Dec. 16, 1952 H. BINDER 2,621,349

PROCESS OF MAKING SLIP LASTED SHOES

Filed Nov. 14, 1950

FIG. 1

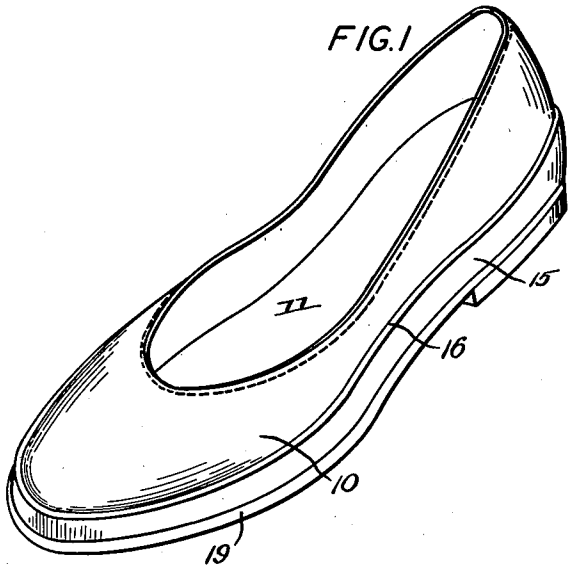


FIG. 4

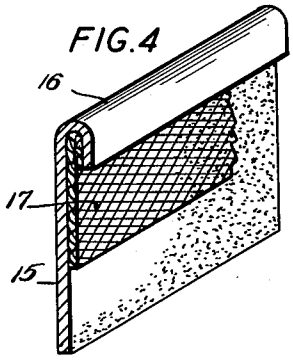


FIG. 5

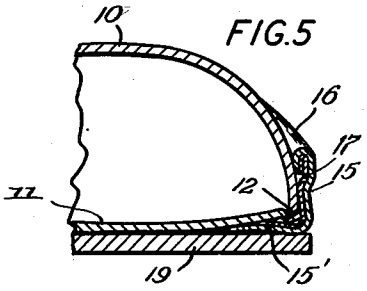


FIG. 2

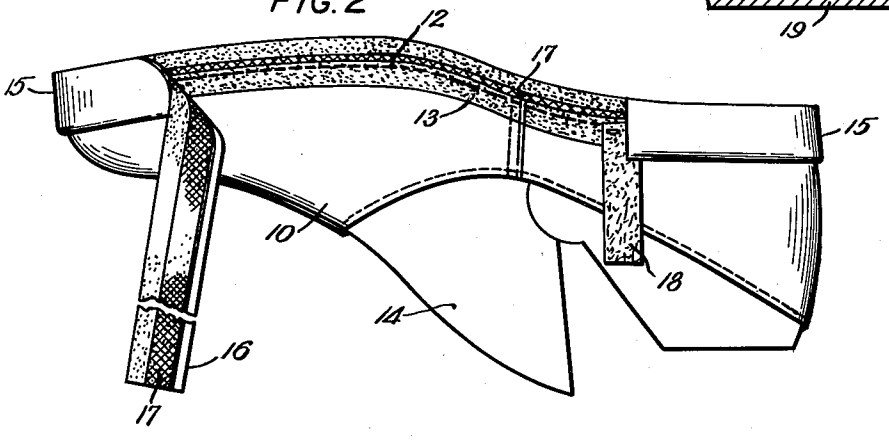
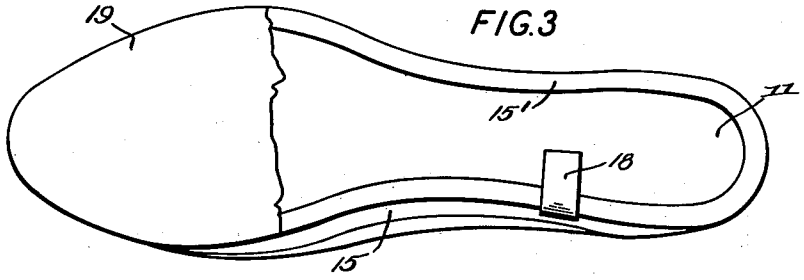


FIG. 3



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PROCESS OF MAKING SLIP LASTED SHOES

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2 Claims. (Cl. 12—142)

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This invention relates to the manufacture of slip lasted shoes and comprises a novel construction and a novel shoemaking process for producing shoes of that type which present the appearance of a platform shoe having its margin covered with a folded binding strip or presenting a so-called "mudguard" effect. The construction and process of my invention present decided advantages in economy of manufacture by simplifying the shoemaking operations to a striking degree, and eliminating or simplifying some of the operations which have heretofore required a high degree of skill on the part of the operator.

Going more into detail, the process of my invention is characterized by the steps of adhesively attaching to the upright marginal walls of the lasted upper a pre-formed binding strip presenting a folded upper edge which is disposed contiguous to the upper, and a free margin which extends beyond the outer face of the sock lining, adhesively securing the said free margin to the outer or exposed face of the sock lining and then covering it by adhesively attaching an outsole to the shoe bottom.

Heretofore it has been the practice to stitch a binding strip together with the margin of the upper to the margin of the sock lining, then lay a platform sole on the shoe bottom and subsequently fold the binding strip over the margin of the platform sole in a cover lasting operation. This cover lasting operation, which requires considerable skill, is now by my invention entirely eliminated. The desired folded edge effect is secured in the pre-formed binding strip which comes to the shoe manufacturer as a complete article already for immediate application. It will be apparent that the edge of the binding strip may be folded very much more rapidly and accurately in strip formation than it can possibly be formed in a cover lasting operation in which one edge of the binding strip is already permanently attached to the upper and in which the folding operation depends in a large measure on the accurate shape and location of the platform which it is to enclose. Moreover, in accordance with my novel process the shoemaker is at no time hampered by a binding strip hanging upon the upper. An even more important saving is effected by the present invention in that it entirely eliminates the expense of a platform sole while reproducing the effect of its presence in every detail.

These and other features of the invention will be best understood and appreciated from the following description of a preferred manner of carrying out my novel process in the production of a typical shoe, all as shown in the accompanying drawings in which:

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Fig. 1 is a view in perspective of the finished shoe,

Fig. 2 is a view in elevation illustrating the step of applying the binding strip,

Fig. 3 is a plan view of the finished shoe bottom showing the outsole as broken away,

Fig. 4 is a view in perspective on an enlarged scale of the binding strip, and

Fig. 5 is a fragmentary sectional view through the forepart of the shoe.

In the manufacture of slip lasted shoes it is customary to stitch the margin of the upper 10 to the edge of a sock lining 11 by a line of stitching 12 which may be formed by a straight needle dry thread sewing machine. The process of my invention follows these steps with the sole exception that the outer surface of the upper is roughened preferably by skiving in a marginal zone 13, as shown in Fig. 2, for the purpose of improving the adhesive bond to be formed subsequently with the binding strip. When the upper and the sock lining have been united in this manner, the last 14 is inserted and the shoe is completed in so far as the lasting operation.

The binding strip employed in carrying out my invention is best shown in Fig. 4. It comprises a continuous strip 15 of upper leather, or of suitable fabric, or plastic material uniformly folded along its upper edge 16 and having a textile reinforcing tape 17 which is adhesively secured to the inner face of the binding strip as a lining and folded within the upper edge of the strip. The exposed inner face of the strip and of the reinforcing tape is provided with an adhesive coating preferably of pressure sensitive composition. This pre-formed binding strip is supplied to the shoe manufacturer by the yard in condition for immediate use.

The binding strip may be applied to the lasted shoe as suggested in Fig. 2, the shoe being held in inverted position and the skived or roughened zone 13 having been first coated with suitable adhesive. Starting at a point adjacent to the inside shank, the operator has merely to locate properly one end of the binding strip 15 and then progressively apply it to the upright marginal wall of the upper with the folded edge 16 lying against the surface of the upper and with the free edge of the strip projecting upwardly a substantially uniform distance above the upper face of the sock lining 11. Fig. 2 represents a shoe with the binding strip 15 partially applied

in this manner. It shows the skived and adhesive coated zone 13 on the side of the upper facing observer and the projecting free margin of the binding strip as already affixed to the side of the shoe remote from the observer. It will be apparent that the operation of applying the binding strip may be very simply and accurately carried out and that the adhesive bond will be formed progressively by the mere pressure of the operator's fingers.

The binding strip is cut so that its ends may be brought into butting relation. Preferably and as herein shown, a cover tab 18, also coated with adhesive, may be stapled to the margin of the upper as indicated in Fig. 2. This tab may serve as a match mark to indicate the initial point of contact for the binding strip, and after the binding strip has been layed, the tab is folded to cover the line of the joint.

After the binding strip has been completely applied as above explained, its free edge is merely wiped in over the bottom of the sock lining 11 to form an inturned flange 15' and this is adhesively and permanently united to the outer face of the sock lining. This step is suggested in Fig. 3 in which it will be seen that the cover tab 18 is also wrapped inwardly and adhesively secured to the sock lining over the joint in the binding strip 15. Finally, the shoe is completed by laying and attaching an outsole 19. Usually this is incorporated in the shoe bottom by the well-known "Compo" process of cement attachment under adequate pressure and time.

Having thus disclosed my invention what I claim as new and desire to secure by Letters Patent is:

1. The process of making slip lasted shoes which includes the steps of roughing the outer

marginal surface of an upper, stitching the upper to the margin of a sock lining, inserting a last in the upper, adhesively attaching to the upright marginal roughened wall of the upper while supported by the last a pre-formed binding strip presenting a folded upper edge, which is disposed contiguous to the upper, and a free margin which extends beyond the outer face of the sock lining, adhesively securing said free margin to the sock lining and then covering it by adhesively attaching an outsole to the shoe bottom.

2. The process of making slip lasted shoes which includes the steps of stitching the margin of an upper to the edge of a sock lining, fastening a cover tab to the margin of the upper, inserting a last in the upper, adhesively attaching to the upright side wall of the upper a preformed binding strip presenting a folded upper edge adjacent to the upper and a lower edge projecting beyond the sock lining, turning the lower edge in over the outer face of the sock lining, folding the cover tab over the joint in the binding strip, and attaching an outsole to the shoe bottom.

HYMAN BINDER.

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