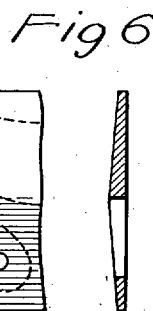
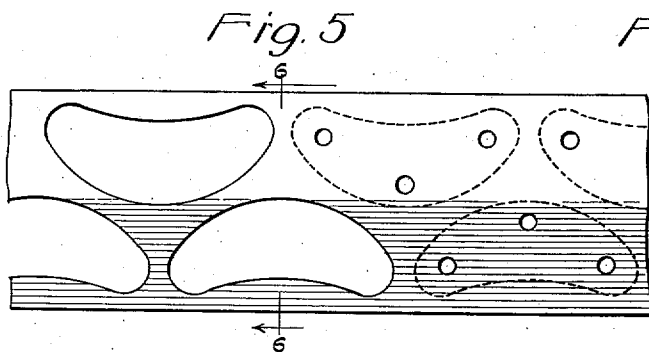
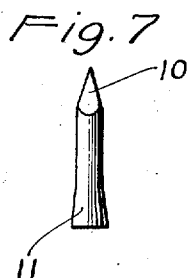
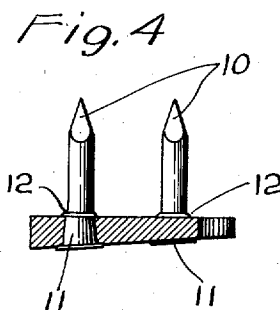
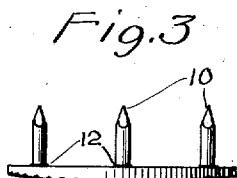
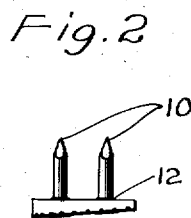
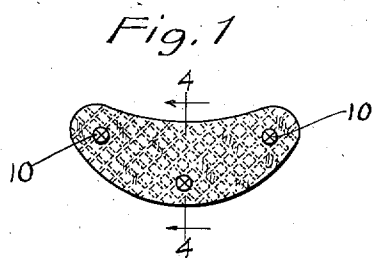


J. RICHER.
METHOD OF MAKING HEEL PLATES.
APPLICATION FILED MAY 23, 1911.

1,019,919.

Patented Mar. 12, 1912.



WITNESSES:

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METHOD OF MAKING HEEL-PLATES.

1,019,919.

Specification of Letters Patent.

Patented Mar. 12, 1912.

Application filed May 23, 1911. Serial No. 828,912.

To all whom it may concern:

Be it known that I, JOSEPH RICHER, a subject of the King of Sweden, residing at Waterbury, county of New Haven, State of Connecticut, have invented an Improved Method of Making Heel-Plates, of which the following is a specification.

This invention relates to an improved method of making heel plates for boots and shoes and has for its object to produce simple, durable and inexpensive heel plates which shall be provided with means for attaching them in place.

The invention will be hereinafter fully set forth and particularly pointed out in the claim.

In the accompanying drawing:—Figure 1 is an inverted plan view of my novel heel plate as in use; Fig. 2 an end elevation thereof; Fig. 3 a rear elevation thereof; Fig. 4 a cross section thereof on an enlarged scale; Fig. 5 a plan view of the strip from which the plates are made; Fig. 6 a cross section of the strip on the line 6—6 in Fig. 5; and Fig. 7 is an elevation of one of the nails detached.

In carrying out my process, special strips of metal are rolled as illustrated in Figs. 5 and 6. These strips are flat on one side, are thickest at the center and taper toward the edges, at which the thickness is half, more or less, the thickness at the center. The finished plates are secured in place by means of nails rigidly inserted therein in the manner which I shall presently describe. The form of nails used, greatly enlarged, is clearly shown in Fig. 7. They are pointed in the usual manner, as indicated at 10, and are provided with outwardly tapering heads 11, the taper of the heads being appreciably longer than the greatest thickness of the plates.

The piercing of the strip, the blanking out of the plates, the setting of the nails therein and the corrugation of the outer face of the plates are all performed mechanically by means of suitable punches and dies in presses. The first operation pierces holes in the strip, the punches being so located as to form the required number of holes, three in

the present instance, in the metal of the strip that will go to form each plate. The holes are made to taper from the outer side of the plate inward and receive the heads of the nails tightly. The second operation blanks out the plates, as indicated in Fig. 5, places and sets the nails tightly therein and preferably although not necessarily corrugates the outer faces of the plates as indicated in Fig. 1. It will be noted that the plates are blanked with their backs toward the center of the strip, so that the thickened center of the strip goes to form the backs of the plates, making the plates thickest at the back and tapering toward the front. By making the holes taper from the outer sides of the plates inward and the heads of the nails tapered to correspond therewith, I insure that as the plates wear away in use they will still be held just as tightly by the nails.

As already stated, the heads of the nails are made longer than the greatest thickness of the plates. The nails are rigidly locked in the plates in the setting operation by upsetting the inner ends of the heads forming collars upon the inner sides of the plates at the base of the projecting portion of the nails. These collars render it practically impossible for the nails to be forced backward through a plate when the nails are driven into a heel in making an attachment and the tapering heads of the nails retain the nails locked in the plates until the plates are completely worn away.

Having thus described my invention I claim:

The method of making heel plates comprising providing one face of a strip of metal with a flat surface and the opposite face with an angularly convexed surface tapering from the longitudinal median line to the edges, and finally blanking out the plates with the backs of the plates toward the middle or thickened portion of the strip.

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

JOSEPH RICHER.

Witnesses:

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