Dec. 1, 1953 J. MELTZER 2,660,743

METHOD OF MAKING RIGIDIFIED SLIP-LASTED SHOES

Filed March 19, 1952 3 Sheets-Sheet 1

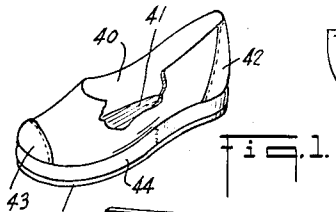


Fig. 1.

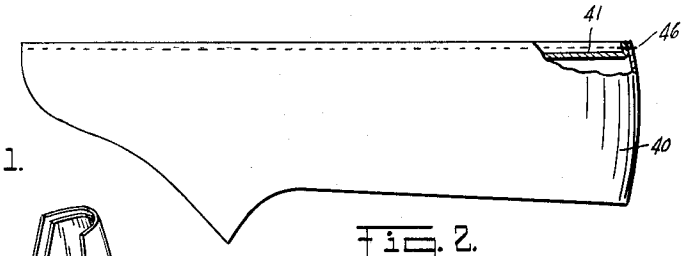


Fig. 2.

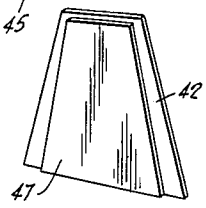


Fig. 3.

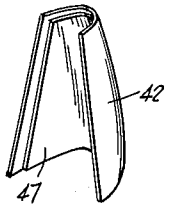


Fig. 4.

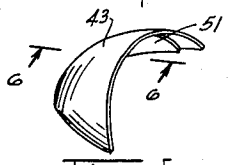


Fig. 5.

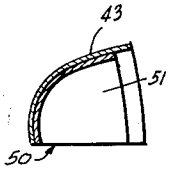


Fig. 6.

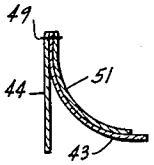


Fig. 9.

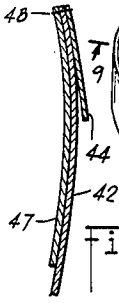


Fig. 8.

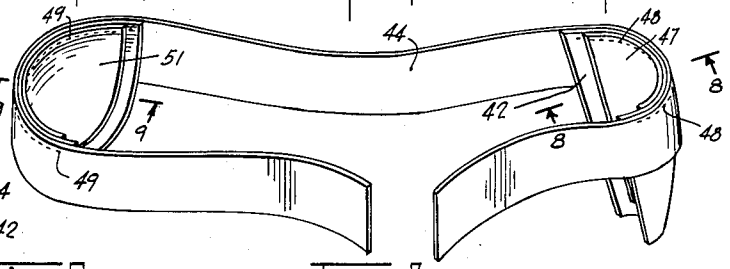


Fig. 7.

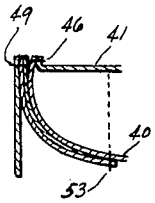


Fig. 11.

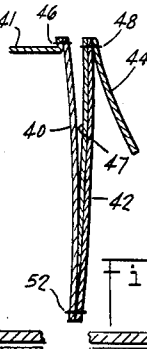


Fig. 12.

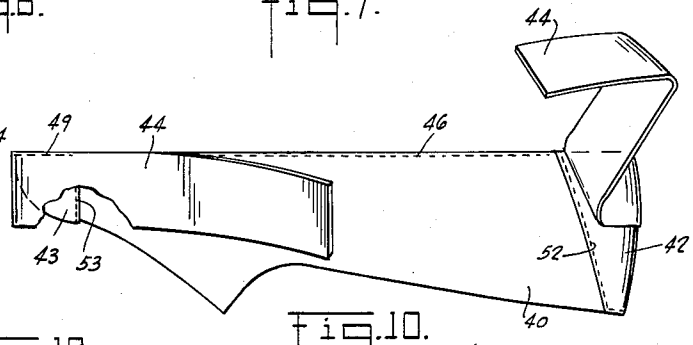
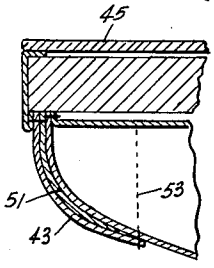


Fig. 10.



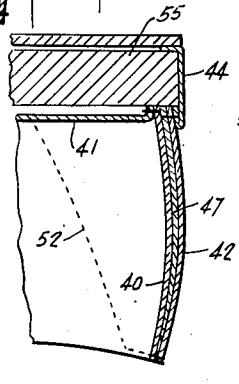


Fig. 15.

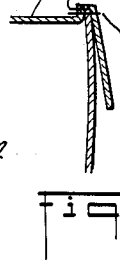


Fig. 14.

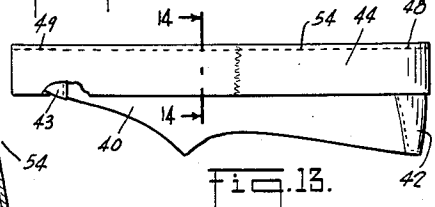


Fig. 13.

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METHOD OF MAKING RIGIDIFIED SLIP-LASTED SHOES

Filed March 19, 1952 3 Sheets-Sheet 2

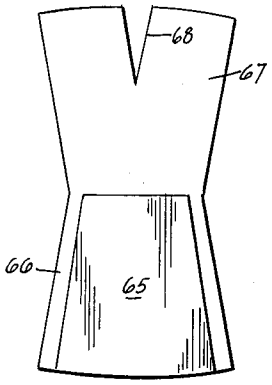


Fig. 16.

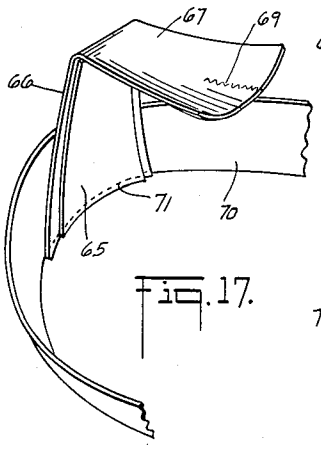


Fig. 17.

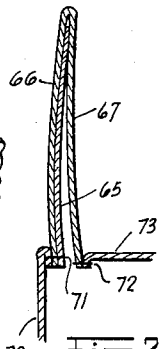


Fig. 20.

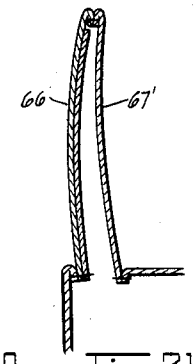


Fig. 21.

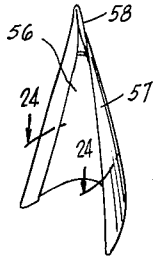


Fig. 23.

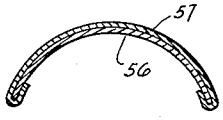


Fig. 24.

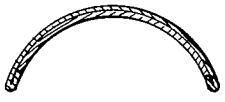


Fig. 25.



Fig. 22.

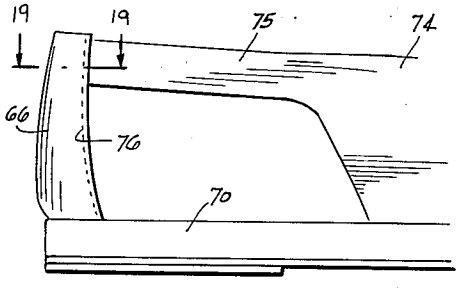


Fig. 18.

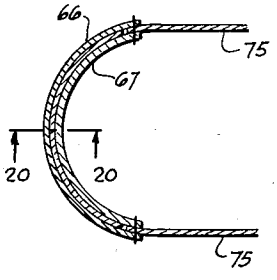


Fig. 19.

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Dec. 1, 1953 J. MELTZER 2,660,743

METHOD OF MAKING RIGIDIFIED SLIP-LASTED SHOES

Filed March 19, 1952 3 Sheets-Sheet 3

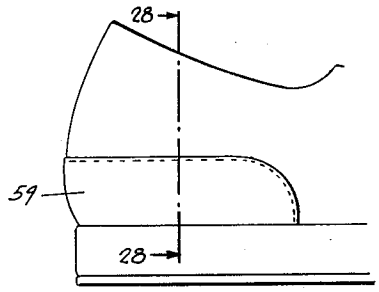


Fig. 26.

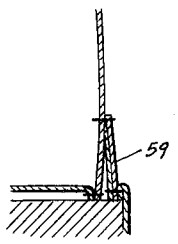


Fig. 28.

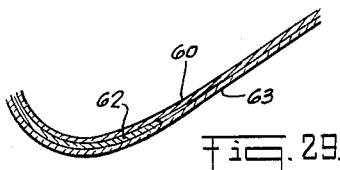


Fig. 29.

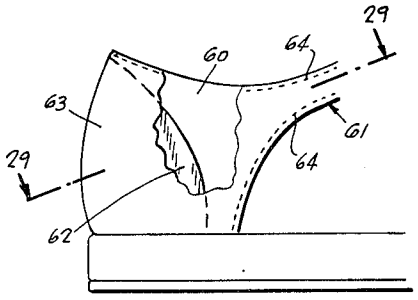


Fig. 27.

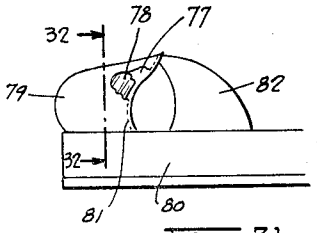


Fig. 31.

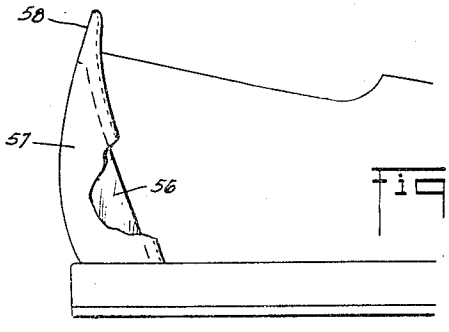


Fig. 30.

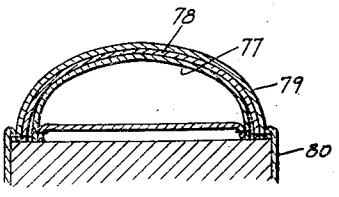


Fig. 32.

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ATTORNEY

Patented Dec. 1, 1953

2,660,743

UNITED STATES PATENT OFFICE

2,660,743

METHOD OF MAKING RIGIDIFIED SLIP-LASTED SHOES

Jack Meltzer, Los Angeles, Calif.

Application March 19, 1952, Serial No. 277,477

3 Claims. (Cl. 12—142)

1

My present invention relates generally to shoes, and has particular reference to shoes of the so-called slip-lasted type, and to certain procedural steps involved in their manufacture.

A general object of the invention is to provide a construction in which it is possible simultaneously to obtain the advantages (1) of a counter which is not only fully rigid but which is stitched into location, and (2) of a full-length sock lining stitched to the upper throughout the full extent of the upper's lower edge.

As is known, a stitched-in sock lining is highly desirable because it is not susceptible to displacement and is devoid of edges which may curl and thereby cause discomfort or impair the attractiveness of shoes having openings at the toe or elsewhere. A rigid counter is desirable for obvious reasons, lending staunchness and form-retaining qualities to the shoe and imparting a stylish and attractive appearance to it. The added advantage of stitching the counter into position lies in the fact that it is more securely held against displacement, thus avoiding premature distortion of shoe contours and impairment of comfort.

It has been found that the simultaneous stitching in of a sock lining and of a counter presents manufacturing difficulties of great magnitude. The sharp curvatures at the end regions of the shoe, where reinforcement is most commonly called for, and the manipulations required of the operator in properly guiding the parts to and through the sewing machine, have made it almost impossible, from a practical standpoint, to achieve satisfactory results, even where yieldable counters of inferior rigidity are used. Consequently, the stitching into position of a counter has usually involved not only a sacrifice in the rigidity of the counter itself but also an impairment of the appearance and workmanship of the finished shoe. Because of this, the employment of a really rigid counter of leather or fibre (as distinguished from counters formed of impregnated buckram or the like, which are only semi-rigid and tend to lose their shape and stiffness prematurely) has heretofore required that the counter be incorporated in the shoe as a separate insert fitted into a pocket specially provided for its accommodation. Due partly to variations in the counters themselves, partly to shrinkage and stretch of the parts of which the counter pockets are formed, and partly to inaccuracies in cutting, stitching and other manufacturing procedures, loose counter inserts have not proved to be entirely satisfactory since they do not always fit

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as nicely, nor stay in place as neatly, as is desirable.

The present invention is specifically aimed to obviate these difficulties and disadvantages. It provides an entirely practical method of manufacture, and a uniformly good product, in which the joint benefits of a full-length stitched-in sock lining and a stitched-in counter of full and permanent rigidity may be simultaneously achieved. The practice of the invention calls for no unusual skill and it is suitable for a variety of styles of shoes, slippers, sandals and other articles of footwear intended for either street wear or indoor use.

The invention is predicated upon a recognition of the fact that it is not the rigidity of the counter that has made it so difficult heretofore to incorporate it in the shoe by stitching, but the endeavor to stitch it into a sharply curved region in which the relationship of the other elements of the shoe, especially the sock lining and lower edge of the upper, imposes an obstacle to the freedom of manipulation of the parts during their passage through the sewing machine. To obviate this, I assemble the parts in such a way that direct attachment of the counter to the lower edge of the upper is entirely avoided. Briefly, the construction involves a counter (preferably with no lower flange) whose lower edge is stitched only to the lower margin of a counter cover and to the top edge of a platform wrapper, the counter being incorporated into the shoe, on the exterior of the upper, by means of the counter cover and the platform wrapper. A feature of the invention resides in purposely securing the counter cover to the upper only along margins other than the lower margin to which the counter is stitched, thus leaving the counter free of direct attachment to the upper and sock lining in the troublesome area.

In practice, the sock lining is stitched to the lower edge of the upper in one operation, while the assembly of counter, counter cover, and platform wrapper is performed as a separate stitching operation. Neither of these procedures presents any special difficulty, regardless of the curvatures involved or the rigidity of the counter. After these sub-assemblies have been joined together, the parts are applied to a last and the sole structure is completed in any desired well-known fashion, including the application of a platform and the covering of its edges by the platform wrapper.

The invention lends itself admirably to the

reinforcement of shoes not only in the heel region but also at the toe end, and in intermediate regions if desired. The upper can be made continuous throughout, or may be formed of sections joined in overlapping relation or spaced apart to define open-work. The shapes of the counters employed, and of the counter covers and platform wrappers, can be widely varied to suit different styles and purposes. And the sequence in which the several steps are performed may be varied in a number of respects as will be pointed out hereinafter.

Several ways of achieving the advantages of the invention are illustrated in the accompanying drawings, in which—

Figure 1 is a perspective view of an article of footwear constructed in accordance with the invention, a part of the upper being broken away to show the sock lining;

Figure 2 is an enlarged view showing how the upper of Figure 1 can be joined to the sock lining in a preliminary operation;

Figures 3 and 4 are views of the counter unit for the heel region of the shoe, before and after the counter and counter cover have been molded into adhesively bonded relation;

Figure 5 is a perspective view of the molded counter unit for the toe region of the shoe;

Figure 6 is a longitudinal cross-section substantially along the line 6—6 of Figure 5;

Figure 7 is a view showing how the platform wrapper of Figure 1 can be joined to the counter units shown in Figures 4 and 5;

Figure 8 is a cross-sectional view substantially along the line 8—8 of Figure 7;

Figure 9 is a cross-sectional view substantially along the line 9—9 of Figure 7;

Figure 10 is a view showing a step in the joining of the sub-assembly of Figure 7 to the sub-assembly of Figure 2;

Figures 11 and 12 are longitudinal cross-sectional views of Figure 10 at the toe and heel ends respectively;

Figure 13 is a view similar to Figure 10, on a reduced scale, of the parts completely joined together and ready for application to a last;

Figure 14 is an enlarged cross-section on the line 14—14 of Figure 13;

Figure 15 is a longitudinal cross-sectional view, partly broken for compactness of illustration, of the finished construction after the sole structure has been completed on the last;

Figure 16 is a plan view of a modified counter unit for the heel region of a shoe, prior to molding;

Figure 17 is a perspective view of this unit, after the counter and counter cover have been molded into a bonded unit and after the platform wrapper has been stitched thereto;

Figure 18 is an elevational view of the rear end of one type of shoe in which the assembly of Figure 17 may be employed;

Figure 19 is a fragmentary cross-section along the line 19—19 of Figure 18;

Figure 20 is a longitudinal cross-section substantially along the line 20—20 of Figure 19;

Figure 21 is a view similar to Figure 20 showing a modification;

Figure 22 is a cross-sectional view of the heel counter unit shown in Figure 4;

Figure 23 is a perspective view similar to Figure 4, showing a heel counter unit of modified design;

Figure 24 is a cross-sectional view along the line 24—24 of Figure 23;

Figure 25 is a view similar to Figure 24 showing a possible modification;

Figures 26 and 27 are views similar to Figure 18, showing the heel regions of other styles with which the invention may be employed;

Figure 28 is a fragmentary cross-section on the line 28—28 of Figure 26;

Figure 29 is a fragmentary cross-section on the line 29—29 of Figure 27;

Figure 30 is a view similar to Figures 18, 26 and 27 showng the heel region of a shoe style employing the counter unit of Figure 23;

Figure 31 is an elevational view of the front end of a modified shoe style with which the invention may be employed; and

Figure 32 is a cross-sectional view along the line 32—32 of Figure 31.

The article of footwear depicted in Figure 1 has an upper 40, a sock lining 41, a heel reinforcement or counter covered by the counter cover 42, a toe reinforcement or counter covered by the counter cover 43, a platform whose edge is covered by the platform wrapper 44, and an outer sole 45. For the sake of simplicity, the upper has been shown as a single uninterrupted element, but the invention is not restricted to this or any other particular style of upper. Nor is it restricted to the particular shapes or styles of counter covers and platform shown in this figure.

One way of forming the shoe of Figure 1 is illustrated in Figures 2–15.

Figure 2 shows how the upper 40 may be joined to the sock lining in a separate preliminary operation. The sock lining extends the full length of the shoe and its edge is stitched at 46 to the upper throughout the full extent of the upper's lower edge.

Figures 3 and 4 show the counter unit employed in the heel region. The practice of the invention imposes no restrictions or limitations upon the selection of the counter material, hence any desired material may be used. I prefer to form the counter 47 of a material of high quality, such as leather or fibre, moldable to the same permanent state of complete rigidity as that of the conventional hard counters heretofore regularly used as separate inserts fitted loosely into counter pockets specially provided for the purpose. The marginal regions of the counter may be skived or tapered, if desired, although this is not essential. Sometimes it is preferable to skive one or more margins and to leave others of normal thickness. In any case, the practice of the invention imposes no necessity for thinning any of the margins of the counter merely to facilitate stitching operations. For this reason, and also to simplify the disclosure, no skiving of counters has been shown in any of the figures.

For a heel reinforcement of the kind shown in Figure 1, the counter 47 may have a substantially trapezoidal shape, as indicated in Figure 3. The counter cover 42 is larger in area than the counter 47 but its lower edge is preferably even with the lower edge of the counter. The cover is composed of a material that is relatively soft and limp, such as leather or fabric. Since it will be exposed on the outside of the finished shoe, a large variety of materials are suitable, and the choice will depend upon the ornamental effect desired.

In the construction illustrated, the shape of the cover 42 is substantially the same as that of the counter 47, and its side and top margins extend only slightly beyond the corresponding

edges of the counter. It is by no means essential, however, that the shapes of the counter and of its cover be similar, and the cover may have a configuration quite different from that of the counter, with its margins extending considerably beyond those of the counter. Under certain circumstances (e. g., when the top edge of the cover is engaged by a binding or collar) the top edges of the counter and counter cover may be even with each other.

By employment of heat and pressure, and other procedures and apparatus well known per se, the counter and cover are molded to the appropriate desired curvature, as shown in Figure 4, and are at the same time adhesively bonded together into the form of a single unit.

In accordance with my invention, the lower edge of the counter unit is secured, by stitches **48** (Figure 7) to the top edge of the platform wrapper **44** which is laid right-side down upon the convex face of the counter unit. Regardless of whether the lower edges of the counter and counter cover are even with each other, as shown in the present drawings, the stitches **48** pass through the counter as well as through the cover. They preferably terminate short of the side edges of the cover **42**, for a purpose presently to be explained.

In the shoe illustrated, there is a counter also at the toe end, although it will be understood that the use of a counter at one or the other end of the shoe, or both, or in any intermediate region, is a matter or choice and depends upon the style and purpose to be achieved. Where the toe counter is to have the general shape indicated in Figure 1, a unit such as that shown in Figures 5 and 6 may be preliminarily formed. Here, too, no limitation upon material selection is imposed by the invention, hence any desired counter material, such as leather, fibre, or equivalent substance, may be used. The counter **51** is in this case of appropriate initial shape and final curvature for use at the toe, and it is adhesively bonded to the cover **43** in accordance with procedures hereinbefore referred to and well known per se. The side and top edges of the cover extend beyond the corresponding edges of the counter, as shown. The bottom edges of the counter and cover may be arranged even with each other, as best shown at **50** in Figure 6.

The unit of Figure 5 is also secured along its bottom edge to the platform wrapper **44**. This is done by means of stitches **49** which pass through the counter as well as through the counter cover and preferably terminate short of the side edges of the cover **43**.

Where the platform wrapper is formed of a single length of material, it may be provided in advance with positioning notches or marks (not shown) that assure proper location thereon, with respect to each other, of the two counter units. A single platform wrapper strip **44** has been shown in the present drawings. It extends around the entire shoe periphery and its ends overlap, preferably on the inner side of the shoe in the shank region. Obviously a platform wrapper of shorter length, or of varying width, or of sectional or pieced character, may be used if the nature or style of the shoe so requires.

If counters are to be used in addition to those at the heel and toe, correspondingly constructed counter units, appropriately contoured and preliminarily molded, are also stitched to the platform wrapper at this stage of the procedure, in the manner indicated in Figure 7.

Regardless of the stiffness or quality of the counter material, and regardless of the sharp curvatures involved, neither of the stitching operations **48** and **49** presents any manufacturing difficulty. Sewing machines of quite usual and well known kind are easily able to join the parts as shown, and no particular skill is required of the operator, as will be recognized by those familiar with shoe manufacturing techniques.

The next step is to unite the sub-assemblies of Figures 2 and 7. This is achieved in the two stages indicated in Figures 10 and 13. Each counter unit is applied to the exterior of the shoe upper in the appropriate region, and is secured to the upper in any desired or suitable manner, as by stitching, lacing or gluing, or (preferably) by combined use of these expedients. In no event, however, is any stitched connection made or attempted along the troublesome lower edge of the counter unit. For example, in the construction herein illustrated, the heel counter cover **42** is stitched to the upper **40** along its sides and top (see Figure 10) by stitches **52**. To facilitate this operation, the platform wrapper **44** may be swung back, as indicated, and it is for this reason that the lines of stitches **48** and **49** were purposely terminated as hereinbefore mentioned. In similar fashion the sides and top of the counter cover **43** in the toe region are stitched to the upper by means of stitches **53**. (It is usually in the toe region that lacing may sometimes be used to advantage instead of stitching.) The use of adhesive to enhance the firm securement of the counter units is optional, where stitching or the like is employed. In some cases, adhesive alone may be found to be sufficient.

The second stage of this phase of the process involves stitching into position those parts of the wrapper **44** which have been left unattached. This is achieved by means of stitches **54** (Figure 13) which are continuations of the lines of stitches **48** and **49** and which preferably overlap the latter to a slight degree. The degree of overlap is not critical since there is no counter pocket involved, the counter having been already stitched into its proper position. In this respect, the present procedure affords a distinct advantage over that described in my Patent No. 2,493,497, since the corresponding overlapping of stitches in that case reduces the entrance opening of the pocket into which a loose counter is still to be inserted.

The stitches **54** extend through the upper **40** and through the sock lining **41**, and lie closely adjacent to the stitches **46**, as shown in Figure 14. No sewing difficulties are encountered, since the parts involved are relatively soft and are readily manipulable in well known fashion as the stitching progresses.

The parts are now ready for application to a last (not shown) and for completion of the sole structure. This may be of any desired character. In the shoe illustrated, the final steps of manufacture involve merely the application of the platform **55** (Figure 15), the covering of its edges by the platform wrapper **44**, and the final application of the outer sole **45**. The use of adhesives, and of other expedients well known in the art, may be resorted to. Additional filler elements or pads, shank stiffening pieces, etc., may be used wherever desirable. One of the advantages of the invention lies in the fact that the platform wrapper fits more smoothly over the edge of the platform in the sharply curved rein-

forced regions of the shoe because it is free of direct connection with the sock lining in those regions.

It is to be understood that the relationships of the parts are somewhat exaggerated and schematically represented in Figure 15. In actual practice, the parts adjust themselves into a compacter relation than that shown.

The finished shoe has a smooth comfortable interior devoid of stitches, linings, counter covers, or other elements whose edges or whose wrinkling might create discomfort. The reinforcements, wherever they may be located, are firm, stitched into position, and long lasting. The counters employed may be of the finest quality, and need not have flanges at their lower ends, thus eliminating such flanges as possible sources of discomfort. On the other hand, the use of a short flange, to round off the bottom edge of the counter, is not precluded if it is deemed to be desirable.

In a number of respects the procedure may be varied without altering the basic idea. For example, under certain circumstances it may be desirable to secure the top edge of the counter unit to the top edge of the upper before the lower edge of the counter unit is stitched to the platform wrapper, or before the sock lining is stitched to the lower edge of the upper. The last-mentioned sequence is preferred where the upper is composed of sections. In such a case it is preferred first to secure the top edge of the counter unit to the corresponding section of the upper, then to join the various sections of the upper, and then to stitch in the sock lining.

The top edge of the upper has been left "raw," as it were, in Figures 1–15. It will be understood that this showing is merely for the sake of simplicity of illustration, and that any usual finish may be provided for, such as a turned-in edge, a binding such as a French cording, a turned down collar or other trimming, etc.

For a similar reason I have shown all the edges of the counter covers in "raw" state. (See Figure 22.) This is not objectionable where the edge is to be concealed (as is the case, for example, with respect to the lower edge, and would be the case with respect to the top edge where the latter is sewed in or caught beneath a binding or collar), but in the case of edges which are to be exposed (such as the side edges of the counters shown in Figures 1–15) it may be desirable to turn in the edge as indicated in Figures 24 and 25. In the former, the edge of the cover is turned in to overlie the adjacent margin of the counter; in the latter, the edge of the cover is turned in to lie in the plane of the counter but not in overlapped relation to it. Depending upon the material of which the counter cover is made, this turning in of one or more edges may or may not be of advantage. Where it is done, however, it is a step which precedes the stitching of the edge, as will be understood.

Figure 23 is illustrative of how the counters and counter covers may be varied in their relationships to each other. In this figure I have shown a heel counter **56** bonded into unitary relation to a cover **57** which extends upwardly beyond the top edge of the counter to form a sort of peak **58**. This is useful in a shoe of the style shown in Figure 30, the peak **58** serving not only as an ornamental embellishment which projects up beyond the top edge of the upper but also as an aid in pulling the shoe onto the foot.

The counter and cover can also be made to terminate short of the top edge of the shoe. Such a style is shown in Figure 26, in which the top edge of the counter cover **59** lies well below the top edge of the upper itself.

The shoe upper, as mentioned, can be made of sections joined together. Where these sections include two which are connected along a vertical seam at the rear end of the shoe, the heel counter and counter cover of the present invention may serve the additional function of concealing this seam.

The possibility of making the upper of sections leads to another advantage of the invention arising from the fact that the section of the upper which is to be reinforced, hence covered over and concealed by the counter unit, may be made of less expensive or thinner material than other exposed parts or sections of the upper.

The sections of the upper need not necessarily be joined to form an uninterrupted whole, nor need they necessarily be joined to each other at all. For example, the type of shoe shown in Figure 10 of my Patent No. 2,493,497, in which the vamp and the quarter are completely separated, may be constructed in accordance with the present invention, as will be readily understood. Gaps in the upper, whether they are in the shank region of the shoe or elsewhere, do not preclude the practice of the invention.

In Figure 27, the style is one in which the upper has a quarter **60** spaced from the forward parts (not shown) and in which the quarter is extended to define a strap **61**. The bonded premolded counter unit in this case is formed of the counter **62** and of the cover **63**. The latter extends forwardly beyond the counter and conforms substantially to the contours of the quarter **60**. Along the lines of stitching **64**, which join the counter cover to the upper, the edges may be turned in, if desired, as will be readily understood, although this is obviously not essential and has not been depicted.

A modification which is particularly useful where the upper is composed of spaced sections is illustrated in Figures 16–20. The counter **65** and its cover **66** may be substantially the same in shape and character as the corresponding elements shown in Figures 3–4. In this case, however, the cover **66** is joined along its top edge to the element **67** which is ultimately folded forwardly, as shown, to constitute a section (in this case the quarter) of the upper of the shoe. The parts **66** and **67** are areas of a single initial blank of material, and the area **67** may be provided with a notch **68** adapted to be seamed closed as at **69** (Figure 17) to impart the desired curvature to it.

The procedure involved in forming the shoe is substantially the same as that hereinbefore described. The counter **65** and the cover **66** are subjected to the well known heat and pressure treatment to mold the counter into the desired curvature and to bond it adhesively to the cover. The lower edge of the resultant counter unit is then stitched to the platform wrapper **70** by a line of stitching **71** which passes through both the counter and the counter cover. In a separate operation, performed either before or after the stitching **71**, the lower edge of the part **67** is stitched, as at **72**, to the sock lining **73**. The side margins of the counter cover **66** are then stitched, as at **76**, to the section or quarter **67**, and then those parts of the wrapper **70** as yet unattached

are stitched to the upper and the sock lining in the corresponding regions of the shoe. Finally, the assembly is applied to a last (not shown) and the sole structure completed.

The reinforced quarter can be left standing alone (in which case the shape would probably be somewhat different from that shown), or it can be joined in various ways to other parts of the upper. One possibility, illustrative of a variety of expedients that could be used, lies in providing the vamp part 74 (Figure 18) with rearwardly extending strap-like parts 75 which can be engaged by the stitches 76 (or by separate stitches) and thus held in sandwiched position between the quarter 67 and the counter cover 66.

The construction of Figures 16–20 can obviously be modified, if it should prove desirable or advantageous to do so, by joining the parts by means of a seam instead of forming them as areas of a single piece. This is indicated in Figure 21 which corresponds in every respect to Figure 20 except that the counter cover 66′ is joined to the upper section 67′ along the top edge by means of an inturned seam, as shown.

Figure 31 shows the forward end of a shoe in which the upper is formed of sections one of which is at the toe end and is spaced from the adjacent one. The section 77 is reinforced by a counter unit which overlies it and has substantially the same shape. The counter unit consists of the counter 78 and the counter cover 79, these parts being adhesively bonded into a unit in the manner hereinbefore described. The lower edge of the unit is stitched to the wrapper 80, and the side and top edges of the cover 79 are stitched, as at 81, to the upper element or section 77. I have illustratively shown an adjacent section 82 of the upper, in the form of a strap-like element extending across the shoe, joined in any desired manner to the top edge portion of the section 77.

In other styles (not shown) the section 77 might extend upwardly and rearwardly to a greater degree, engaging with two or more strap-like sections of the upper, or contoured in a variety of ways. In any such case, the construction shown would apply, and the same procedure could be followed, the only difference being that the counter cover 79 would probably be extended upwardly beyond the upper edge of the counter, in a manner similar to that described in connection with Figure 27.

The type of counter unit shown in Figure 16 could obviously be employed in the toe region, or elsewhere, by simply modifying its contours and curvatures.

In general, it will be apparent that the advantages of the invention may be achieved in an almost innumerable variety of styles, and for this reason many of the details herein described and illustrated are merely illustrative, as will be understood.

Having thus described my invention and illustrated its use, what I claim as new and desire to secure by Letters Patent is:

1. In the process of making a slip-lasted shoe rigidified in at least one of its sharply curved end regions, the steps which consist in stitching a full-length sock lining to an upper throughout the full extent of the upper's lower edge, separately stitching the lower edge of a rigid counter of appropriate relatively sharp curvature to the lower margin of a counter cover and to the top edge of a platform wrapper, applying the counter to the exterior of the upper, securing the counter cover to the upper only along margins other than said lower margin so that the lower edge of the counter is left free of direct attachment to the lower edge of the upper, then force lasting the assembly and while it is on said last applying a platform and covering its edge with said platform wrapper.

2. The procedural steps defined in claim 1, in which the upper is formed of sections, and in which the counter cover and section of the upper which it is intended to overlie are joined together along their top edges prior to the assembly of the sections of the upper into final stitched relation to the sock lining.

3. The procedural steps defined in claim 2, in which the counter cover and the section of the upper which it is intended to overlie are formed of a single element of material.

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