Nov. 29, 1932. E. P. LIBBY 1,889,205

ART OF MAKING SHOES

Filed Sept. 21, 1928

Fig. 1.

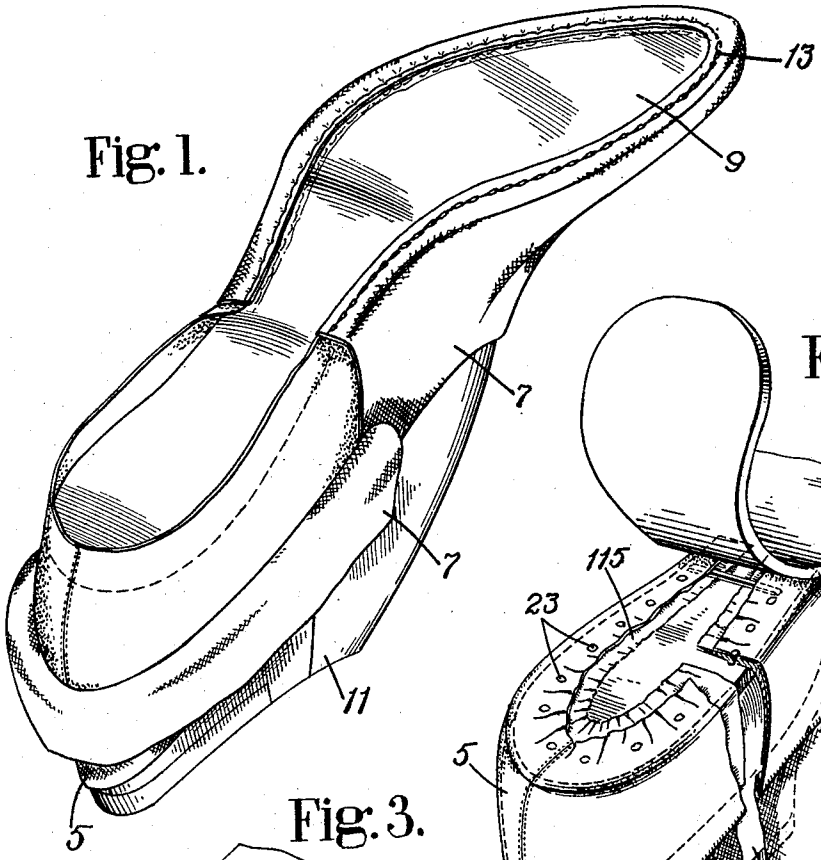


Fig. 2.

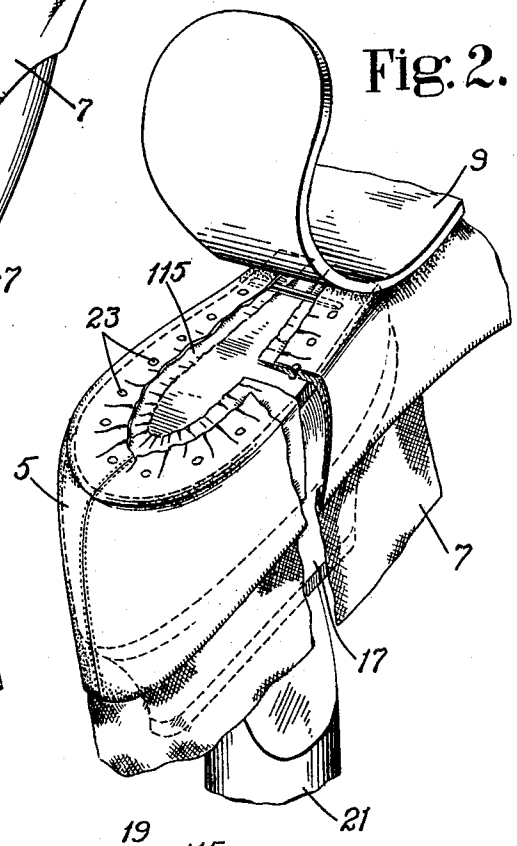


Fig. 3.

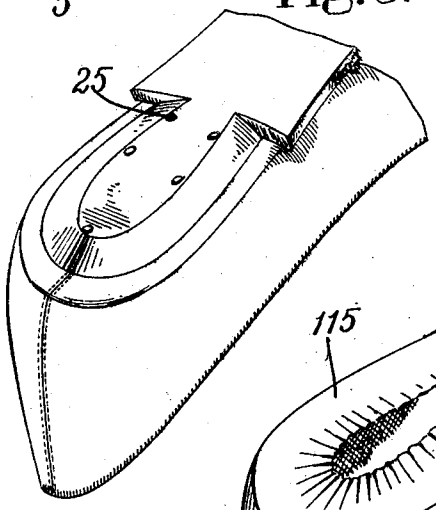
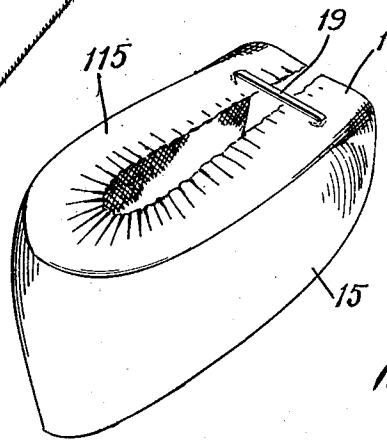


Fig. 4.



INVENTOR.

Edward P. Libby

By his Attorney,

Nelson W. Howard

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1,889,205

UNITED STATES PATENT OFFICE

EDWARD P. LIBBY, OF AUBURN, MAINE, ASSIGNOR TO UNITED SHOE MACHINERY CORPORATION, OF PATERSON, NEW JERSEY, A CORPORATION OF NEW JERSEY

ART OF MAKING SHOES

Application filed September 21 1928. Serial No. 307,408.

This invention relates to a counter particularly adapted for use in making molded counter turn shoes and to a method of making the counter.

Methods of making molded counter turn shoes may be divided into two general classes, first, those in which the molded counter is attached to the shoe while the shoe is wrong-side-out, and, second, those in which the counter is inserted in and attached to the shoe after the shoe has been turned right-side-out. In both methods the counter may or may not have a strengthening member, commonly called a "tuck", which fits inside the lower portion of the counter and is fastened to the flange of the counter. It is desirable, other things being equal, to dispense with the tuck; and the present invention provides a molded counter which has no tuck attached thereto and a method of making the counter, said counter being preferably inserted in the shoe after the shoe has been turned right-side out.

According to the present invention the forward ends of the flange of the counter are connected by a staple having one leg anchored to one end only of said flange and the other leg anchored to the other end. The illustrated counter has a wide flange the forward ends of which are held in spaced relation by a staple which bridges the gap between said ends. Such a counter may be conveniently produced by molding it with a wide flange, holding the forward ends of the flange in the desired relation and fastening the forward ends of the flange in this relation by driving a staple in such manner that one leg of the staple is anchored to one end only of the flange and the other leg to the other end only of the flange.

There is thus provided a rigid counter which will hold its shape in the shoe, and the flange of which will receive not only the lasting tacks but also part of the nails by which the heel is attached so that the counter will be securely fastened in place.

Referring now to the accompanying drawing,

Fig. 1 is a perspective showing a turn shoe wrong-side-out upon the first last after the shoe has been sewed around the forepart and shank;

Fig. 2 is a perspective showing the heel form with the counter and the shoe right-side-out upon it after the margin of the upper has been lasted over upon and tacked to the flange of the counter;

Fig. 3 is a perspective of the heel portion of a shoe to which a wood heel is to be attached, showing the heel seat nailed and shaped to receive such a heel; and

Fig. 4 is a perspective of the counter.

The counter 15 (Fig. 4) has a flange wide enough so that, in the course of the manufacture of the turn shoe in which it is to be incorporated, it receives not only the lasting tacks 23 (Fig. 2) but also the heel seat nails 25 as well as part of the nails (not shown) by which the heel (also not shown) is attached. This counter may be made by dieing a blank out of sheet stock, molding it to approximate shape and then holding the forward ends of the counter in the desired relative position and driving and clenching the staple 19. The illustrated staple is an elongated one and has one leg anchored to one of the forward ends of the counter flange and the other leg anchored to the other forward end of the flange so as to hold the two ends of the flange in the desired spaced relation.

In employing the counter in the preferred manner, an upper 5 and a lining 7 together with a sole 9 are assembled wrong-side-out upon a first last 11, the lining being slit as shown, and its rear portion turned down, as illustrated in Fig. 1. The upper and lining are fastened to the sole by a row of stitches 13 which extends around the shank and forepart of the shoe leaving the heel seat open. Fig. 1 shows the shoe at this stage of its manufacture.

The first last is now withdrawn, the shoe turned right-side-out, and the heel portion of the lining pulled out farther if necessary. A counter such as the counter 15 is placed upon an iron heel form 17, and the heel portion of the shoe is placed over it. The form 17 is preferably mounted upon the standard 21 of a heel seat lasting machine such as that

disclosed in Letters Patent No. 1,583,044, granted May 4, 1926, upon an application filed in the name of Hoyt, by which machine the lasting step of the present method may advantageously be carried out, the heel form 17 being substituted for the last pin of the machine disclosed in the Letters Patent referred to. The shoe is pulled forward to locate the counter properly in the shoe, and then the lasting machine is caused to operate whereby the margin of the upper 5 is lasted over upon the wide flange 115 of the counter and fastened to the flange by the tacks 23. Fig. 2 shows the shoe at this stage of its manufacture. The placing of the upper and the counter upon a form at this stage in the manufacture of the shoe, and the lasting of the upper over upon and the attaching of it to the counter flange permits the counter to be located accurately and fastened securely in the desired position; and the heel end of the sole, being quite unattached to the rest of the shoe, may be bent back as shown so as to be out of the way during the lasting operation.

The shoe is now removed from the heel form, the heel portion of the lining put smoothly into place with its lower margin out-turned upon the flange of the counter; and a shank piece is placed in the shoe and fastened by cement or tacks or both. The shank piece has not been shown since a shank piece is a well known part of a turn shoe, one suitable article of this kind being shown, for example, in Letters Patent No. 1,429,-694, granted September 19, 1922, upon an application filed in the name of Pope.

The second last is now inserted in the shoe and the heel seat nailed, for example, by means of the nails 25, as shown in Fig. 3, the nails 25 passing through the sole, the counter flange and the shank piece. If a wood heel is to be attached, the heel seat of the sole is trimmed as shown in that figure. The heel is then nailed on in the usual manner.

Although a particular form of counter having a wide flange the forward ends of which are held in spaced relation has been shown, it should be understood that the invention is not limited in the scope of its application to the particular counter illustrated or to the method of making this particular counter.

Having thus described my invention, what I claim as new and desire to secure by Letters Patent of the United States is:

1. A molded counter, the forward ends of the flange of which are connected by a staple having one leg anchored to one end only of said flange and the other leg anchored to the other end only of said flange.

2. A molded counter, the forward ends of which are held in fixed spaced relation by a staple which bridges the gap between said ends.

3. A molded counter, having a flange wide enough to receive the heel attaching nails of a turn shoe, the forward ends of said flange being held in spaced relation by a staple which bridges the gap between said ends and has its legs anchored respectively, one to each end.

4. The method of making a molded counter for use in turn shoes which comprises providing a counter with a wide flange and fastening the forward ends of the flange in fixed relation to each other by a staple, one leg of which passes through one end only of the flange, and the other leg of which passes through the other end only of said flange.

5. The method of making a molded counter for use in turn shoes which comprises providing a flanged counter holding the forward ends of the counter in the desired relation and fastening the forward ends of the flange in fixed, spaced relation to each other by a staple, one leg of which passes through one end only of the flange and the other leg of which passes through the other end only of said flange.

In testimony whereof I have signed my name to this specification.

EDWARD P. LIBBY.