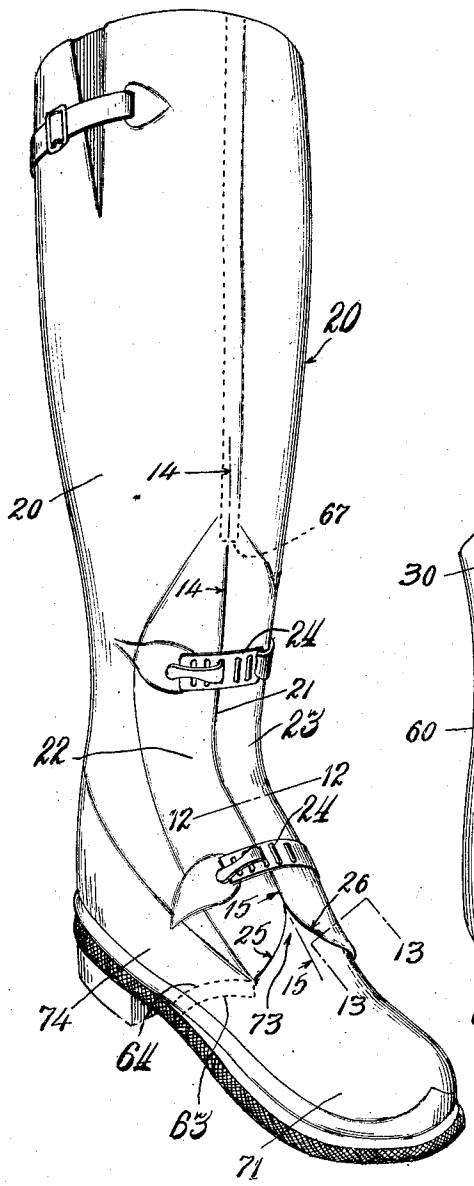
July 22, 1930. G. L. VAN DINTER ET AL 1,771,277

FORM FITTING BOOT AND METHOD OF MAKING SAME

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Fig. 1.



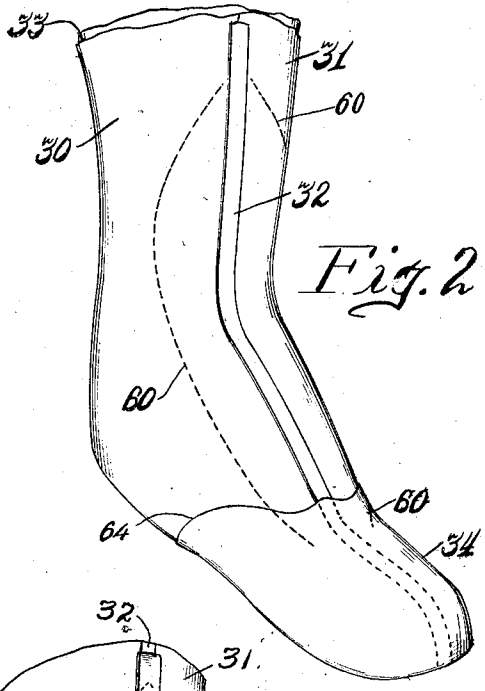


Fig. 2.

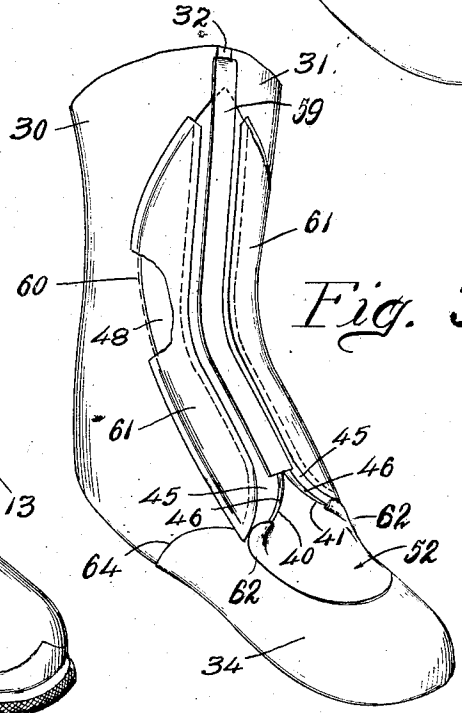


Fig. 3.

Inventors.
George L. VanDinter
and Conrad Ferrettie
By: Eugene M. Giles
Attorney.

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FORM FITTING BOOT AND METHOD OF MAKING SAME

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Fig. 4.

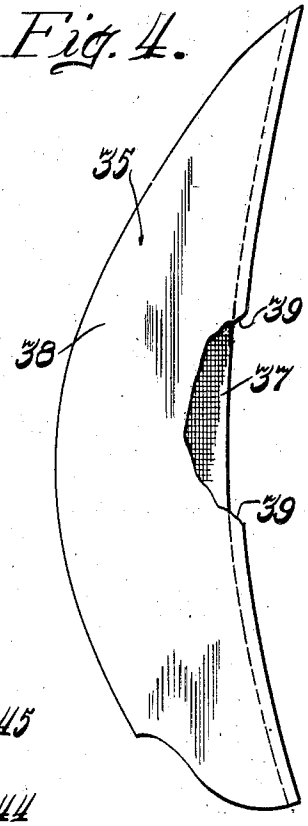


Fig. 6.

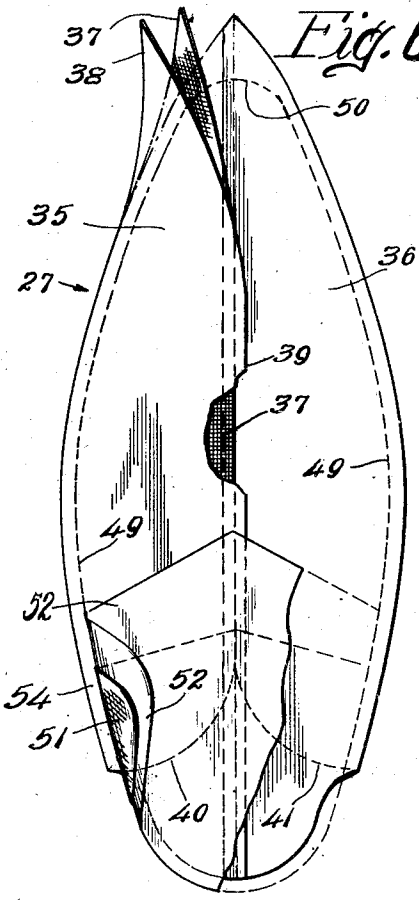


Fig. 7.

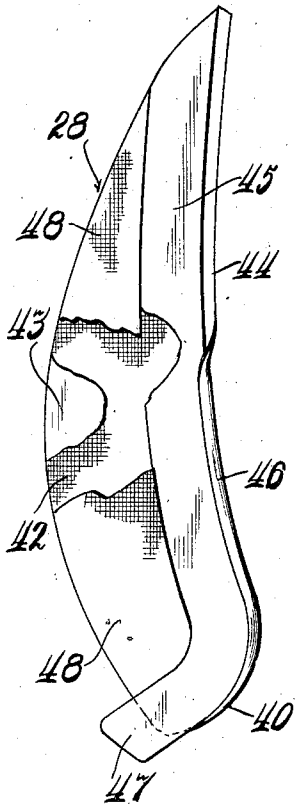
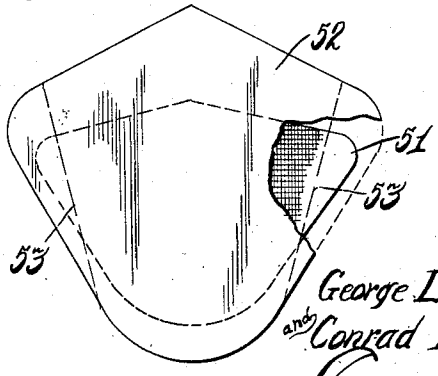


Fig. 5.



Inventors.
George L. VanDinter
and Conrad Ferrettie.
By: Eugene M. Giles
Attorney.

July 22, 1930. G. L. VAN DINTER ET AL 1,771,277

FORM FITTING BOOT AND METHOD OF MAKING SAME

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Fig. 9.

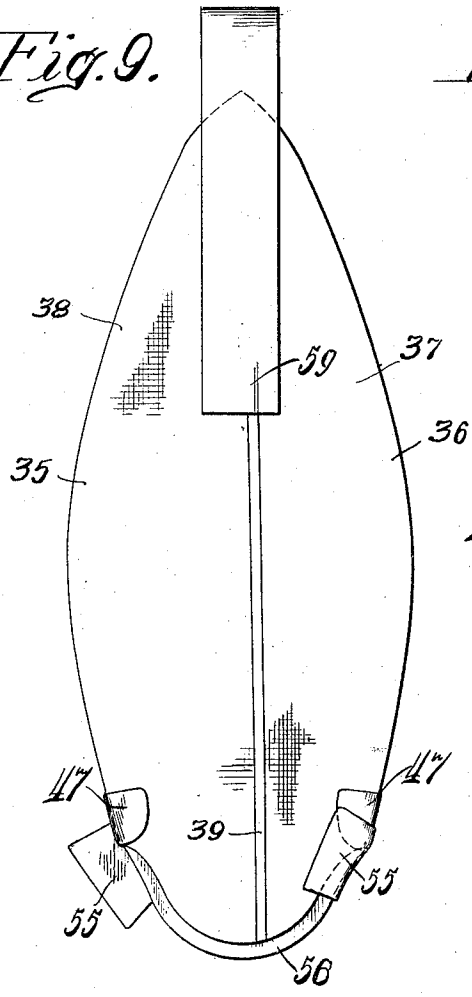


Fig. 8.

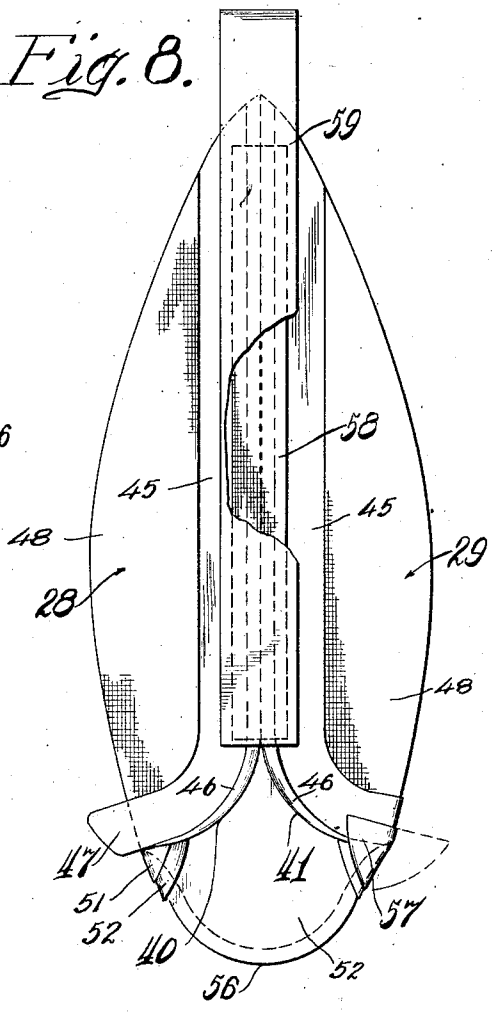
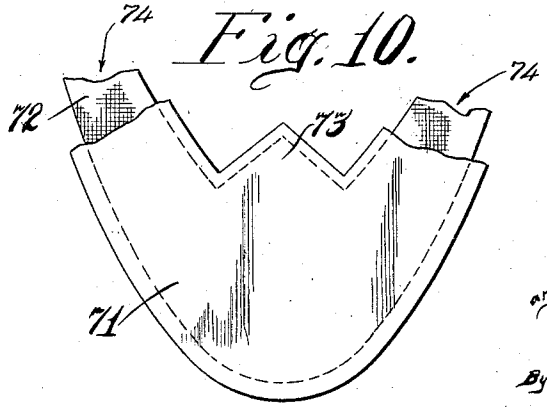


Fig. 10.



Inventors
George L. VanDinter
and Conrad Ferrettie.
By: Eugene M. Giles
Attorney.

July 22, 1930. G. L. VAN DINTER ET AL 1,771,277

FORM FITTING BOOT AND METHOD OF MAKING SAME

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Fig. 12.

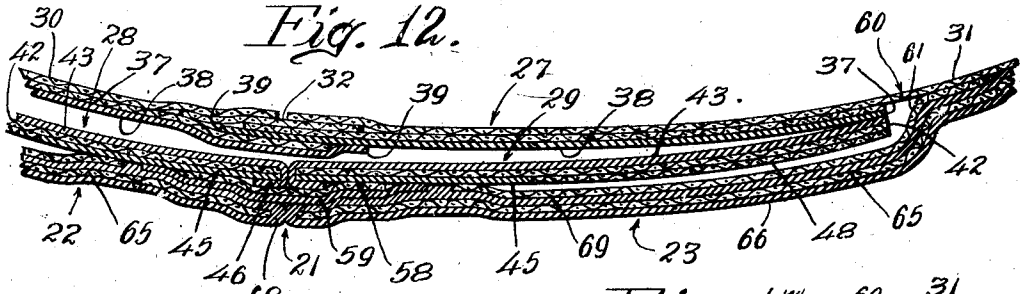


Fig. 11.

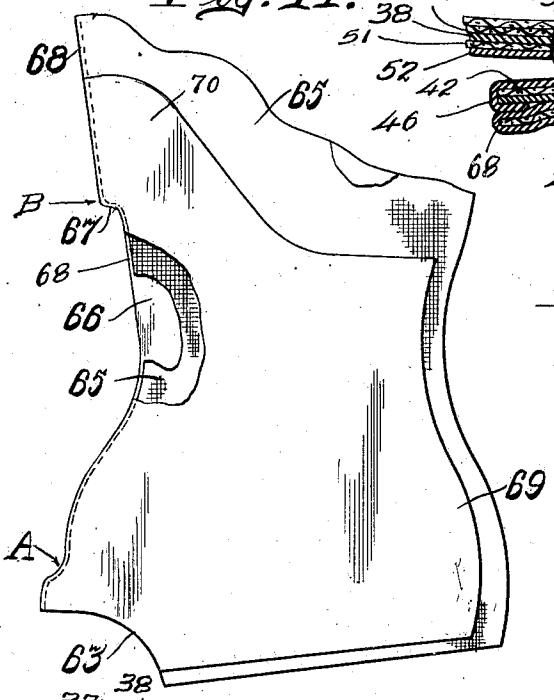


Fig. 13.

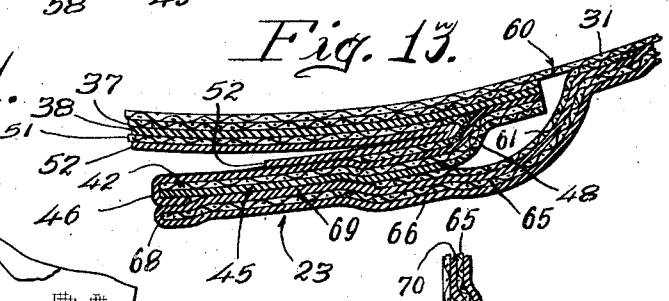


Fig. 14.

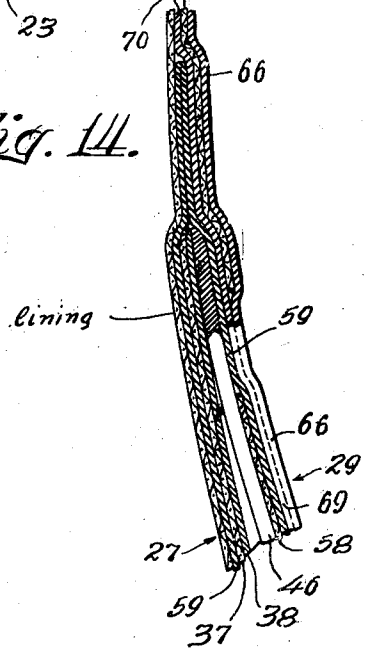
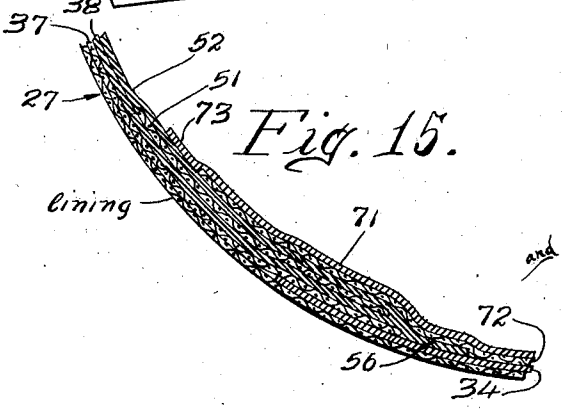


Fig. 15.



Inventors
George L. VanDinter
and Conrad Ferrettie
By: Eugene M. Giles
Attorney.

Patented July 22, 1930 1,771,277

UNITED STATES PATENT OFFICE

GEORGE L. VAN DINTER AND CONRAD FERRETTIE, OF MISHAWAKA, INDIANA, ASSIGNORS TO MISHAWAKA RUBBER AND WOOLEN MANUFACTURING COMPANY, OF MISHAWAKA, INDIANA, A CORPORATION OF INDIANA

FORM-FITTING BOOT AND METHOD OF MAKING SAME

Application filed June 17, 1929. Serial No. 371,353.

Our invention relates to high top footwear or boots, such as shown in our Patent 1,726,782, which are of form fitting construction with an expansible folded section at the ankle and instep permitting enlargement for inserting and removing the foot and our present invention has reference more particularly to the construction and location of the pocket member and the shaping, strengthening and waterproofing of the boot at the expansible section.

In manufacturing rubber boots of the form fitting type with an expansible folded construction at the instep and ankle it is important to minimize the thickness and shape the structure in a neat, compact, close-fitting form not only for the sake of appearance but also because of the constant flexing which occurs at this place when the boot is in use. Moreover, it is desirable to reinforce the expansible structure so that it will maintain its shape and withstand this flexing, and also the manipulation of folding and unfolding in applying and removing the boot, over a long period of time without breaking down and furthermore the expansible portion should be constructed or built up in such a manner that it is thoroughly and permanently sealed against leakage or penetration of moisture to the interior of the boot.

The principal objects of our invention are to provide an improved form fitting boot; to insure a neat, compact and close-fitting expansible structure at the ankle and instep which permits enlargement for applying and removing the boot; to provide a closing pocket at this place which is formed in a manner to readily assume the desired shape without distortion or stretching; to reinforce and strengthen the expansible structure so that it will withstand constant hard usage without breaking down; to thoroughly seal the expansible portion against leakage or entry of moisture therethrough to the interior of the boot; to provide the wall of the boot and the expansible folding portion thereof with a continuous unbroken layer of rubber composition between the interior and exterior of the boot; to insure extra strengthening of said layer of rubber composition where the strains in opening and closing the pocket are greatest; to provide an improved method of building a waterproof expansible structure into the front of a rubber boot; and in general to improve the appearance, serviceability and waterproofing of a form fitting rubber boot.

On the drawing:

Fig. 1 is a perspective view of a boot constructed in accordance with our invention;

Fig. 2 is a perspective view showing the lining assembled on the last ready for the applying of the pocket structure, the upper part of the last and lining being broken away;

Fig. 3 is a similar view with the pocket structure secured in place;

Fig. 4 is a plan view of one of the half portions which compose the back wall of the pocket;

Fig. 5 is a plan view of the reinforcing patch for the lower end of the pocket;

Fig. 6 is a plan view of the back wall of the pocket with the patch applied on the lower end thereof;

Fig. 7 is a plan view of one of the half portions comprising the front wall of the pocket;

Fig. 8 is a front view of the pocket ready for building into the boot;

Fig. 9 is a back view thereof;

Fig. 10 is a plan view of the toe covering of the boot, the side extensions thereof being broken away;

Fig. 11 is a plan view, looking at the inner side thereof, of one of the side coverings or quarters of the boot with the upper portion thereof broken away;

Fig. 12 is an enlarged transverse section through the pocket of the boot taken substantially on the line 12—12 of Fig. 1;

Fig. 13 is a similar view taken substantially on the line 13—13 of Fig. 1;

Fig. 14 is an enlarged longitudinal sectional view of the upper end of the pocket taken substantially on the line 14—14 of Fig. 1; and

Fig. 15 is a similar view of the lower end of the pocket taken substantially on the line 15—15 of Fig. 1.

Referring to the drawings, in Fig. 1 of

which our invention is shown in connection with a boot of knee length although not limited thereto, the reference numeral 20 indicates the boot as a whole which is divided along the line 21 over the ankle and instep to form a pair of separable flaps 22 and 23 which are detachably connected in the closed position by buckles 24 of a well known form. Any other suitable type of fastening devices may, however, be employed. The flaps 22 and 23 are flared at their lower ends as indicated at 25 and 26 respectively forming a "Blucher" type of opening and the vamp of the boot has an extension 27 under the flaps 22 and 23 and secured at its upper end to the front wall of the boot just above the upper end of the opening 21, and said extension has a flap 28 and 29 respectively on each lateral edge extending inwardly thereover to the dividing line 21 and secured to the inner edge of the respective overlying flap 22 or 23. This vamp extension 27 and its side flaps 28 and 29 form in effect an elongated somewhat elliptical pouch or pocket which is slit down the front and closes the opening between the flaps 22 and 23, but permits separation of the boot flaps and enlargement of the boot at the ankle and instep for freely inserting and removing the foot. In the closed position this pocket or pouch and the boot flaps 22 and 23 fold together in a flat, compact form corresponding to the shape of the ankle and instep and the expansible structure is held in this closed compact form by the buckles 24 which connect the boot flaps 22 and 23 at suitably spaced intervals.

In making up a rubber boot with this expansible ankle and instep construction, it is highly desirable to provide ample precaution against penetration of water or moisture to the interior of the boot,—to reinforce the places where greatest strains occur so that they will not break down or give way in constant use and at the same time to maintain a compact, neat appearing, form fitting effect, all of which we have found may be successfully accomplished by constructing the boot in the following manner:

The boot lining, preferably composed of a pair of similar half sections or quarters 30 and 31 jointed together along their forward edges by a tape 32, is stretched around the last 33, secured together at the back and lasted over and secured to the edge of an inner sole member in the usual manner. A vamp 34 of rubber composition is then fitted over the toe and adhesively secured to the lining with the edges also lasted over the edge of the inner sole member and the structure (shown in Fig. 2) is then ready for the expansion pocket to be applied thereto.

This pocket is preferably made up separately and thereafter applied to the aforesaid lining structure and comprises a back wall which consists of the vamp extension 27 of Fig. 6 and a divided front wall comprising the two pocket flaps 28 and 29. The back wall 27 is preferably made up of left and right half sections 35 and 36, which are overlapped and secured together along a center line, said half sections being lune shaped or curved somewhat in the manner of the half section 35 shown in Fig. 4 so that they assemble in a shape to conform to the surface of the last over which the pocket is to be located. Each half section 35 and 36 is of two-ply construction, comprising a layer 37 of fabric on the underside and an outer layer 38 of rubber composition, adhesively secured together, the inner edges of the rubber layers 38 being extended beyond the corresponding edges of the fabric layers 37 as indicated at 39, and particularly on the outside overlapping section 35, so that there is a rubber to rubber engagement of the edge 39 of the section 35 with the rubber facing 38 of the section 36 which in the vulcanization of the boot is consolidated into integral form and provides a joint which is thoroughly sealed and prevents admission of water or moisture along the juncture line of the sections 35 and 36 to the interior of the boot.

The pocket flaps 28 and 29 which have curved lower ends 40 and 41 respectively to correspond to the curved edges 25 and 26 of the boot flaps 23 and 24, are alike in construction, except that one is right hand and the other left hand, both being lune shaped or curved like the back wall sections 35 and 36 to conform to the shape of the last as shown in Fig. 7 which illustrates the left hand flap 28. Each flap 28 and 29 comprises a layer 42 of fabric which has a layer 43 of rubber composition adhesively secured to the under side and with a projecting edge 44 of rubber composition along the inner edge of the fabric 42 as indicated in Fig. 7. The outer edges of the fabric and rubber layers 42 and 43 preferably coincide as shown in Fig. 7. A strip 45 of rubber composition is laid over and adhesively secured to the fabric 42 as shown in Fig. 7 after which the extended edge 44 of the rubber layer 43 is turned thereover as indicated at 46 to finish the inner edge of the pocket flap, said rubber strip 45 being extended beyond the pocket flap as shown at 47 to afford a projecting tab for a purpose hereinafter explained. The portion of the outer surface of the fabric layer 42 which is not covered by the rubber strip 45 is covered with a piece 48 of fabric which is adhesively secured to the fabric 42 and extends up to the rubber strip 45 and the outer edge of this fabric piece 48 coincides with the outer edges of the fabric and rubber layers 42 and 43. The flaps 28 and 29 are arranged over the vamp extension 27 with their inner edges substantially abutting and their outer edges coinciding respectively with the outer edges of the vamp extension as shown in Figs. 6 and 8, and the outer edges

of the rubber layers 43 of the sections or pouch flaps 28 and 29 are adhesively secured to the corresponding outer edge of the underlying rubber layer 38 of the vamp extension along a width indicated at the outer side of the dotted lines 49 in Fig. 6 so that when the boot is vulcanized, the outer edges of the rubber layers 38 and 43 are consolidated and the pocket thus thoroughly sealed along the lateral edges. The flaps 28 and 29 are also adhesively secured at their upper ends to the vamp extension 27 in like manner but over a wider area as indicated above the dotted line 50 in Fig. 6 to insure adequate security and thorough sealing at this point, and at the lower ends of the flaps 28 and 29 the rubber tabs 47 are turned under the vamp extension or back wall 27 of the pocket and adhesively secured to the under side thereof as shown in Fig. 9.

For reinforcing the connection of the vamp extension with the vamp of the boot and the connection of the side flaps 28 and 29 with the vamp extension 27 at the lower end of the pocket, a patch is provided which comprises a layer 51 of fabric with a layer 52 of rubber adhesively secured thereover as shown in Fig. 5, the edges of the rubber layer being extended well beyond the fabric at all points therearound, and this patch has lateral portions thereof folded inwardly along the lines 53 (see Fig. 5) as shown in Fig. 6. This patch is adhesively secured to the lower end of the vamp extension 27 substantially as shown in Fig. 6 preferably before the side flaps 28 and 29 are secured in place, and is located so that lateral edge portions of rubber layer 38 of the vamp extension are exposed at each side thereof as shown at 54 in said figure so that the outer edges of the side flaps 28 and 29 may be secured directly to the lateral edges of the vamp extension, and when the side flaps 28 and 29 are applied, the lower ends thereof are adhesively secured to the inturned portions of the patch so that there is not only a rubber to rubber connection between the rubber layers 38 and 43 along each lateral edge of the patch but moreover the rubber layers 43 are adhesively secured to the inturned portion of the patch fabric 51 and to the exposed edge of the rubber layer 52 thereof (see Fig. 6), thus forming an additional rubber to rubber connection between the rubber layers 43 of the side flaps and the exposed inner edge portion of the rubber layer 52 of the patch and thereby affording additional reinforcement and security against leakage at the lower end of the pocket. To further strengthen and increase the stock of rubber composition at the lower ends of the side flaps 28 and 29 a piece of rubber composition is applied as shown in Figs. 8 and 9 over the edge of the pocket with a portion 55 thereof overlying and adhesively secured to the inturned end 47 of the rubber strip 45 and the exposed edge 56 of the rubber layer 52 of the patch 51—52 as shown in Fig. 9 while the portion 57 of said reinforcing piece of rubber which is at the front of the pocket overlies and is adhesively secured to the fabric 51 and edge portion of the rubber 52 of the patch 51—52 and the lower extremity of the respective flap 28 or 29 with a rubber to rubber contact along the edge of the rubber portion 57.

After the pocket has been prepared as above indicated, the interior is powdered with talcum or chalk to avoid adhesion and consolidation of the inner surfaces, and then the adjoining edges of the flaps 28 and 29 are connected by a fabric tape 58 which terminates some distance below the upper end of the pocket as indicated in Figs. 8 and 14, said tape being preferably apertured along the center line overlying the juncture of the side flaps 28 and 29 so that it may be readily divided along this line after the boot has been vulcanized. A rubber tape 59 which is somewhat wider than the fabric tape 58 is then secured over the fabric tape and extended up beyond the end of the pocket member as shown in Figs. 8, 9 and 14 and looped back and adhesively secured to the under side of the pocket as shown in Fig. 9, said tape being carefully rolled down particularly at the upper end of the pocket so that said rubber tape, beyond the end of the fabric tape 58, thoroughly adheres to the upper extremities of the rubber strips 45 and the turned edge portions 46 of the side flaps 28 and 29 and fills the crease therebetween and moreover the rubber tape at the upper extremity of the pocket is fitted firmly against the pointed upper end of the pocket, also for the purpose of reinforcing and insuring a thorough rubber to rubber sealing of the pocket at the upper end.

After the pocket has been prepared in this manner, it is applied in position over and adhesively secured to the lining on the last with the lower end of the pocket, including the lower extremities of the side flaps 28 and 29, extending over and adhering to the vamp covering 34 of rubber composition. The pocket extends over the layer 34 of rubber composition sufficiently so that the rubber reinforcing portions 47 and 55 on the under side of the pocket overlie and are secured to the rubber vamp covering 34 so as to insure a rubber to rubber connection at this point and moreover the extended edge portion 56 of the rubber layer of the patch 51—52 also extends over the rubber layer 34 thereby insuring a rubber to rubber contact, and after vulcanizing the consolidated rubber connection between the lower end of the pocket and the rubber layer 34 extends well up above the lower extremities of the side flaps 28 and 29

and insures adequate reinforcing and a thorough sealing against leakage.

After the pocket structure of Figs. 8 and 9 has been secured to the lining structure of Fig. 2, a stitch wheel is run close to the edge of the pocket at each side to partially cut through the lining along the lines 60 said lines terminating substantially at the lower ends of the side flaps and also a short distance below the upper end of the pocket, so as to divide the intermediate instep and lower leg portion of the lining along its sides from the rest of the lining and leaving the upper and lower ends of said portion undivided from the rest of the lining. Of course, the partially severed lines 60 may be provided before the pocket is applied, but we have found it preferable to place the pocket in position and then run the cutter along the edges of the pocket, using the latter as a guide to determine the position of the partial cutting.

After the pocket is secured in place and the lining partially cut along the lines 60 a lune shaped piece 61 of fabric corresponding in curvature to the pieces from which the pocket is made so as to conform to the shape of the last, is laid over each pocket flap and cemented along the inner edge to the respective flap 28 or 29, said connection being made to the rubber strip 45 thereof just beyond the edge of the fabric piece 48. The outer edge of each fabric piece 61 extends beyond the outer edge of the pocket and beyond the cut line 60 and is cemented to the lining section 30 or 31 at the outer side of the line 60.

The folded in portions of the reinforcing patch 51—52 which project beyond the lower ends of the side flaps 28 and 29 together with the overlying portion 57 of the rubber reinforcing member 55—57 is then folded back as shown at 62 in Fig. 3 over the lower corner of the side flap 28 or 29 where the latter is secured to the vamp covering 34 so as to reinforce the connection at this point against the strain of opening and closing, and it is to be noted that when turned back in this manner, there is a rubber to rubber connection between the folded back portion and the lower corner of the respective side flap 28 or 29 and the rubber layer 34 which in the subsequent vulcanization is consolidated into a unitary mass, affording a thorough and effective sealing at this place. Moreover, the turned back portion 62 comprises a small piece of fabric between two layers of rubber and affords a substantial strengthening of the connection of the lower corner of the flap 28 or 29 with the boot.

After this is completed, the outside covering of the boot is applied, consisting preferably of two quarters such as shown in Fig. 11 which are cut away at 63 to extend down along the side of the boot as shown by dotted lines at 63 in Fig. 1 and overlap the rear edge of the vamp covering 34, which said rear edge is shown by the dotted lines at 64 in Fig. 1. These quarters are preferably formed as shown in Fig. 11 with a layer 65 of fabric having a layer 66 of rubber on the outer side offset as at 67 to lap above the slit 21 and with the rubber layer 66 projecting beyond the forward edge of the fabric 65 as shown at 68. There is also an inner layer 69 of rubber composition which likewise extends beyond the forward edge of the fabric so as to form a rubber to rubber connection between the layers 66 and 69 and seal the edge of the fabric 65. Said layer 69 of rubber, however, does not extend entirely to the lower or rear edges of the fabric and it may also terminate well below the upper end of the quarter it being important, however, that it extend well up above the opening 21 between the side flaps 22 and 23 of the boot, the extension 70 being provided for this purpose herein. These quarters are applied at the opposite sides respectively of the boot with the edge 63 located substantially as indicated by the dotted line in Fig. 1 and the portions substantially between the points A and B of Fig. 11 fitted together along the edges of the respective flaps 28 and 29 with the rubber edges of the layers 66 and 69 overlying the exposed rubber portion of the outturned corner piece 62, the turned edge 46 at the lower end of the flaps 28 and 29 and the tape 59, said quarters being lapped above the point B and rolled down into close engagement in the usual manner. These quarters are then rolled down on the last and secured together at the back and lasted over the sole in the usual manner. Then a toe covering 71 of rubber is applied which has a layer 72 of fabric of lesser area thereunder so that the edges of the rubber extend over and beyond the edges of the fabric, said toe covering having a pointed portion 73 which fits up between the curved edges 25 and 26 of the side flaps 22 and 23 and is adhesively secured to the upper surface of the patch 51—52. This toe covering has side extensions 74 which cover the lapped joint 63—64 and are widened out and lapped at the back of the boot.

From the foregoing it will be observed that the pocket has a continuous unbroken rubber lining, the edges of which have a consolidated rubber to rubber connection with the rubber facing of the boot so that there is no break in the rubber covering nor exposed fabric through which water may leak or moisture enter by capillary action.

After the boot has been assembled in this manner it is vulcanized in the usual manner and after vulcanizing the facing and the tapes 58 and 59 are slit along the line 21 up to the upper end of the pocket so that the side flaps 21 and 22 may be separated. The lining is also slit along the lines 60 at each side of the pocket so that the sides of the

pocket are loose and the front of the boot may now be expanded to afford free access and removal of the foot. The fasteners 24 may be attached in any convenient manner preferably by means of tabs which are arranged in place before the boot is vulcanized or any other desired type fastener may be employed provided that it does not afford any possibility of leakage to the interior of the boot, the principal requirement being that the expansible portion at the ankle and instep be so constructed that it is thoroughly waterproof and possibility of leakage is avoided.

While we have shown and described our invention in a preferred form, we are aware that various changes and modifications may be made without departing from the principles of our invention, the scope of which is to be determined by the appended claims.

We claim as our invention:

1. In a form fitting boot the combination of an upper with an expansible section for locally enlarging a portion of the upper, said expansible section including a pair of separable instep flaps having their upper ends joined together at a distance below the top of the boot and a pocket member under and closing the opening between said flaps, the wall of the upper having a continuous uninterrupted layer of rubber composition surrounding said expansible section and said expansible section having a layer of rubber composition similar to and of substantially the same thickness as and having a continuous uninterrupted rubber to rubber connection therearound with the first mentioned layer of rubber composition.

2. In a boot of the class described the combination of an upper with an expansible section for locally enlarging a portion of the upper, said expansible section including a pair of separable instep flaps having their upper ends joined together at a distance below the top of the boot and a pocket member under and closing the opening between said flaps, the wall of the upper consisting of layers of fabric and rubber composition the latter of which layers surrounds the said expansible section and said expansible section comprising superposed layers of fabric and rubber composition the latter of which has a continuous uninterrupted rubber to rubber connection therearound with the layer of rubber composition of the upper wall.

3. In a boot of the class described the combination of an upper with an expansible section for locally enlarging a portion of the upper, said expansible section including a pair of separable instep flaps having their upper ends joined together at a distance below the top of the boot and a pocket member under and closing the opening between said flaps, the wall of the upper comprising a layer of fabric between two layers of rubber composition, both of which latter layers surround the expansible section, said expansible section comprising an inner layer of fabric and an outer layer of rubber composition the latter of which has a continuous uninterrupted rubber to rubber connection thereabout with the aforesaid two layers of rubber composition of the upper wall.

4. In a boot of the class described the combination of an upper having a pair of separable flaps along the ankle and instep portion of the boot, the lower ends of said flaps being flared and the upper ends joined together at a distance below the top of the boot, a pocket member under the flaps having a back wall forming a continuation of the vamp of the boot and a divided front wall comprising two portions conforming to and underlying and having their inner edges secured to the inner edges of the respective separable flaps aforesaid, and a continuous unbroken layer of rubber composition in the pocket and continued outwardly therefrom entirely around the pocket to form a part of the surrounding wall of the upper.

5. In a boot of the class described the combination of an upper having an expansible section for locally enlarging the upper along the ankle and instep and comprising a pair of separable flaps joined together at a distance below the top of the boot, a pocket member under the flaps for closing the opening therebetween and comprising an elongated fabric reinforced back wall with a layer of rubber composition covering the front thereof, a divided front wall for the pocket having separable lateral portions with a layer of rubber on the under side, said layers of rubber composition of said lateral portions of the pocket front wall being consolidated along their outer lateral edges with the respective outer lateral edges of the layer of rubber composition of the pocket back wall, and a layer of rubber composition forming a part of the upper and surrounding the opening between the aforesaid separable flaps and having a continuous unbroken rubber to rubber connection around said opening with the back and front wall layers of rubber composition of the pocket.

6. In a boot of the class described the combination of an upper with an expansible section over the instep and having the upper end terminating at a distance below the top of the boot, said expansible section having one end thereof interposed between and consolidated into a unitary mass with two layers of rubber composition.

7. In a boot of the class described the combination of an upper with a pair of separable instep flaps having their upper ends joined together at a distance below the top of the boot, and an elongated pocket member with a divided front wall affording inwardly extending portions having the inner edges

thereof secured to the corresponding edges of the instep flaps, portions of the upper and lower ends of the pocket member being interposed between and consolidated into a unitary mass with two layers of rubber composition.

8. In a boot of the class described the combination of an upper with a pair of separable instep flaps flared at their lower ends and having their upper ends joined together at a distance below the top of the boot, an elongated pocket member closing the opening between said flaps and having a front wall comprising a pair of inwardly extending portions the inner edges of which are secured to the corresponding edges of the aforesaid instep flaps with an integral rubber composition sealing connection therebetween, an integral mass of rubber composition sealing the upper end of the pocket, and a plurality of layers of rubber composition having the lower end of the pocket member interposed therebetween and consolidated therewith.

9. In a boot of the class described the combination of an upper with a pair of separable instep flaps flared at their lower ends and having their upper ends joined together at a distance below the top of the boot, an elongated pocket member closing the opening between said flaps and having a front wall comprising a pair of inwardly extending portions the inner edges of which are secured to the corresponding edges of the aforesaid instep flaps with an integral rubber composition sealing connection therebetween, a reinforcing of fabric and rubber composition embracing the lower extremities of the aforesaid portions of the pocket front wall at the juncture thereof with the back wall of the pocket, and two layers of rubber composition forming a part of the boot upper at the lower end of the pocket and having the aforesaid reinforcing interposed therebetween and consolidated therewith.

10. In a boot of the class described the combination of an upper comprising a lining, a toe covering of rubber composition on the lining, a pocket member having a back wall and a front wall with inwardly extending separable side portions overlying the back wall and flared at their lower ends, said pocket member having the lower end overlapping the aforesaid toe covering, and a facing of rubber composition overlying the pocket and having separable portions secured along their edges to the inner edges of the separable side portions of the front wall of the pocket member.

11. The method of making a waterproof form-fitting rubber boot which comprises providing a pocket member with a divided front wall composed of separable side portions and a lining of rubber composition, building the pocket member in the front wall of the boot at the instep, applying a facing of rubber composition on the front wall of the boot, and consolidating a continuous portion of said facing around the pocket with the pocket lining.

12. In a rubber boot of the class described, the combination of an upper having an opening at the front closed at the upper end and said closed upper end of the opening being located at a distance below the top of the boot, an elongated pocket member under and closing said opening and having rubber composition front and back walls with their interior faces joined together along the outer edges of the pocket member to form a flat joint, said front wall of the pocket member comprising laterally separable portions which underlie and are joined along their inner edges to the upper at the respective sides of its opening, and cooperating fastening means on the front wall at opposite sides of the opening.

13. In a rubber boot of the class described, the combination of an upper having an opening at the front closed at the upper end and forming a pair of separable flaps the upper ends of which are joined together at a distance below the top of the boot, an elongated pocket member under and closing said opening and having rubber composition front and back walls both diminishing in width toward their upper and lower ends and with their interior faces joined together along the lateral edges and at their upper ends to form a flat joint, said front wall of the pocket member comprising laterally separable portions which underlie and are joined along their inner edges to the respective flaps of the upper, and fastening means for connecting said separable flaps.

14. In a rubber boot of the class described, the combination of an upper having a pair of separable instep flaps the upper ends of which are joined together at a distance below the top of the boot, and an elongated expansible pocket member under and closing the opening between said flaps and having rubber composition front and back walls, the front wall of which comprises laterally separable portions, a mass of rubber composition on the outer side of and along the inner edge of each of said separable portions and consolidated with the overlying instep flaps, and two overlying layers of fabric extending laterally from each rubber mass, one of said layers being secured to the outer side of the front wall of the pocket and the other layer being secured to the inner side of the upper.

15. In a rubber boot of the class described, the combination of an upper having a pair of separable instep flaps the upper ends of which are joined together at a distance below the top of the boot, and an elongated expansible pocket member under and closing the opening between said flaps and having rubber composition front and back walls, the

front wall of which comprises laterally separable portions each having a layer of fabric on the front face and rubber composition extending along and interposed between the inner edge of each layer of fabric and the opening between said separable portions for sealing the edge of the fabric.

16. In a rubber boot of the class described, the combination of an upper having a pair of separable instep flaps the upper ends of which are joined together at a distance below the top of the boot, and an elongated expansible pocket member under and closing the opening between said flaps and having rubber composition front and back walls, the front wall of which comprises laterally separable portions which are secured along their inner edges to the respective instep flaps, two superposed layers of fabric between each of said laterally separable portions and the boot upper and secured respectively thereto, and rubber composition extending along and interposed between the inner marginal portions of said superposed layers and the opening between the said separable portions.

17. In a rubber boot of the class described, the combination of an upper having a pair of separable instep flaps the upper ends of which are joined together at a distance below the top of the boot, and an elongated laterally expansible pocket member under and closing the opening between said flaps and having rubber composition front and back walls, the front wall of which comprises laterally separable portions at opposite sides respectively of the aforesaid opening, said upper comprising a layer of fabric having an outer facing of rubber composition and a layer of rubber composition on the inner side and the latter layer having a continuous rubber-to-rubber connection with the aforesaid pocket front wall along each side and across the top of the opening between the instep flaps.

18. In a rubber boot of the class described, the combination of an upper having a pair of separable instep flaps the upper ends of which are joined together at a distance below the top of the boot, and an elongated laterally expansible pocket member under and closing the opening between said flaps and having rubber composition front and back walls, the front wall of which comprises laterally separable portions at opposite sides respectively of the aforesaid opening, said upper comprising a layer of fabric with a layer of rubber composition on the outer side and extending to the top of the boot, a layer of rubber on the inner side of said fabric and terminating a substantial distance below the top of the boot, said latter layer of rubber composition having a continuous rubber-to-rubber connection with the aforesaid pocket front wall along each side of and across the top of the opening between the instep flaps, and a fabric lining on the inner side of the latter layer of rubber composition.

19. In a rubber boot of the class described, the combination of an upper having a pair of separable instep flaps the upper ends of which are joined together at a distance below the top of the boot, and an elongated laterally expansible pocket member under and closing the opening between said flaps and having rubber composition front and back walls, the front wall of which comprises laterally separable portions at opposite sides respectively of the aforesaid opening, said upper comprising a layer of fabric having an outer facing of rubber composition and a layer of rubber composition on the inner side and the latter layer having a continuous rubber-to-rubber connection with the aforesaid pocket front wall and said facing of rubber composition along each side and across the top of the opening between the instep flaps.

20. In a rubber boot of the class described, the combination of a boot wall comprising quarters which are joined together part way down the front and separable therebelow to provide an expansive opening along the instep, an elongated laterally expansible pocket member within the boot and closing said expansive opening and having rubber composition front and back walls, the front wall of which comprises laterally separable portions at opposite sides respectively of the aforesaid opening, said quarters having a layer of rubber composition having a continuous rubber-to-rubber connection with the aforesaid pocket front wall along each side and across the top of said expansion opening, and a toe covering comprising a layer of rubber composition having a rubber-to-rubber connection with the quarter at each side of the pocket member, and a rubber-to-rubber connection with the lower end of the pocket member.

21. In the making of a rubber boot of the class described, the forming of a pocket member by placing layers of rubber composition in superposed relation, adhesively connecting the inner faces thereof along laterally spaced oppositely converging lines, and subsequently consolidating said adhesively connected portions by vulcanization.

22. In the making of a rubber boot of the class described, the forming of a pocket member of elongated substantially elliptical front and back walls of rubber composition, then arranging said walls in superposed relation, then adhesively joining the inner faces of said walls along their lateral edges and at the top, and subsequently consolidating said adhesively connected portions by vulcanization.

23. The method of making a rubber boot of the class described which includes assembling on a last a boot lining with an instep pocket member which is closed at the upper end, then applying quarters of fabric re-

inforced rubber composition over the lining with corresponding edge portions extending over and secured to the pocket member thereof in substantially abutting relation and other edge portions thereof joined together at and above the upper end of the pocket member, then vulcanizing the assembled structure and slitting the front of the pocket between the substantially abutting edges of the quarters.

24. The method of making a rubber boot of the class described which includes assembling on a last a boot lining with an instep pocket member which is closed at the upper end, then applying quarters of fabric reinforced rubber composition having a layer of rubber composition on the inner side, over the lining with corresponding edge portions of the quarters extending over the pocket in substantially abutting relation and the said layer of rubber composition adhesively secured to the front of the pocket and other edge portions of the quarters joined together at and above the upper end of the pocket member, then vulcanizing the assembled structure and slitting the front of the pocket between the substantially abutting edges of the quarters.

25. The method of making a rubber boot of the class described which includes assembling on a last a boot lining with an instep pocket member which is closed at the upper end, then applying quarters of fabric reinforced rubber composition over the lining with corresponding edge portions thereof extending over and secured to the pocket member in substantially abutting relation and other edge portions thereof joined together at and above the upper end of the pocket member, then adhesively applying a toe cover of rubber composition over the toe portion of the lining to overlap the sides of the quarters and the lower end of the pocket member, then vulcanizing the assembled structure and slitting the front of the pocket between the substantially abutting edges of the quarters.

26. The method of making a form fitting rubber boot which includes forming the boot lining with an elongated instep and lower leg portion thereof divided along the sides from the rest of the lining and integral therewith at the upper and lower ends, adhesively applying an elongated pocket member on said portion of the boot lining, assemblying boot wall quarters on the lining with forward edge portions thereof brought close together on the pocket member substantially midway between the lateral edges of said instep and lower leg portion, and other forward edge portions of said quarters joined together above the upper end of the pocket member, vulcanizing the assembled structure, and after vulcanizing slitting the structure at the front of the pocket and between the ends thereof.

27. The method of making a form fitting rubber boot which includes forming a boot lining with an elongated instep and lower leg portion thereof divided along the sides from the rest of the lining and integral therewith at the upper and lower ends, adhesively securing on the outer side of said portion an elongated pocket member with front and back walls of rubber composition secured together along their lateral edges and at their upper ends and with fabric overlying and secured to the front wall inwardly from the lateral edges of the pocket member and also secured to the boot lining beyond the lateral edges of the aforesaid instep and lower leg portion of the boot lining, then applying on the lining and adhesively securing thereto quarters of boot wall material with portions along the forward edges of said quarters extended over and adhesively secured to the front wall of the pocket member and with other portions along the forward edges of said quarters joined together at and above the upper end of the pocket member, then vulcanizing the assembled structure, and then dividing the structure at the front of the pocket member between the upper and lower ends of the pocket member and substantially midway between the lateral edges thereof.

28. In a rubber boot of the class described, the combination of an upper having an opening at the front, closed at the upper end and said closed upper end of the opening being at a distance below the top of the boot, an elongated pocket member under and closing said opening and having rubber composition back and front walls joined together along their lateral edges and at their upper ends, said pocket being secured to the upper around said opening and being of maximum width substantially at the upper end of the instep portion of the boot and tapered in width upwardly therefrom to the upper closed end of the opening, and said pocket member and opening being extended downwardly along the instep portion of the boot substantially to the lower end of said instep portion.

GEORGE L. VAN DINTER.
CONRAD FERRETTIE.