

CORRECTED
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INSTRUCTIONS FOR WAIST BELT AND BROWN BESS BAYONET SCABBARD

by Sam Fletcher - 3rd N. Jersey

NOW OF 5th Co.
3rd N. York Regt. 1775
S.A.R.

- o Read my instructions for the cartridge box for the list of tools and materials required.
- o Materials Required -
 - Leather belt blank 44-50" x 1 3/4"
 - Leather - grade 6-7 oz. for frog, strap and scabbard
 - Hardware - Bob Reed supplies B-7 waist belt buckle and H-1 scabbard hook

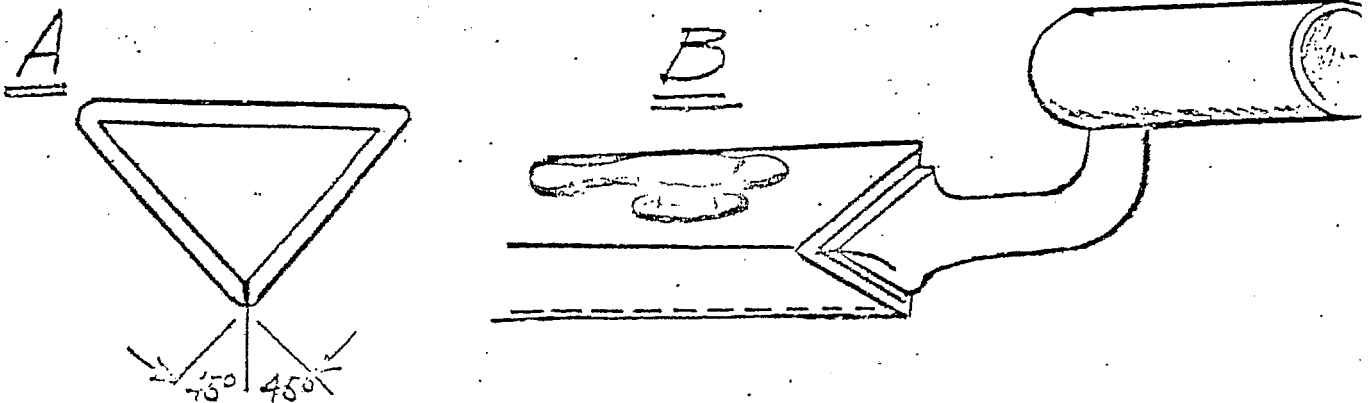
- o Procedure *AN American bayonet scabbard requires a #54 GROWN LOCKET ONLY
A British bayonet scabbard requires a #55 and a #16 SCABBARD TIP*

WAIST BELT AND FROG

1. Trim WAIST BELT and punch holes to suit. Bevel all edges lightly.
2. Cut FROG and STRAP from leather. Mark and make stitch holes on both parts.
3. Cut slot or oval hole in FROG for SCABBARD Hook. Note the HOOK must be forced through the slot - don't cut it too large.
4. Stitch FROG to STRAP. Note - Top grain of FROG leather should be on the outside of the back and the folded over lower section.
5. Clean up belt buckle casting, make tongue and sew to belt blank.
6. Locate FROG on WAIST BELT so that it hangs on your left hip. Mark stitches and sew FROG to BELT.
7. Sew STRAP to BELT at a proper distance and angle.
8. Finish with Neetsfoot oil.

SCABBARD

1. Layout and cut leather to template. Note template is for Navy Arms Brown Bess pattern. Check it for length and width against any other.
2. Bevel inside edges of leather blank about 45° along entire length of the rear seam (as in A).



3. Mark stitches at 5 S/inch on both edges and punch the holes with an awl. Start stitches very close to the bottom tip.

Shown in Collectors Enc. p. 36

o Procedures (continued)

4. Wet leather with warm water until pliable and shape around the bayonet. Note that seam must run on face of bayonet opposite to the bent arm and socket. See above (B).

see X below

5. Wrap leather while wet with a strip of smooth plastic or other material that will hold the leather tightly to the bayonet. Note - do not use string, rope or any textured wrapping material or you will transfer the pattern to the wet leather.

6. Let scabbard dry 24 hours before unwrapping.

use stitch spacer #5 or 6 to mark holes - Saddlers awl for holes

7. Start stitching at closed end with 2 needles and the saddle makers stitch. Continue until about four inches from open end and STOP!

8. Polish scabbard hook casting. Cut a 3/8 x 1" brass rectangle from sheet stock and drill two holes just large enough to accept the pins on the hook. Countersink the holes carefully to full thickness of the sheet.

9. Cut/file any excess length of the pins such that when pins are inserted through the scabbard leather, through the plate and peened into the countersinks that the whole thing will be approximately smooth. This is a trial and error proposition and better have too much after peening than too little.

10. Locate scabbard HOOK such that top edge of scabbard will be flush/slightly above the top edge of the FROG when installed.

11. Install HOOK and peen pins onto plate.

12. Complete stitching to top of SCABBARD.

13. Dampen and roll SCABBARD with a wall paper roller to smooth the seam and straighten it out.

14. After drying, finish SCABBARD with blue dye prime coat and two coats of black stain. Seal and polish leather after staining.

15. Insert SCABBARD in FROG working HOOK through FROG cutout with an awl as required.

Preferred method

5- Shape leather around bayonet with a wall paper roller and, after forcing corners to sharp edges, it will stay there by itself without any wrapping or holding. Let dry overnight.

LEATHER LIST

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Single Frog

1 piece of white "buff" belt leather 50" long x 2 1/4" wide x 3/32 or 1/8" thick.

1 piece of white "buff" belt leather 6" long x 5/8" wide x 3/32 or 1/8" thick. LABELED PIECE "C"

1 piece of white "buff" belt leather labeled "PIECE A"
1 piece of white "buff" belt leather labeled "PIECE B" } SAME THICKNESS AS ABOVE 8" x 14" TOTAL

Double Frog

1 piece of white buff belt leather 51" long x 2 1/4" wide x 3/32 or 1/8" thick

1 piece of white buff belt leather 6" long x 5/8" wide x 3/32 or 1/8" thick. LABELED "PIECE C"

1 piece of white buff belt leather labeled "PIECE E" 6 3/4" x 18" x 3/32 or 1/8" thick } total 18" x 10"

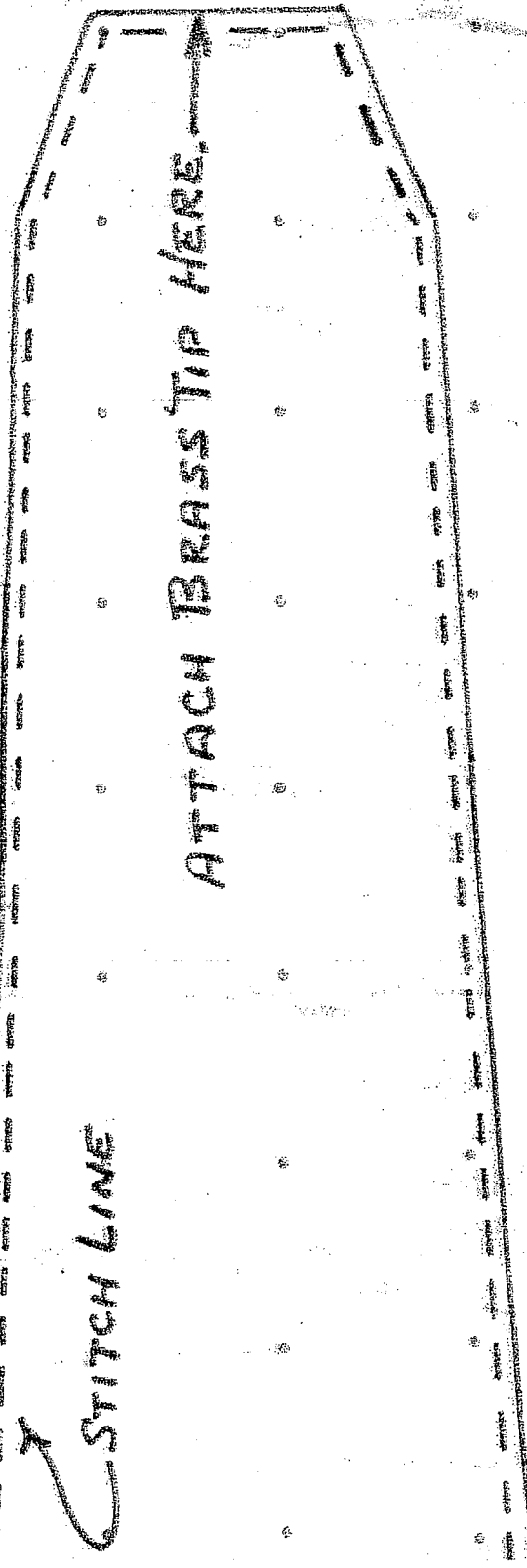
1 piece of white buff belt leather labeled "PIECE G" 3 1/4" x 9 1/2" x 3/32 or 1/8" thick } 3/32 or 1/8"

VEGETABLE TANNED

1 piece of brown V-T leather belt thickness 51" long x 2 1/4" wide x 3/32 or 1/8" thick
This is used for both single and double frog belts

of George C. Neumann
Illustrated Encyclopedia

George C. Neumann +
p. 36 Castle Books, Secaucus, N.J., 1975



BAYONET SCABBARD

NAUTA PATTERNMASTER

Original in collection of George
as shown in "Collectors Illustrated"
of the American Revolution" George
Frank J. Kravic. p. 36

← ATTACH SCABBARD LOCKET HERE.

← LOCKET

← TOP VIEW

← STITCH

