3", 3-1/2" Cantle • 6-1/4" x 7-1/4" Gullet • #787 Short Post Horn.

818 - O.Y.



15", 16" Seat • 12", 13" Swell • 3-1/4" Cantle • 6" x 7-1/4" Gullet • #787 Short Post Horn.

1252 - Modified Chuck Shepherd



13", 14", 15", 15-1/2", 16" Seat • 13" Swell • 4" Cantle • 6-1/4"; 7-1/4" Gullet • #8 Western Pleasure Horn.

548 - Lo Association



16" Seat • 13" Swell • 3" Cantle • 6-1/4" x 7-1/2" Gullet • #787 Short Post Horn.

727 - Bulldogger



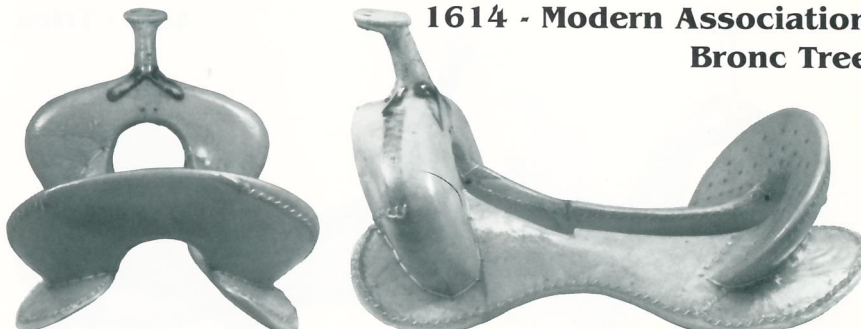
15", 15-1/2", 16" Seat • 10" Swell • 2-1/2" Cantle • 6-1/2" x 7-1/4" Gullet • Egghead Horn.

512 - Mississippi Roper



15-1/2" Seat • 12-1/2" Swell • 3-1/2" Cantle • 6-1/2" x 7-3/4" Gullet • 787 Horn.

1614 - Modern Association Bronc Tree



16", 16-1/2" Seat • 14" Swell • 4-1/4" Cantle • 6" x 8-1/4" Gullet • #211 Post Roper Horn • Note: Available without horn for use as bronc saddle tree.

187 - Police Dragoon



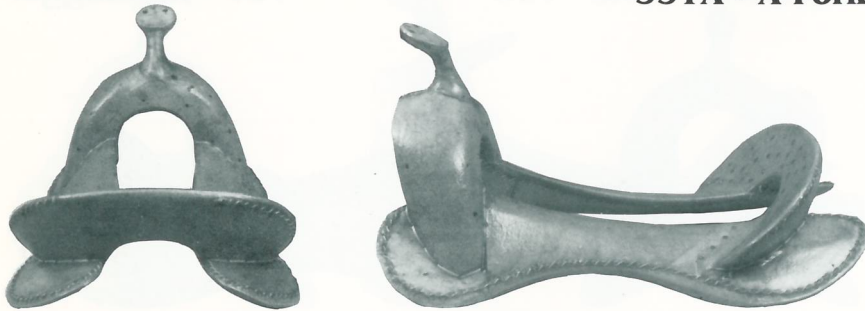
17" Seat • 7-1/2" Swell • 3-1/2" Cantle.

318 - Buena Vista



16", 17", 18", 19" Seat.

331A - A Fork



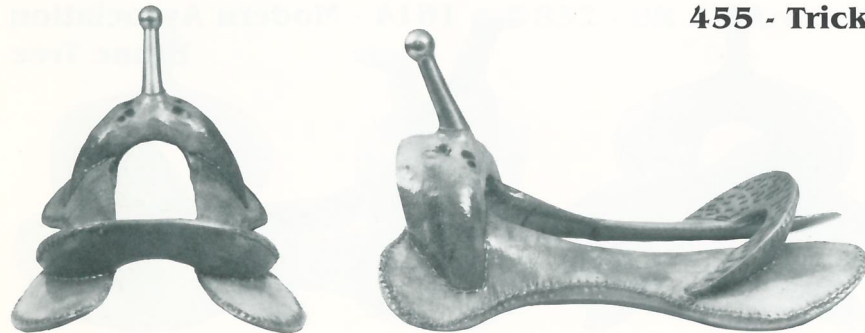
14", 15", 16" Seat • 9" A Fork Swell • 3-1/4" Cantle • 6-1/4" x 7-3/4" Gullet • #787 Short Post Horn.

1035 - Bear Trap



15", 16" Seat • 14-1/2" Swell • 4" Cantle • 6-1/4" x 8" Gullet • #787 Short Post Horn.

455 - Trick



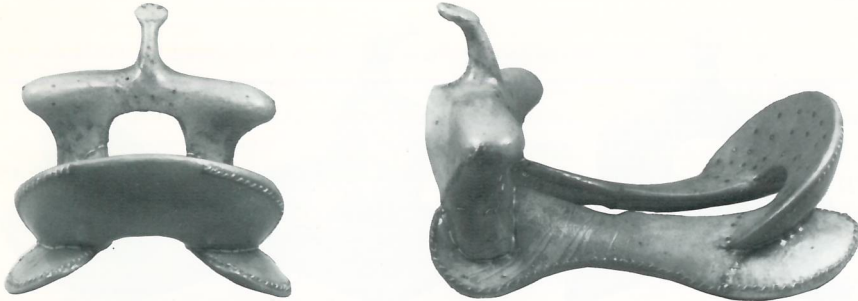
14-1/2", 15", 15-1/2" Seat • 9-1/2" Swell • 2-1/2" Cantle • 6-1/4" x 7" Gullet • Trick Horn.

1901 - Old Timer



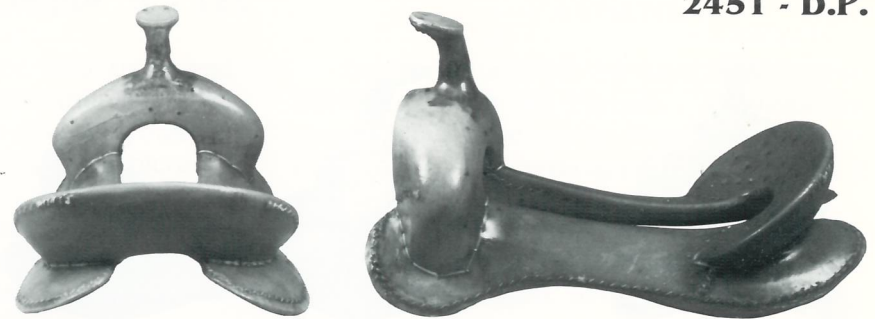
15", 16" Seat • 9" A Fork Swell • 4-1/2" Cantle • 6" x 8-1/4" Gullet • #211 Post Roper Horn.

2440 - All-Around Racer



14", 15" Seat • 13" Swell • 4-1/2" x 12-1/2" Cantle • 6-1/2" x 7-1/4" Gullet • #30 Cutter Horn.

2451 - D.P.



14-1/2", 15", 15-1/2" Seat • 12" Swell • 3-1/2" x 12-1/2" Cantle • 6-1/4" x 8" Gullet • #787 Short Post Horn.

558 - Futurity Cutter



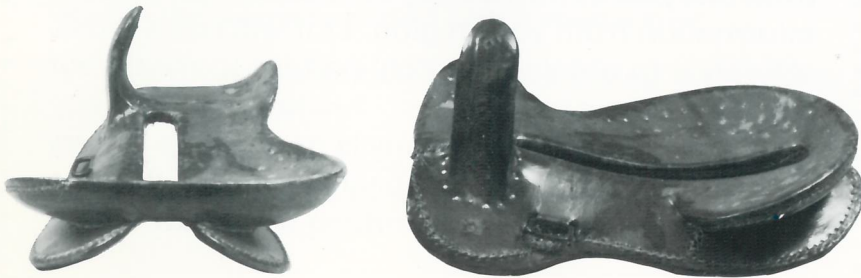
15", 15-1/2", 16" Seat • 13" Swell • 4-1/2" Cantle • 6-1/2" x 8-1/2" Gullet • #300 Extra Tall Cutting Horn.

133 - Youth All-Around



13" Seat • 11" Swell • 3" Cantle • 6-1/4" x 7-3/4" Gullet • #8 Western Pleasure Horn.

- Side Saddle



18" Ladies Side Saddle

31 - Little Wonder



12" Seat • 12" Swell • 3" Cantle • 5-1/4" x 6-1/4" Gullet • #F-10 Boy Horn.

231 - Jr. Roper



13" Seat • 11" Swell • 3", 3-1/2" Cantle • 4-1/2" x 6-1/2" Gullet • #787 Short Post Horn.

819 - Youth Roper



13" Seat • 12" Swell • 3-1/4" Cantle • 6-1/2" x 7-1/4" Gullet • #787 Short Post Horn.

43 - Pony



11" Seat • 8-1/4" Swell • 2-1/4" Cantle • 4" x 6" Gullet • #F-10 Boy Horn.

260 - Pony



11" Seat • 9" Swell • 2-1/2" Cantle • 4-1/2" x 6-3/4" Gullet • #F-10 Boy Horn.

— A TREE FOR EVERY NEED... —

It is important to remember that trees shown in this catalog represent only some of our most popular styles. Flor Saddle Tree Company has seven hundred different saddle tree patterns to choose from—we can supply a tree for every need.

If your particular requirement cannot be met by a style shown, please contact us with information regarding name, style and size you are interested in.

Names and styles of saddle trees will vary greatly from one part of the country to another. Given such information from your region, Flor will run a cross-reference to obtain a "match" pattern to meet your specifications exactly.

Flor Saddle Tree Company is proud of its history in customer service and quality control. We welcome the opportunity of working with **you**.

—ORDERING—

A form is inserted in each catalog, outlining all measurements necessary for us to produce your order. You may mail this form to us with your order, or phone us anytime Monday through Friday between 8:00 a.m. and 5:00 p.m. Eastern time.

We can provide almost any design you require, and will keep special features for your exclusive use if requested. Trees shown on the preceding pages are standard designs, available from existing patterns. If you order styles that require new patterns, we will need an order sufficient for us to absorb our tooling costs, or a nominal payment to cover this work.

Production orders require a minimum of 18 trees per style. Seat lengths and horns may vary. If you need less than 18 trees, we suggest that you consider our Ruwart-Simpson line, which is set up to produce custom orders.

—SHIPPING—

We can usually produce your trees and have them ready for shipment within 3-4 weeks of order acceptance. This is assuming that the trees ordered are standard styles, as pictured in this catalog or that patterns have been made by Flor Saddle Tree Company. On special orders we may suggest that a sample tree be sent to you for approval before producing your trees.

Trees are banded together for shipment. If cartons are required there will be an additional charge.

Shipment is via common carrier of your choice (we have most major truck lines available to us on a one day notice). If preferred, you may always pick up your trees at our plant during normal business hours.

—PAYMENT—

Our terms are net 30 days to approved accounts which are current. All trees are shipped F.O.B. Demorest, GA. New accounts must complete a credit application and mail it to the address listed below.

It usually takes 30 days to process these applications, so if you need your initial order rushed, we suggest allowing us to ship it C.O.D.

All invoicing is handled by our accounting department located in Athens, TN. Please mail all checks, credit applications or direct any questions about your account to:

Flor Saddle Tree Division of P.I. Inc.

P.O. Box 669

Athens, TN 37303

Attn: Credit Department.

—FLOR SADDLE TREE COMPANY GUARANTEE—

Flor trees are guaranteed for five (5) years from the time of shipment from our factory. We will replace any tree that fails during the warranty period with a similar tree.

If you have a tree that has failed during the warranty period, it should be returned to us only after receiving a "returned goods authorization."

Flor Saddle Tree Company reserves the right to inspect any tree returned for replacement, and will not guarantee trees that have been damaged by neglect or misuse (Such as Barrel racing trees used for roping, etc.)



FLOR Saddle Tree Company

A Division of P. I. Inc. • P.O. Box 608, Demorest, Georgia 30535 • 404/754-9350

**Serving The Saddle Industry
—Over 100 Years—**