

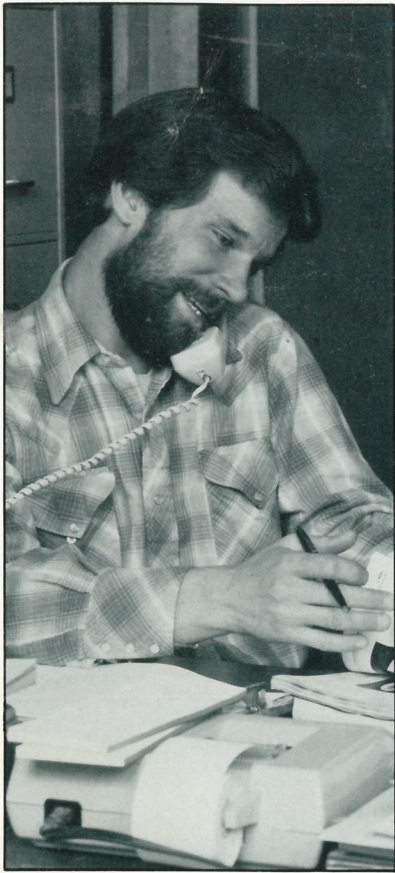
PRODUCT CATALOG

RUWART--SIMPSON SADDLE TREE COMPANY

A Division of Mont-Tenn Corp.

TOP QUALITY
— TREES —
SINCE 1850





Dear Saddlemaker

This is our first catalog since taking over the Hal Simpson Co. in 1984, and we know you will find it helpful. Prior to this, the last catalog was published by the Ruwart Mfg. Co. in 1963.

We have departed from the average saddle tree catalog format which usually contains only pictures of various trees; instead, we are showing you a little bit about how RUWART-SIMPSON trees are made, and what to look or ask for in ordering. We are proud of the heritage this firm has developed over the 136 years it has been in business. We shall continue the tradition of making only the best rawhide covered saddle trees.

Our new plant in West Yellowstone is clean and well-equipped. Our employees are qualified and interested in their work. Most ride or own horses and know first-hand what you need and expect in the way of trees as a custom saddlemaker.

This catalog does include photos and information on our most popular styles of trees and a list of the others we have active patterns for. From time to time we will photograph new styles and send you individual pages.

We are involved with other businesses here in Montana such as Ralide products and pack equipment; however, RUWART-SIMPSON is independently operated with but one objective: To put out the very best traditional saddle trees at competitive prices in a reasonable time. We know your customers won't wait forever for their saddles to be built, so we always try and meet your requested delivery time. Because your customers will sometimes order a saddle and want delivery before it is possible for us to make a custom tree, we wish to call your attention to our stock tree program as outlined in the enclosed price list. Please let us know your requirements and we will make every effort to satisfy them.

Anytime you are in our area we encourage your stopping to visit us. We are always interested in discussing your needs and showing you how our trees are made. Please call on our toll free WATS line to place orders: 1-800-624-8564.

David B. Akers
Vice-President

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HISTORY OF THE RUWART-SIMPSON SADDLE TREE COMPANY

Founded in Jefferson City, Missouri in 1850 as the J. Sullivan Saddle Tree Company, by Mr. James Sullivan and Mr. Henry Ruwart, Sr., the company operated within the walls of the Missouri State Prison and produced saddle trees, stirrups and other tack items then used by the saddle industry. At that time it was not uncommon for labor intensive businesses to be located inside prisons and to use inmates as the prime labor force.

Mr. Sullivan was apparently the financial backer of the business, and Mr. Ruwart the manager of day-to-day operations. A Montgomery Ward catalog published in 1887 advertised side saddles "Made on a patented Ruwart Tree," which remained very popular for many years. The company continued to operate from inside the prison until 1907 when the state of Missouri prohibited the sale of interstate commerce in goods made by prison labor.

In 1912 Mr. Henry Ruwart, Jr., who had taken over the business from his father, traveled to Denver and purchased the T. E. Meanea Saddle Tree Company located at 13th and Platte streets, now the site of I-25, running north and south through the city. Upon their release, several former prison employees from Missouri came to Denver and regained their old jobs in the tree factory.

World War I broke out soon after the Ruwart operations began in Denver, and the company made thousands of McClellan type trees for the U.S. Cavalry. After the war the patterns and special jigs for these trees (considered obsolete) were destroyed; however, the firm was to see them become very popular again.

In 1939, the company moved from its location on 13th Street to a new building at 4893 Washington Street. It was the most modern saddle tree factory in operation at that time. Meanwhile, in 1937 Mr. Charles Henry Ruwart had taken over the presidency of the firm, a position he held until his death in 1958. His son, Chuck Ruwart, then assumed direction of the business. In 1966 Mr. Hal Simpson, who had joined the firm as an accountant, bought out the Ruwart family, moved the business to 2714 Walnut Street, and took in as a partner Mr. Martin Quimby. The Simpson-Quimby business operated until January 1976 when Mr. Quimby sold out and the firm's name was changed to the Hal Simpson Company.

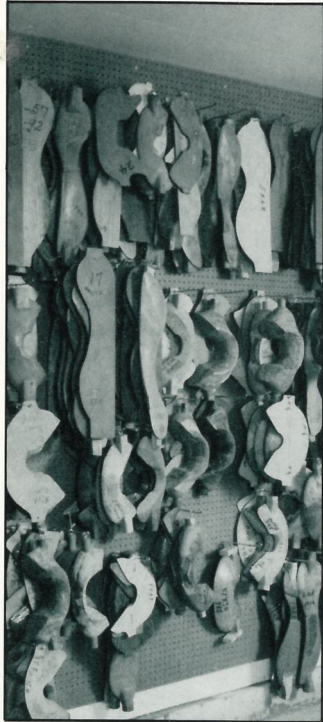
In November 1984, William Akers and his sons, David and Brown, bought the business from Mr. Simpson and renamed it Ruwart-Simpson Saddle Tree Company. The new owners operated the business at its location on Walnut Street until April 1985, when the machinery and equipment were moved to West Yellowstone, Montana and operations continued from temporarily leased quarters.

During the summer of 1985, a new 6,000 square foot building was added to the then existing Ralide-West warehouse at Firehole and Electric Street and is now the permanent home of the Ruwart-Simpson Saddle Tree Company.

THERE ARE NO SHORTCUTS TO PROVIDING QUALITY SADDLE TREES...

WITH OVER 100 YEARS OF PRODUCING SADDLE TREES, PRODUCT QUALITY IS OUR HERITAGE.

WIDE PATTERN SELECTION



QUALITY LAMINATED CONSTRUCTION



MASTER TREE BUILDER



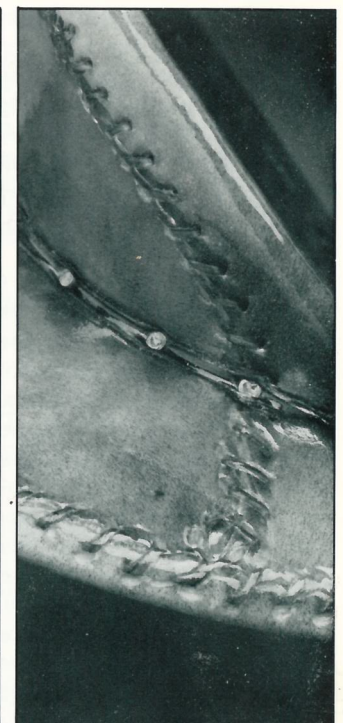
TOP QUALITY RAWHIDE PROCESSING



EXPERT STITCHING CONTROLS



DETAILED CUTTING AND STITCHING



There are over 200 active patterns in our shop and we have other old favorites that we use from time to time. If you have an original design or feature and want it made for you on an exclusive basis, we will be glad to discuss the costs of developing patterns. Once made, these patterns would be used to produce trees for your use only.

Our trees are machined from seasoned spruce dried to 12% moisture content. We use laminated construction on critical parts, including a hardwood center ply on the forks. Trees are sanded and dipped in a special sealer that stabilizes the wood and prepares the surface for the rawhide.

Jimmy Lockhart, our master tree builder, learned the trade from Mr. Fred Haak, who worked for the Ruwart Mfg. Co. for many years. All parts are glued and nailed together in a special jig that assures the tree will be as ordered. Jimmy has been building trees for 17 years and knows what you need and expect in a custom saddle tree.

We only use top quality heavy native steer hides which we process in our own plant by a formula that is best for rawhiding saddle trees. At no time do we allow our hides to dry out, which causes them to lose strength when they must again be softened up for use. Rawhide is stored at 38 degrees until ready for stitching.

Helen Miller is in charge of our rawhide department and personally stitches our most difficult trees, plus supervising all the other stitchers working in our shop. All work is done in our own plant, and completed trees are air dried for at least three days before a final coat of lacquer is applied.

We know how important it is for you to have trees that are not only strong and well-shaped but also look good, with even, well-spaced stitches. The finest tree can be ruined by a poor job of cutting or stitching the rawhide. We take great care with this part of tree building so that you and your customer will be satisfied.

SPLITER
Buck

72" American OLD Recondition

PROPER METHODS OF SADDLE TREE MEASUREMENT

A SADDLE IS ONLY AS GOOD AS THE TREE IT'S BUILT ON...

As a custom saddle maker you stake your reputation on the products you turn out. The best leather and workmanship on your part will all be wasted if the saddle tree doesn't fit horse or rider, or fails in any way to perform for a reasonable amount of time.

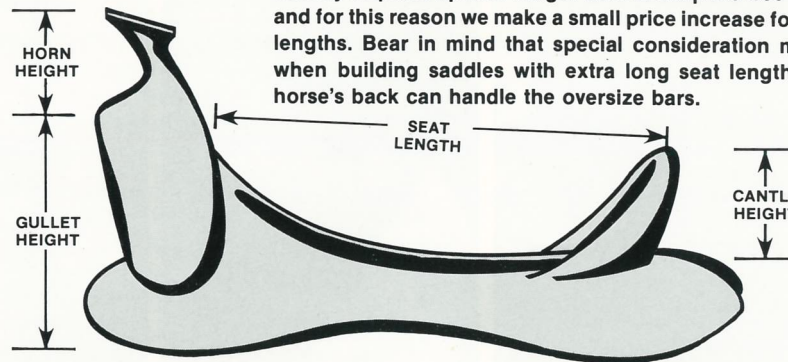
At Ruwart-Simpson, we build trees that give you the kind of satisfaction you want and your customer demands. Both our businesses depend on satisfied customers and word of mouth recommendation. Our laminated construction and the fact we produce our own rawhide gives us the ability to assure you of quality. Ruwart-Simpson trees are guaranteed for 5 years, but we know that with reasonable care they will continue to function much longer.

Ruwart-Simpson has been in business for over 135 years, so you are assured that we will ship you trees you are proud of and that we will be around in the future to serve you.

POINTS ON SEAT LENGTH:

Any of our full size adult trees can be ordered with from 14" to 16½" seats in 1/2" increments. Kids' pony trees normally are from 10" to 13"; however, we have built special trees as small as 8".

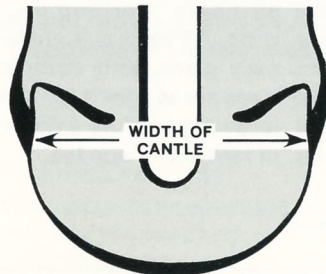
Today, it is fairly common to get requests for saddles with up to 18" seat length, especially from some of the cutting horse people. Anything over 16½" usually requires special longer bars to keep the tree in proportion, and for this reason we make a small price increase for these longer lengths. Bear 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.



POINTS ON CANTLES:

We will put any style of cantle you want on your tree, but suggest using the two most popular, which are regular (round) and comfort. Standard widths range from 11½" to 13½", but we can make smaller or larger on request. Height is normally 3" to 6", depending on expected use.

Dish will usually be 1/2" to 2", with 1¼" being somewhat standard. Certain trees such as Low Moose, Pleasure and Dude saddles lend themselves to comfort cantles while roping, and ranch trees make up best with regular cantles. Buckaroo and Ole Timer trees with very high cantles (up to 6") become what is often called shovel cantles. We laminate our cantles, which gives extra strength in this often overlooked, but very important, part of the tree.

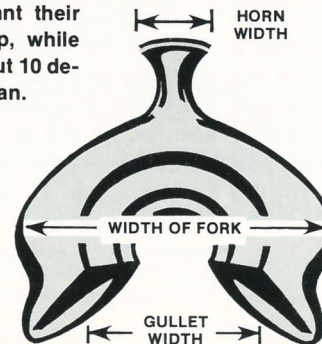


POINTS ON FORKS:

The fork, or front, is the most distinctive part of any tree. We have many patterns for each type of tree and can usually come up with what you and your customer want, even if the name might be different. Opposite you will find a list of the names of trees that we are familiar with. Names will vary from one part of the country to another, so it's important to be sure we know exactly what you want.

Let us know what type of saddle you are going to build: all around roper, cutter, barrel racer, etc., and this pretty much identifies the basic style of fork you will need.

We will position the fork in a normal manner unless you have a specific request. Some cutters, for example, want their forks straight up, while others want about 10 degrees forward lean.



STOCK TREE PROGRAM

We try and keep three popular trees in stock for immediate shipment, to take care of your saddle customers who can't wait for a custom tree to be made up. These are an Improved Association, "A" Fork and an S. F. Bowman, all with 15½" seat. These are top quality trees, rawhide laced, but at a slightly lower price than our custom trees because we run several through at the same time and can do this more efficiently than one at a time. See your price list for further details.

In addition to the trees pictured at the back of this catalog, we have patterns and are familiar with the following styles:

Colorado Roper
Carter Cutter
Spencer Trail Rider
California Cutter
Steer Roper
Southwest Roper
Dee Picket Roper
Colorado Youth
Arkla Roper
R. C. Roper
Texas Cutter
Low All Around
Rock Special
Leo Camarillo Roper
Marty Wood
Lieuallen
Walker Dogger
Matlock Rose
Pro Roper
Deuce Five

T. J. Holmes
Buster Welch
Feed Lot Special
Leddy
Ellensburg
Buffalo Moose
Colorado Dude
Lane Hudson
Blanchard Roper
T. M. Roper
Elbo Roper
Fit's Em
Sonny Perry
In Between Roper
Sid Special
Low Bronc
K Kutter
Ashcraft
Western Pleasure
Chuck King

NOTE:

Names and styles of saddle trees will vary greatly from one part of the country to another. If you will just describe the tree you want, we can cross-reference it with other manufacturers' catalogs and come up with exactly what you are looking for.

HORN STYLES AVAILABLE

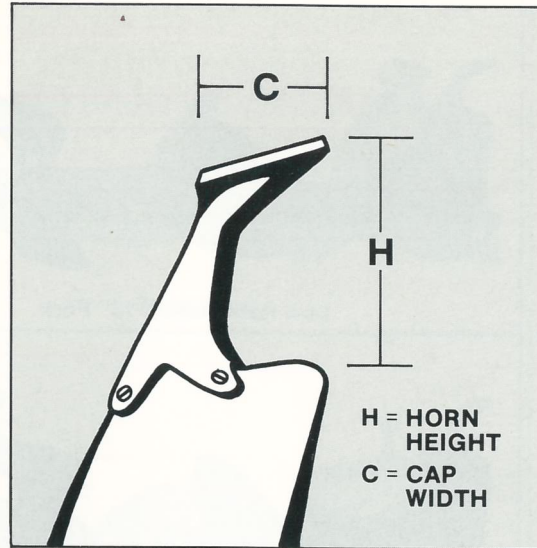
POINTS ON HORNS:

We own our own match plates and molds for horns and have them cast to our specification from high tensile malleable iron. This is far and away the best metal for saddle horns as it is not brittle and will flex slightly without breaking.

The top of the fork is routed out to exactly fit the legs of the horn. Rivets (that go through the fork and into the steel plate on the bottom of the gullet) plus screws are used to attach the horn securely.

Horns will be installed in the normal position for the style of tree being made, unless you have a special request. Some cutters, for example, will want a straight-up horn position, while others like a little bit of forward lean.

We install a plywood horn cap on all custom trees which can be larger than the indicated horn cap size. If, however, you want the horn cap made smaller than the indicated size, we must grind the metal down, and for this we make a small additional charge.



BAR STYLES

POINTS ON BARS:

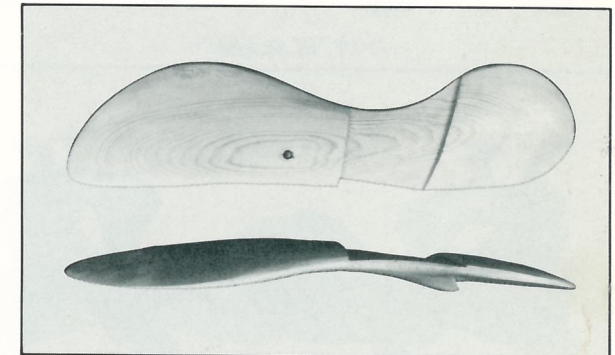
Regular and Arizona bars are our most popular and are illustrated below in detail so you can see the flare and twist that we use. Ruwart-Simpson's bar patterns have been changed over the years to provide a better fit on today's well-nourished horses. Our bars fit the horse, but at the same time provide a narrow waist for better rider comfort.

The laminated construction we use gives you strength and resistance to warp not found with one-piece bars.

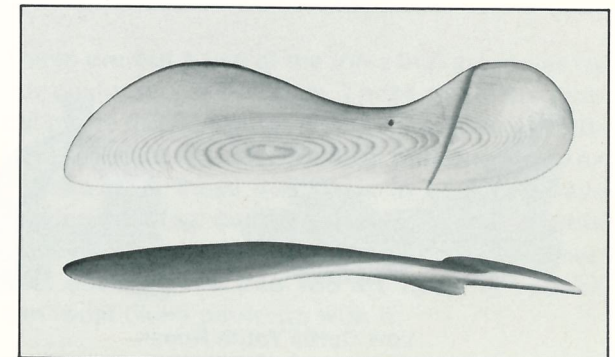
We can also provide Arab, Wade and Northwest style bars on request. We take extra care smoothing out the area where the cantle and fork attach to the bars. A "Dutchman" is normally used to provide a slight rise on the front of the seat, but this may be left off for cutter or level ride types of trees.

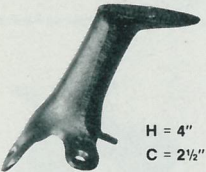

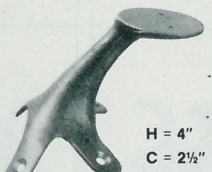
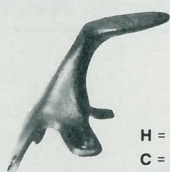

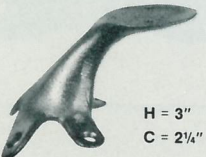

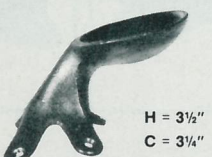




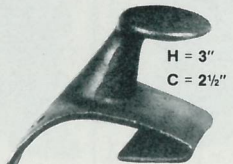
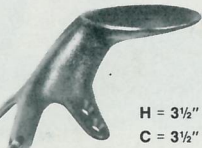
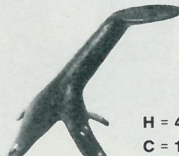
You will find our trees are easy to work, with regard to ground seats and stirrup rigging attachment.

REGULAR BAR

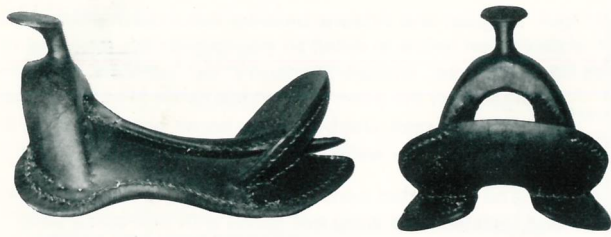


ARIZONA BAR



 <p>H = 4" C = 2½"</p> <p>HEAVY DUTY POST ROPER</p>	 <p>H = 3½" C = 2½"</p> <p>HEAVY DUTY POST ROPER</p>	 <p>H = 4" C = 2½"</p> <p>REGULAR ROPER</p>	 <p>H = 3½" C = 2¼"</p> <p>REGULAR ROPER</p>	 <p>H = 3" C = 2¼"</p> <p>ALL AROUND</p>
 <p>H = 3" C = 2¼"</p> <p>ALL AROUND</p>	 <p>H = 2½" C = 2"</p> <p>ALL AROUND</p>	 <p>H = 3½" C = 3¼"</p> <p>MEXICAN</p>	 <p>H = 3¼" C = 3"</p> <p>MEXICAN</p>	 <p>H = 2¾" C = 2¼"</p> <p>MEXICAN</p>
 <p>H = 5" C = 1¾"</p> <p>EXTRA HIGH CUTTER</p>	 <p>H = 4¼" C = 1½"</p> <p>HIGH CUTTER</p>	 <p>H = 3" C = 2½"</p> <p>H. D. RANCH WRAP AROUND</p>	 <p>H = 3½" C = 3½"</p> <p>DUCK BILL</p>	 <p>H = 4" C = 1¾"</p> <p>EGG CAP OLD STYLE</p>

SADDLE TREES



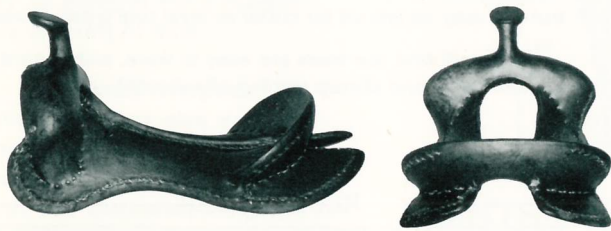
"A" Fork (Weatherly Style)



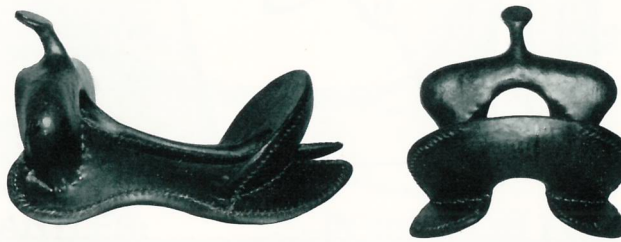
Low Association 13" Fork



Bronc



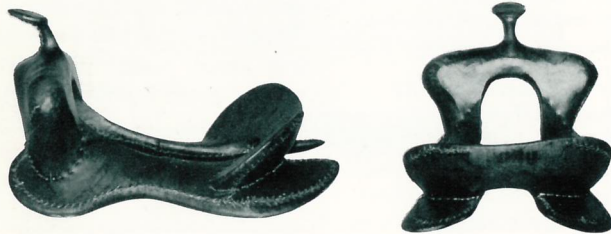
T. M. Roper



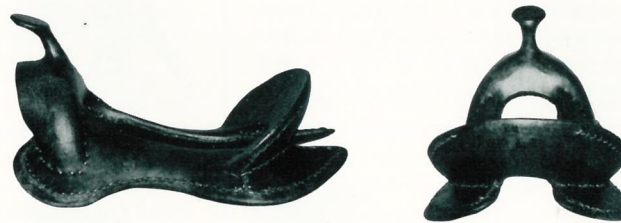
Association 14" Fork



S. F. Bowman



Tipton



"A" Fork (Wade Style)



Little Wonder



Low Curtis Youth Roper



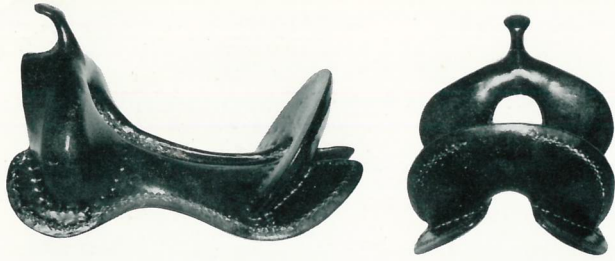
Flat Seat Cutter



Fit's Em 14" Fork

SADDLE TREES

PLEASE INQUIRE ABOUT OUR
CUSTOM TREE MANUFACTURING



Visalia Half-Breed



Pack Tree



Youth Bowman



Bob Crosby Bull Dogger



Martha Josey Barrel Racer



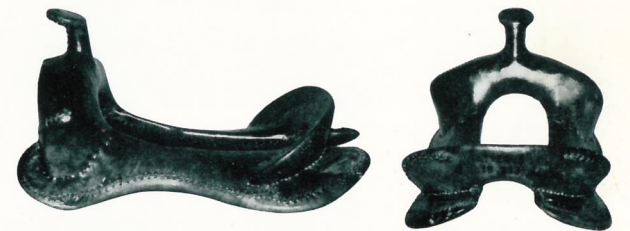
Fit's Em 13" Fork



Low Moose



Chuck Shepard



Jess Goodspeed

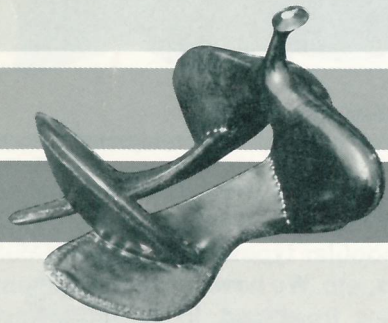


Half-Breed Visalia



#552 Fit's Em

These are but a few of the trees that are in use by our customers at this time. These styles are typical of the most popular types: ropers, ranch, cutters, barrel racers, etc. We have patterns on many variations of these trees and, in addition, have catalogs dating back over 50 years on saddle manufacturers and other firms who made trees. Just describe the tree you are needing and we can most likely come up with it.



RUWART—SIMPSON SADDLE TREE COMPANY

A Division of Mont-Tenn Corp.

P.O. BOX 998

WEST YELLOWSTONE, MT 59758

Call toll free to place orders: 1-800-624-8564

Montana, Alaska and Canadian customers dial direct: 1-406-646-7612

"A SADDLE IS ONLY AS GOOD AS THE TREE IT'S BUILT ON."

MEANEA STYLE TREE WITH 20" FORK
One of our specialties is duplicating old and unusual trees. The original of the above was made by Ruwart back in the 1920's for the Frank A. Meanea Saddle Co. of Cheyenne, WY.