

UNITED STATES PATENT OFFICE.

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METHOD OF BUILDING HEELS.

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Specification of Letters Patent.

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No Drawing.

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To all whom it may concern:

Be it known that I, ERASTUS E. WINKLEY, a citizen of the United States, residing at Lynn, in the county of Essex and State of Massachusetts, have invented certain new and useful Improvements in Methods of Building Heels; and I do hereby declare the following to be a full, clear, and exact description of the invention, such as will enable others skilled in the art to which it appertains to make and use the same.

This invention relates to a method of building heels and more particularly to building heels formed of a plurality of superposed dinked out lifts.

Heretofore in making heels from dinked out lifts, it has been customary to form a heel pile by superposing a desired number of lifts one upon the other within a die or former and pasting each successive lift either before or after it is placed within the die. If forming jaws are used they are closed upon the lateral surface of the pile to aline the lifts and place all their breasts in substantially the same vertical plane. After the lifts have been alined, a nail is driven therethrough to permanently secure them together. This method of building heels is slow and tedious as it is necessary to use some care in placing the lifts properly within the die or forming device and more time than is necessary is consumed in pasting lifts one by one as they are used.

The object of the present invention is to provide a method of building heels which will require a minimum of care on the part of the operative in assembling the lifts and which will at the same time be speedy. In accordance with this object, the present invention contemplates a method of building heels from dinked out lifts in which both the assembling of the lifts to form the heel pile and their pasting is performed outside of the die or other device which may thereafter be used for alining the lifts prior to inserting the nail to permanently secure them together.

In the preferred method of practicing the invention, the dinked out lifts are placed according to size in bins, arranged upon a table in front of the operative as is now the practice. The operative first takes a lift of the largest size to be used from its bin and dips or immerses it, generally with the left hand, in the trough of paste which

is conveniently arranged at the front of the table as usual. While she is dipping this lift to paste it, she reaches into the appropriate bin with her right hand and takes therefrom the next largest size lift. This lift she places upon the lift, in her left hand, which she has just dipped in the paste. These two superposed lifts while held together are then dipped in the trough of paste to paste the second lift and while this is being done she takes, with her right hand, lift next in size from its appropriate bin and places it upon the two lifts now held in her left hand. The third lift is then pasted by immersing all three of them in the trough of paste. This process continues until enough lifts have been superposed upon each other to obtain a heel of the desired height. It should be understood, of course, that as the lifts are superposed upon each other they are placed breast upon breast although no particular care need be exercised in their superposition except to see that the general direction of the breasts of the heels is the same.

It will be obvious to those skilled in the art that an extremely speedy method of obtaining a heel pile of the desired height is thus provided as it is unnecessary for the operative to exercise any judgment or even to inspect the lifts as they are placed one upon the other, their relative position being determined by a sense of touch alone. Furthermore time is saved for the reason that the period occupied in pasting the lift with one hand is utilized to obtain from the proper bin the next lift to be placed upon the pile.

It is obvious that the heel pile formed in the manner above described will not have the breasts of the lifts in absolute alinement. In order to put the heel pile in proper condition to receive the nail or other permanent securing device and thereafter be compressed, the lifts are alined with their breasts all in substantially the same vertical plane, and otherwise centered relatively to each other, preferably, by placing the pasted heel pile within any of the usual and well known forms of collapsible dies, or formers, that have heretofore been used and closing the jaws thereof upon the lateral surfaces of the lifts forming the pile. After the lifts have been alined and centered as above described or in some other convenient way, which is best done immediately

while the paste is still wet, the lifts are permanently secured together by driving a nail therethrough and the heel pile is then ready to be taken to the heel compressing machine as usual.

While, as above described, it is preferred to aline the lifts of the heel pile by some mechanical means, it is obvious that this is not essential as the lifts may very quickly be alined and centered by hand after the pile is once formed in the manner described.

It will be obvious to those skilled in the art that the invention is not limited to the manufacture of heels from whole lifts but can readily be practiced in making what are known to the trade as pieced heels, that is, heels in which one or more of the lifts are formed of two or more pieces. Therefore, in the claims where the term "lift" is used, it should be interpreted as inclusive of either a whole lift or a pieced lift.

The method of building heels outlined above affords an organized method of manufacture which is very simple and enables heels to be produced with greater economy and speed than heretofore, while yet retaining in the product the more desirable qualities of heels made by the methods of the prior art.

Having thus described the invention, what is claimed as new, is:—

1. A method of building heels from dinked out lifts, which consists in dipping a lift in paste, then forming a heel pile by superposing additional lifts on said pasted lift, breast above breast, and successively dipping the partially completed pile in paste after the addition of each new lift until the desired height has been obtained, and then alining the lifts of the heel pile with their breasts all in substantially the same vertical plane by the application of pressure to the lateral surface of the pile.

2. A method of building heels from dinked out lifts, which consists in dipping a lift in paste, then forming a heel pile by superposing additional lifts on said pasted lift, breast above breast, and successively dipping the partially completed pile in paste after the addition of each new lift until the desired height has been obtained, then alining the lifts of the heel pile with their breasts all in substantially the same vertical plane by the application of pressure to the lateral surface of the pile, and then permanently securing the lifts together by driving a nail therethrough.

3. A method of building heels from dinked out lifts, which consists in forming a heel pile by taking a lift in the hand, dipping it in paste while taking another lift, superposing the second lift on the first, breast above breast, dipping the two lifts in paste while taking a third, and so on until the desired height of heel has been obtained, and then alining the lifts of the pile with their breasts all in substantially the same vertical plane by the application of pressure to the lateral surface of the pile.

4. A method of building heels from dinked out lifts, which consists in forming a heel pile by taking a lift in the hand, dipping it in paste while taking another lift, superposing the second lift on the first, breast above breast, dipping the two lifts in paste while taking a third, and so on until the desired height of heel has been obtained, and then alining the lifts of the pile with their breasts all in substantially the same vertical plane by the application of pressure to the lateral surface of the pile while the paste is still wet.

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Witnesses:

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