June 7, 1932. M. L. DODGE ET AL 1,861,844

SLIPPER AND METHOD OF MAKING

Filed April 19, 1930

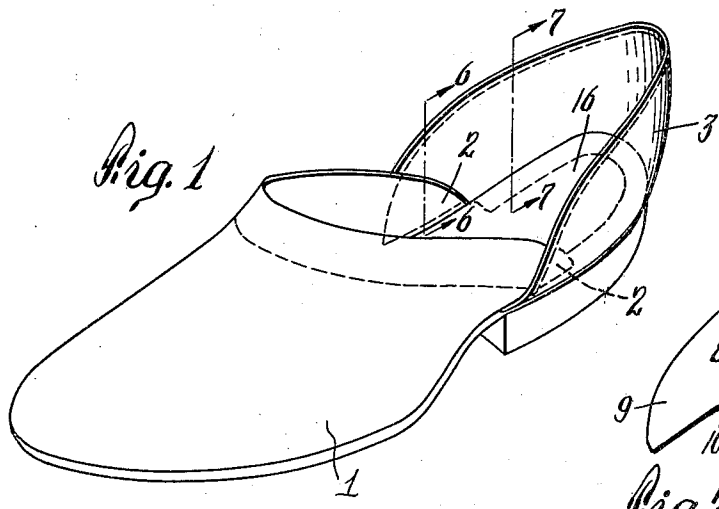


Fig. 1

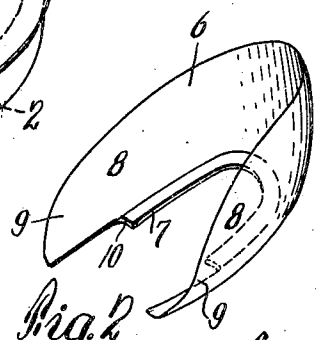


Fig. 2

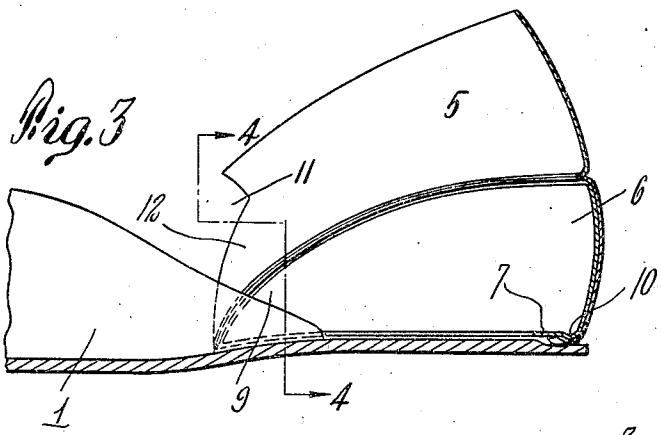


Fig. 3

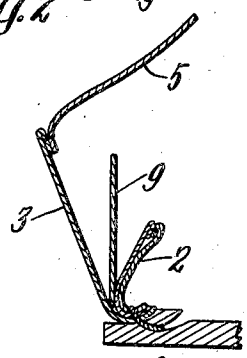


Fig. 4

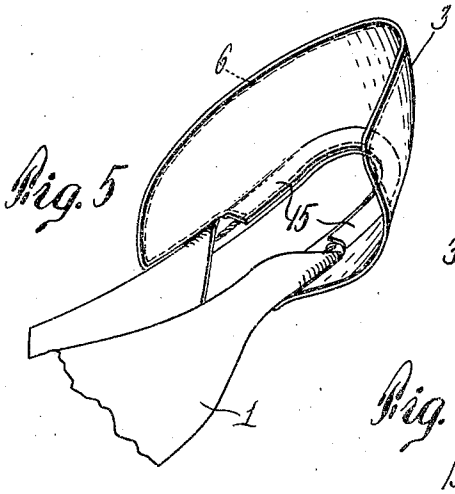


Fig. 5

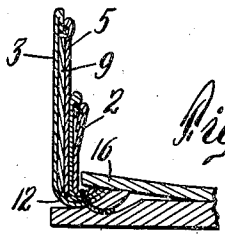


Fig. 6

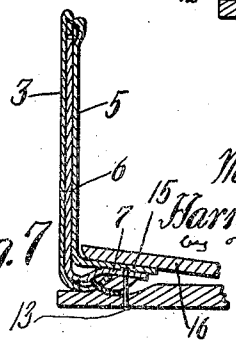


Fig. 7

Inventors:
Milton L. Dodge,
Harry L. J. Duchemin.
by
Wright Brown Quinby & May
Att'ys.

Patented June 7, 1932 1,861,844

UNITED STATES PATENT OFFICE

MILTON L. DODGE, OF NEWBURYPORT, AND HARRY L. J. DUCHEMIN, OF HAVERHILL, MASSACHUSETTS; SAID DUCHEMIN ASSIGNOR TO SAID DODGE

SLIPPER AND METHOD OF MAKING

Application filed April 19, 1930. Serial No. 445,583.

This invention relates to slippers, more particularly of the "opera" type in which the vamp and counter portions overlap but are unattached to each other above the shoe sole, and has for its object to produce such a slipper which has incorporated therein a preformed counter stiffener.

As heretofore constructed the counter in tempered condition has been incorporated in the shoe prior to lasting and has been turned with the upper and thereafter allowed to set. This requires the use of relatively expensive counter stiffeners, adds to the amount of material to be turned and requires care in tempering and in shaping after the turning operation.

In accordance with the present invention a pre-formed or molded stiffener is used in place of the tempered counter. This preformed counter does not have to be tempered, nor turned or shaped after incorporation in the shoe.

For a more complete understanding of this invention, reference may be had to the accompanying drawing in which

Figure 1 is a perspective view of the completed slipper.

Figure 2 is a perspective of the molded counter used.

Figure 3 is a fragmentary section showing the shoe in one stage of its manufacture, the counter stiffener having been inserted.

Figure 4 is a detail section on line 4—4 of Figure 3.

Figure 5 is a perspective of the heel end portion of the shoe showing the lining in position within the stiffener

Figures 6 and 7 are sections on lines 6—6 and 7—7, respectively, of Figure 1.

Shoes of the type known as "opera" are provided with vamps such as 1, as shown in Figure 1, having free rear edges 2 extending back along the sides of the shank portion of the sole and secured thereto and inwardly of the forward ends of counter portion 3 of the shoe which overlap the portions 2 of the vamp, but which are unattached thereto above the sole. In manufacturing such a slipper in accordance with the present invention, the shoe is lasted wrong side out upon a last, the sole being in temper, and with the rear ends of the vamp at 2 overlapping the forward ends of the counter portion. This lasting is done in the usual manner with the exception that the lining of the counter portion is not lasted in and no counter stiffener is in position. The lasting having been effected, the last is withdrawn and the shoe turned, thus bringing the forward ends of the counter portion outside of the rear ends 2 of the vamp, and the sole and upper are shaped by relasting or molding on forms. The counter lining 5 is then pulled outwardly, as shown in Figures 3 and 4, and a previously molded counter stiffener 6 such as shown in Figure 2, is inserted in position. As shown in Figure 2 this counter stiffener 6 has its attaching flange portion 7 cut back from the adjacent forward ends of its side walls 8, this cutting being sufficient to bring the forward ends of the flange just back of the rear ends 2 of the vamp, when the stiffener is inserted, while the forwardly extending portions 9 of the side walls are extended in overlapping relation to the rear portions 2 of the vamp and substantially to the forward extremities of the counter portion 3 inwardly of the lining 5. The counter stiffener flange is cut back leaving the side wall portions extending forwardly thereof with the lower edges substantially in alinement or continuation with the juncture of the flange with the side walls, so that when in the shoe these forward ends extend substantially to the top face of the shoe sole and outwardly of the line of securement of the counter upper and the vamp to the sole. As shown the attaching flange 7 is provided with a downwardly extending bead 10 about its outer margin closely adjacent to the upstanding walls of the stiffener, it being preferable to so form the flange in order that it may engage the upper materials firmly outside of the stitch line of the shoe, though it is not essential. Preferably the outer face of the stiffener is coated with suitable adhesive to secure the counter upper materials 3 thereto and the attaching flange 7 is secured in position against the shoe sole in any suitable or usual manner as by tacks 13 (Figure 7) or other fastening devices. The counter lining

5, it will be noted, has its forward portion cut away as at 11. This facilitates the tucking in of this lining which is now done after a suitable adhesive has been applied to the inner face of the counter stiffener. The forward portions 12 of the lining are brought against the inner faces of the portions 9 of the stiffener and down closely adjacent to the upper face of the sole, as shown in Figure 6, the side portions of the vamp 1 being preferably folded together inwardly over the sole to facilitate this, as shown in Figure 5. The marginal portion of the counter lining back of the cut away portion 11 then engages over the upper face of the counter flange and over the inseam as shown at 15 in Figure 5 and is secured thereto not only by adhesive, but is also held in position by the shank piece 16 which overlies it in the completed shoe, as shown in Figures 1 and 7. This shank piece may have fixed thereto a shank stiffener in the usual manner.

It will be seen that in this construction a pre-formed counter stiffener has been used and yet the vamp and counter portions of the shoe are entirely unattached to each other above the sole.

From the foregoing description of an embodiment of this invention it should be evident to those skilled in the art that various changes and modifications might be made without departing from the spirit or scope of this invention as defined by the appended claims.

We claim:

1. The method of making a slipper which comprises lasting the slipper wrong side out with the sole in temper and with the rear ends of the vamp overlapping the forward ends of the counter portion and unattached thereto away from the sole and the counter lining unattached to the sole, withdrawing the last, turning the shoe, pulling the counter lining up, inserting and securing a preformed counter stiffener within the counter portion of the upper, said stiffener having a sole-attaching flange terminating approximately at the rear edges of the vamp and having side wall portions extending forwardly to the forward edges of the counter portion and outwardly of the lapping portions of the vamp, and then tucking in the counter lining and securing it to the inner face of the stiffener.

2. The method of making a slipper which comprises lasting the slipper wrong side out with he sole in temper and with the rear ends of the vamp overlapping the forward ends of the counter portion and unattached thereto away from the sole and the counter lining unattached to the sole, withdrawing the last, turning the shoe, pulling the counter lining up, inserting and securing a preformed counter stiffener within the counter portion of the upper, said stiffener having a sole-attaching flange terminating approximately at the rear edges of the vamp and having side wall portions extending forwardly to the forward edges of the counter portion and outwardly of the lapping portions of the vamp, and then tucking in the counter lining and securing it to the inner face of the stiffener, and overlying said flange.

3. In a method of making a slipper, those steps which comprise lasting the slipper wrong side out with the sole in temper, and with the rear ends of the vamp overlapping the forward ends of the counter portion and unsecured thereto away from the sole and the counter lining unattached to the sole, withdrawing the last, turning the shoe, and then inserting a preformed counter stiffener within the counter portion of the upper and securing it to the sole back of said overlapping vamp and counter portions only.

4. In a method of making a slipper, those steps which comprise lasting the slipper wrong side out with the sole in temper and with the rear ends of the vamp overlapping the forward ends of the counter portion and unsecured thereto away from the sole and the counter lining unattached to the sole, withdrawing the last, turning the shoe, and then inserting a preformed counter stiffener within the counter portion of the upper and securing it to the sole back of said overlapping vamp and counter portion only and fixing the counter lining to the inner face of the counter, and rearwardly only of said overlapping portion overlying the shoe sole.

5. A counter stiffener having a sole attaching flange terminating back of the forward ends of its side walls adjacent thereto.

6. A counter stiffener having side walls and an attaching flange extending inwardly at the lower edges of said side walls, and terminating back of the forward ends thereof, the side wall portions projecting forwardly of said flange having their lower edges substantially in continuation with the juncture of said flange with said side walls back therefrom.

7. A slipper having a sole and overlapping vamp and counter portions unsecured together above said sole, said counter portion including a counter stiffener having side portions extending forwardly of the rear ends of said vamp and a sole-attaching flange terminating back of said vamp.

8. A slipper having a sole, and vamp and counter portions secured to said sole with their adjacent ends overlapping, said counter portions including a lining unsecured to said sole at said overlapping portions.

9. A slipper having a sole, and vamp and counter portions secured to said sole with their adjacent ends overlapping, said counter portion including a counter stiffener unsecured to said sole at said overlapping portions.

10. A slipper having a sole, and vamp and counter portions secured to said sole with their adjacent ends overlapping, said counter portion including a counter stiffener having its lower edges positioned outwardly of the securement of said vamp and counter portions to said sole at said overlapping ends.

11. A slipper having a sole, a vamp secured to said sole at the forward portion thereof, said vamp including side portions extending back along the sides of the shank portion of the sole and secured thereto, and a counter stiffener secured to the rear portion of said sole and having forward extensions overlapping the secure vamp portions at the shank for a substantial extent, said forward extensions being free of the connection between the vamp and sole.

12. A slipper having a sole, and vamp and counter portions secured to said sole with their adjacent ends overlapping, said counter portion including a counter stiffener having a sole attaching flange terminating back of said overlapping portions and its sides extending forwardly of said flange in overlapping relation to said vamp.

In testimony whereof we have affixed our signatures.

MILTON L. DODGE.
HARRY L. J. DUCHEMIN.