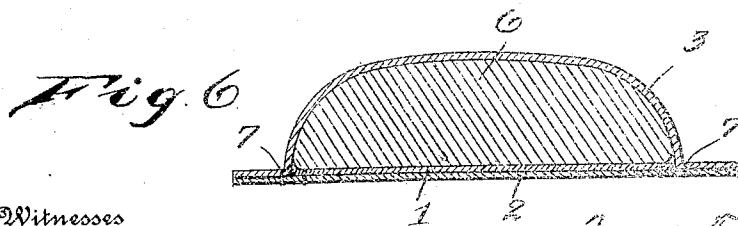
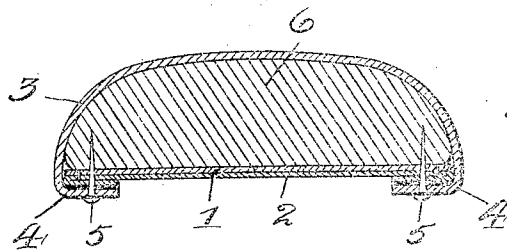
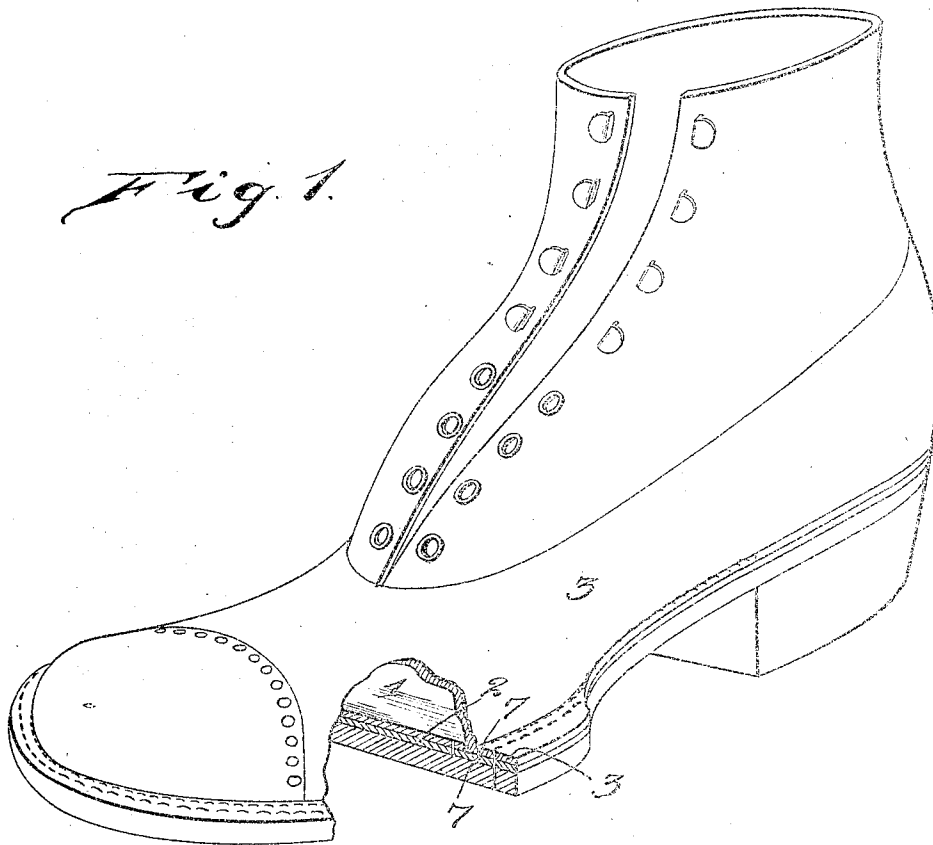


F. T. TAPPAN.
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APPLICATION FILED MAR. 1, 1912.

1,036,371.

Patented Aug. 20, 1912.
2 SHEETS—SHEET 1.



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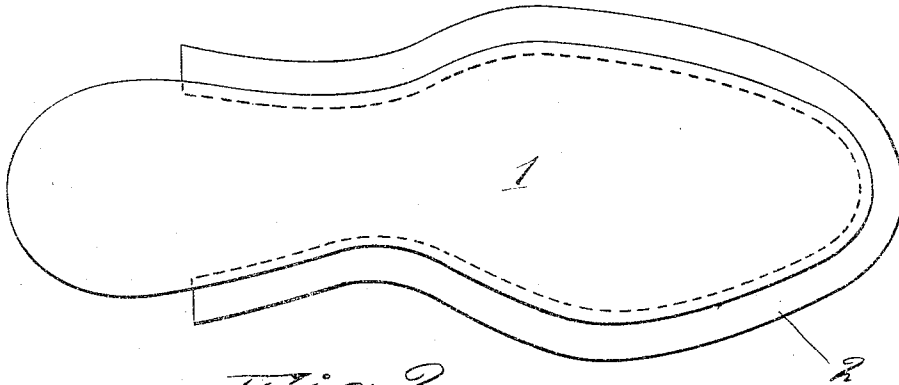


Fig. 2.

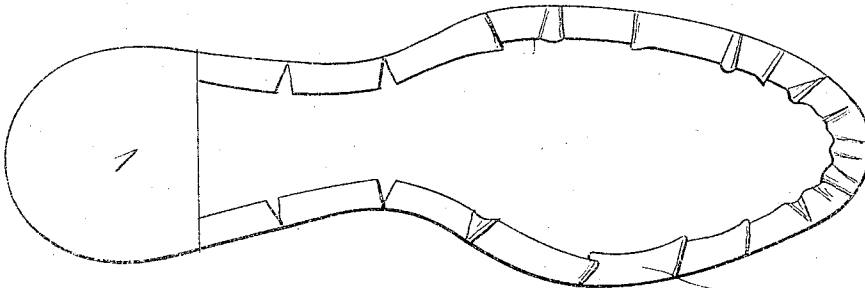


Fig. 3.

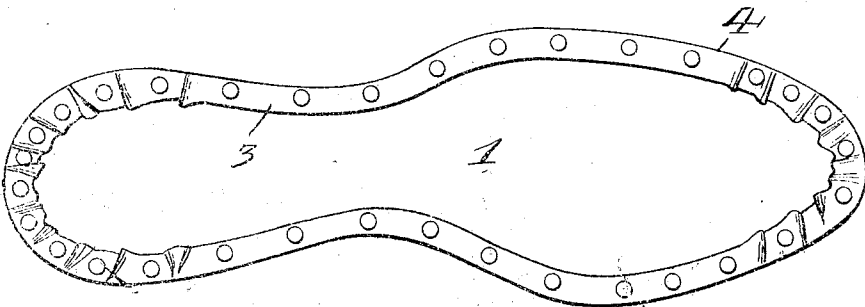


Fig. 4.

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UNITED STATES PATENT OFFICE.

FRANK T. TAPPAN, OF COLDWATER, MICHIGAN.

METHOD OF MAKING STITCH-DOWN SHOES.

1,036,371.

Specification of Letters Patent. Patented Aug. 20, 1912.

Application filed March 1, 1912. Serial No. 630,964.

To all whom it may concern:

Be it known that I, FRANK T. TAPPAN, a citizen of the United States, residing at Coldwater, in the county of Branch and State of Michigan, have invented certain new and useful Improvements in Methods of Making Stitch-Down Shoes, of which the following is a specification.

My invention relates to improvements in methods of making stitch-down shoes, and the object of my invention is to simplify and cheapen the construction of stitch-down shoes produced by well known methods.

By the use of my improved method I am enabled to attach any kind of an inner sole to the upper of a stitch-down shoe while the upper is firmly drawn over the last, and free from wrinkles. Furthermore there are fewer operations in my method, than are necessary to produce the stitch-down shoes heretofore employed.

My invention will be described in detail hereinafter and illustrated in the accompanying drawings in which—

Figure 1 is a perspective view of a stitch-down shoe partly broken away showing the relative positions of the two soles the welt and the upper after the shoe is completed. Fig. 2 is a plan view of the inner sole showing the welt extended. Fig. 3 is a plan view of the inner sole showing the welt turned over upon the same. Fig. 4 is a bottom plan view of the upper turned in upon the welt of the inner sole. Fig. 5 is a transverse sectional view of Fig. 4 showing the adhesive material between the welt and upper and held upon the last while the same is hardening, and Fig. 6 is a transverse sectional view of the shoe on the last, after the tacks have been removed and the part of the upper and welt secured together, turned out and the row of stitching for securing the upper to the inner sole.

In carrying out my method of producing a stitch-down shoe, the inner sole 1 is provided with pliable welt 2 which can be stitched thereto or it may be a pliable cover for the insole and extending beyond the insole to form a pliable welt therefor. This welt is turned in upon the insole and placed within the upper of the shoe with the welt on the lower face of the insole. The upper 3 of the shoe is turned in at its lower edge as indicated at 4 upon the welt 2 and both the lower face of the welt 2 and the upper

face of the inwardly turned portion 4 of the upper are coated with some adhesive material, whereby they are cemented together. The inwardly turned portion of the upper and the welt are firmly held together by tacks 5 which also pass through the insole into the last 6. The shoe is left upon the last until the adhesive material thoroughly sets, when the tacks are removed and the welt and that part of the upper cemented thereto are turned outwardly as clearly shown in Fig. 6 of the drawings. While on the last the upper and welt are secured together by a row of stitching 7 which stitching passes as close as possible to the edge of the inner sole. When the welt and upper are secured together by this row of stitching the shoe is complete ready for the outer sole, which is attached in the usual manner to the welt formed of the welt of the inner sole and a portion of the upper.

Having thus described my invention what I claim is—

1. The method of producing a stitch-down shoe, which consists in providing an insole with a downwardly and inwardly turned welt, turning the lower portion of the upper in upon the welt, then securing the inside of the lower portion of the upper to the outside of the welt, then turning the welt of the insole and the portion of the upper secured thereto outwardly, and attaching the outer sole thereto.

2. The method of producing a stitch-down shoe, which consists in providing an insole with an inwardly turned welt on its lower face, then turning the lower portion of the upper inwardly upon the welt, then cementing the lower portion of the upper thereto and holding them together until the cement has set, and then turning the welt and that portion of the upper cemented thereto outwardly to form an outer welt, stitching the layers of said outer welt together, and securing the outer sole thereto.

3. The method of producing a stitch-down shoe, which consists in providing an insole with a welt turned inwardly upon its lower surface, then cementing the lower inwardly turned portion of the upper thereto and tacking the same together on the last and allowing the cement to set, then turning the welt outwardly together with that portion of the upper cemented thereto and then securing the upper to the welt to form an

outer sole attaching welt, and attaching the sole thereto.

4. The method of producing a stitch-down shoe, which consists in providing an insole with a welt turned inwardly upon the lower face of the inner sole, then cementing the lower inwardly turned portion of the upper thereto, and securing the same together in their inwardly turned position by tacks, passing therethrough and through the insole into the last and holding them in said position until the cement has set, then removing the tacks and turning the welt and that portion of the upper cemented thereto outwardly to form an outer sole, attaching welt, then stitching the upper to the welt adjacent the outer edge of the insole and then securing the outer sole to the welt.

5. The method of producing a stitch-down shoe which consists in providing an insole with an inwardly turned welt, then cementing the lower inwardly turned edge of the upper thereto and securing the same together in their inwardly turned position by tacks passing therethrough and through the insole and into the last and letting it remain thus held until the cement has set, then re-

moving the tacks and turning the welt outwardly and that portion of the upper cemented thereto, then stitching the upper to the welt adjacent the outer edge of the insole, and then securing the outer sole to the welt formed by the welt of the insole and the lower edge of the upper.

6. The method of producing a stitch-down shoe, which consists in providing an insole with a covering upon one side thereof and secured thereto and extending beyond the edge of the insole to provide a welt, then turning said welt downwardly and inwardly upon itself, then bending the lower portion of the upper upon the welt and cementing it thereto, holding the welt and upper together until the cement is set, then turning the welt and upper outwardly, stitching them together adjacent their point of separation to provide a sole attaching welt, and securing the outer sole thereto.

In testimony whereof I hereto affix my signature in the presence of two witnesses.

FRANK T. TAPPAN.

Witnesses:

H. A. CLOSE,

OMAR EBENHACK.