June 22, 1948. F. L. AYERS 2,443,588

METHOD OF MAKING SLIP LASTED SHOES

Filed March 23, 1946

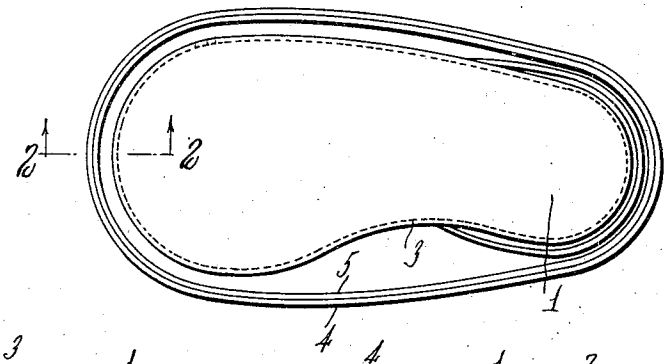


Fig. 1.

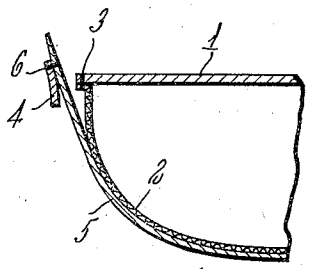


Fig. 2.

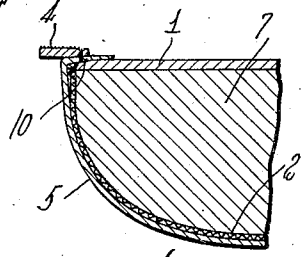


Fig. 3.

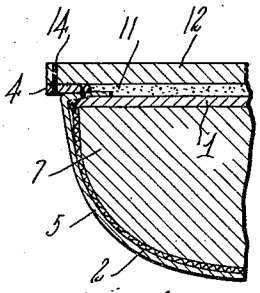


Fig. 4.

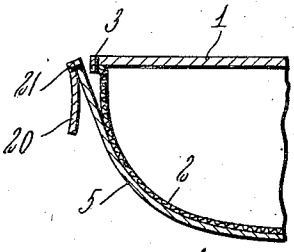


Fig. 5.

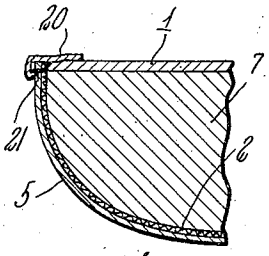


Fig. 6.

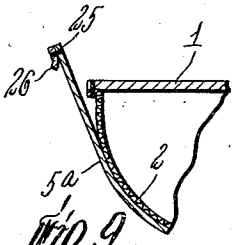


Fig. 9.

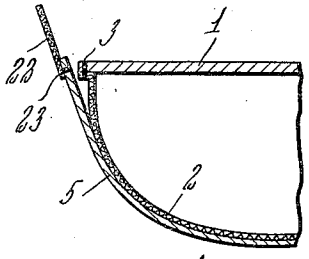


Fig. 7.

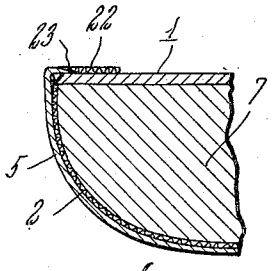


Fig. 8.

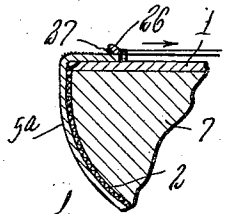


Fig. 10.

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METHOD OF MAKING SLIP LASTED SHOES

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3 Claims. (Cl. 12—142)

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This invention relates to shoes and to their construction, and has for an object to provide a method wherein no lasting allowance for the upper is necessary though, if desired, the outer may be pulled onto the last in order to shape it to the last.

In accordance with this invention, therefore, a thin, flexible innersole is secured about its margin to the shoe lining, and this assembly is slip lasted, after which the outer with a securing strip or welt is pulled over and secured, and the shoe is then completed.

Further objects and advantages will appear from a description of certain embodiments of the invention shown in the accompanying drawings in which

Figure 1 is an inverted plan view of the shoe parts in condition for slip lasting.

Figure 2 is a detail sectional view on line 2—2 of Figure 1.

Figure 3 is a view similar to Figure 2, but showing the outer lasted.

Figure 4 is a view similar to Figure 3, but showing further steps in the making of the shoe.

Figures 5 and 6 are views similar to Figures 2 and 3, respectively, but showing a modification.

Figures 7 and 8 are views similar to Figures 5 and 6, respectively, but showing another modification.

Figure 9 is a view similar to Figures 2 and 5, but showing still another modification.

Figure 10 is a view similar to Figure 9, but showing the shoe in a more advanced condition.

Referring first to Figures 1 to 4, a flexible innersole 1 is marginally secured to the lining 2 of a lined shoe upper, as by a line of stitching at 3. The marginal portion of the outer, which is at this time unsecured to the innersole, previously had applied thereto a welt strip 4. As shown in Figure 2, the welt strip has its outer face turned toward the outer face of the outer 5 and is secured to this outer in overlying relation as by the stitching 6. After the lining and innersole margins have been secured together, the shoe is slip lasted, the last being shown at 7 in Figures 3 and 4. Thereafter the outer is lasted over, bringing the welt 4 into partly underlying relation substantially parallel to the innersole 1 and having its outer margin extending outwardly from the margin of the outer 5 as shown in Figure 3. Such lasting may be effected, if desired, by engaging suitable clamp members between the outer edge of the welt strip and the upper in accordance with the well known pre-welt method of lasting. While the upper is held in this

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condition, either by cement securing the inwardly turned edge portion 10 of the outer, or by maintaining the lasting mechanism in lasting position, a filler 11 may be inserted against the lower face of the innersole 1 to bring the outer surface of the sole to substantially the transverse plane of the lower face of the welt 4 and an outersole 12 is then applied and secured to the welt 4 as by outersole stitches 14. This construction provides a shoe having the appearance of a welt shoe, but permits the shoe to be initially lasted by the slip lasting method and permits the outer to be pulled onto the last.

Instead of forming the marginal strip applied to the outer as a welt, it may be otherwise formed as illustrated, for example, in Figures 5 to 10. Referring first to Figures 5 and 6, instead of the welt strip 4, a thin flexible strip 20 may be employed, secured to the marginal portion of the outer as by the stitching 21. When the outer is pulled over, the free edge of this strip 20 may be brought around to enclose the outer face of the stitching 21 as shown in Figure 6, bridging over its margin together with the margin of the outer 5, and it may be brought in to overlie and be cemented to the innersole 1 as shown in Figure 6. This provides a beaded effect to the lower edge of the upper. An outersole may then be applied against the in-turned edge portion of the strip 20, using a filler, if desired, or necessary, between the outersole and innersole.

In Figures 7 and 8, a strip 22 of canvas, or the like, is secured to the lower margin of the outer 5 as by stitches 23. This strip 22 is of a more or less porous material, such as canvas, to which cement will readily adhere without requiring any roughing operation as is usually necessary when the grain face of leather is being conditioned to take cement. This strip 22 forms substantially a lasting allowance continuation of the outer, and it may be grasped by the pulling pinchers or other suitable mechanism by which the outer may be pulled over and the strip laid down against the face of the innersole 1 where it may be cemented as shown in Figure 8. This construction permits the cutting of the upper without lasting allowance, and provides a surface to take the cement which requires no roughing which would be required with lasting allowances on upper materials of many types. The outersole may then be secured against the innersole and the strip 22, with or without a filler as may be necessary, depending upon the thickness of the strip 22, and other shoemaking factors.

A third method of employing a marginal strip

for the outer is illustrated in Figures 9 and 10. In these figures, the outer 5*a* is shown as provided with a lasting allowance, and to its margin is secured, as by stitching 25, a narrow marginal strip 26. When the shoe is to be lasted a flexible non-extensible cord or wire 27 (see Figure 10) may be engaged between the strip 26 and the outer 5*a* outwardly of the stitching 25, so that when this strand 27 is pulled at opposite ends, the outer may be pulled inwardly around the lining and innersole into the lasted position shown in Figure 10, the lasting allowance portion of the outer being brought in against the outer margin of the innersole. The parts may be secured in this position as by the use of a temporary cement, after which the strand 27 may be removed. The outer surface of the outer 5*a* may then be roughed in the usual manner, this roughing also removing the strip 26 which has served its intended purpose in facilitating the lasting in of the outer. The parts being thus conditioned, an outersole may be cemented to the inturned margin of the outer, with or without a filler between it and the innersole, as may be found desirable.

From the foregoing description of certain embodiments of this invention it should be evident to those skilled in the art that various further changes and modifications might be made without departing from the spirit or scope of this invention.

I claim:

1. The method of making a shoe, which comprises marginally securing an innersole to the lining of a shoe upper, the outer of which is provided with a marginal strip on its outer face, slip lasting, applying a flexible non-extensible strand about said outer outwardly of and engaging said strip, pulling the outer over said last by pulling opposite end portions of said strand in the proper directions, securing the pulled over outer and removing said strand, and thereafter completing the shoe.

2. The method of making a shoe, which comprises marginally securing an innersole to the lining of a shoe upper, the outer of which is provided with a marginal strip on its outer face, slip lasting, applying a flexible non-extensible strand about said outer outwardly of and engaging said strip, pulling the outer over said last by pulling opposite end portions of said strand in the proper directions, securing the pulled over outer and removing said strand, removing said strip, and thereafter completing the shoe.

3. The method of making a shoe, which comprises marginally securing an innersole to the lining of a shoe upper, the outer of which is provided with a marginal strip on its outer face, slip lasting, applying a flexible non-extensible strand about said outer outwardly of and engaging said strip, pulling the outer over the last by pulling opposite end portions of said strand in the proper directions, securing the pulled over outer and removing the strand, roughing the outer surface of the in-turned margin of the outer and removing the marginal strip by the roughing operation, and cementing an outersole to said roughened margin.

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