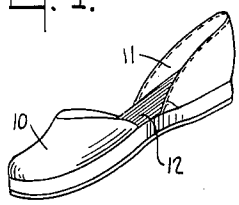
Dec. 25, 1951 J. MELTZER 2,580,037

PROCEDURE FOR MAKING SLIP-LASTED SHOES WITH FULL LENGTH SOCK LINING AND PREFORMED COUNTER

Filed June 10, 1950 2 SHEETS—SHEET 1

Fig. 1.



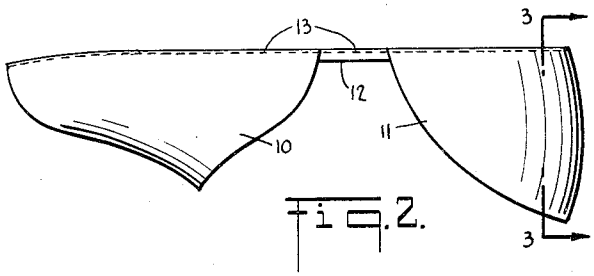


Fig. 2.

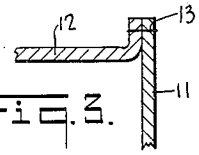


Fig. 3.

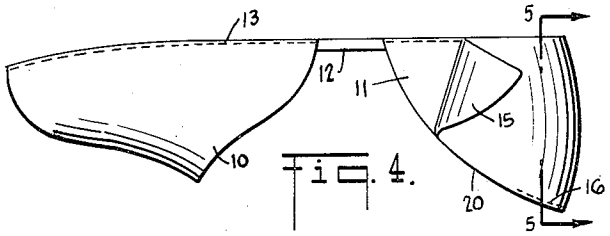


Fig. 4.

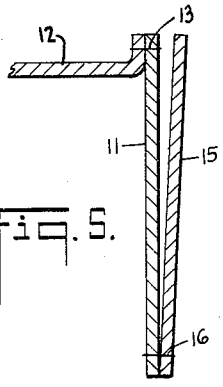


Fig. 5.

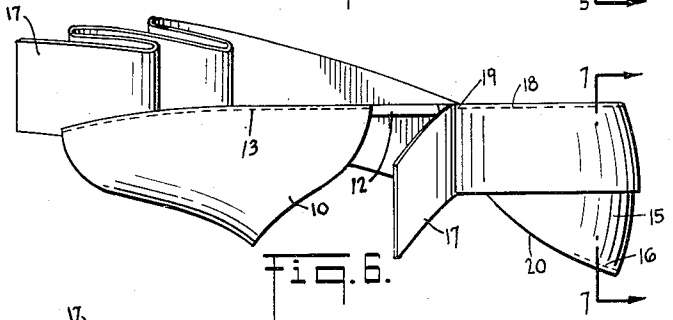


Fig. 6.

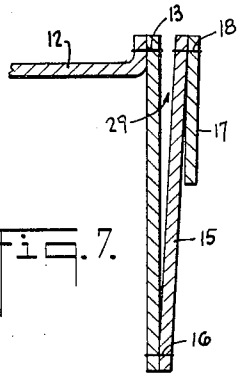


Fig. 7.

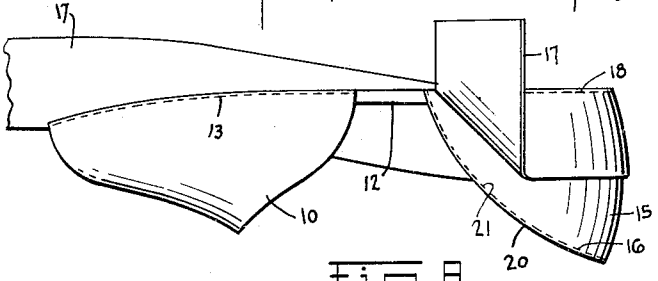


Fig. 8.

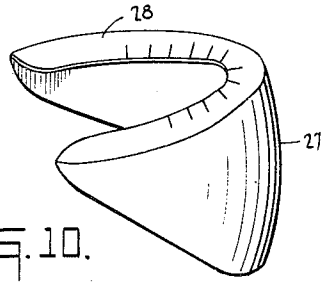


Fig. 10.

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PROCEDURE FOR MAKING SLIP-LASTED SHOES WITH FULL LENGTH SOCK LINING AND PREFORMED COUNTER

Filed June 10 , 1950 2 SHEETS—SHEET 2

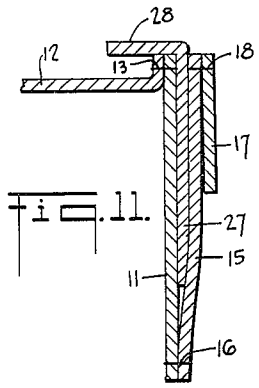


Fig. 11.

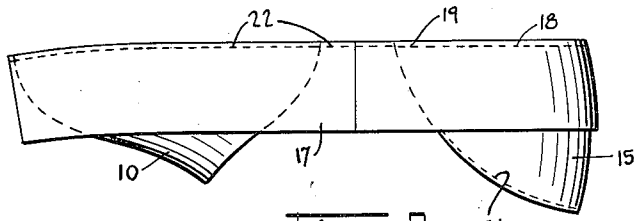


Fig. 9.

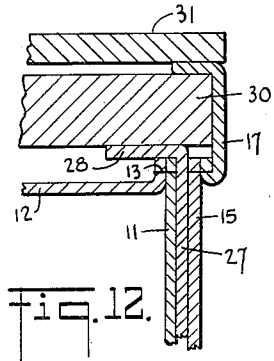


Fig. 12.

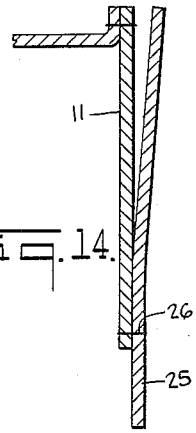


Fig. 14.

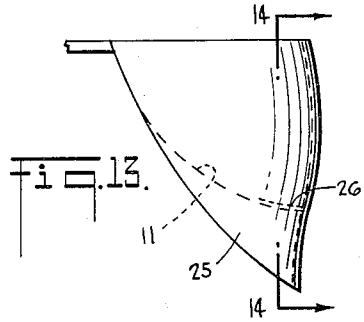


Fig. 13.

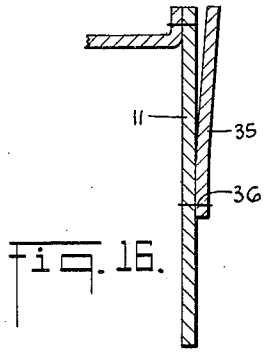


Fig. 16.

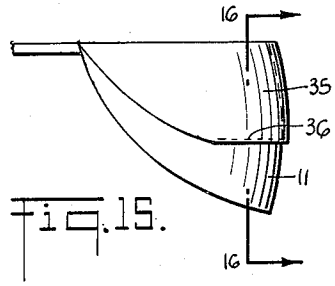


Fig. 15.

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Patented Dec. 25, 1951 2,580,037

UNITED STATES PATENT OFFICE

2,580,037

PROCEDURE FOR MAKING SLIP-LASTED SHOES WITH FULL-LENGTH SOCK LINING AND PREFORMED COUNTER

Jack Meltzer, Los Angeles, Calif.

Application June 10, 1950, Serial No. 167,348

4 Claims. (Cl. 12—142)

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My present invention relates generally to footwear, and has particular reference to a procedure for making slip-lasted shoes with a counter cover element, the procedure being an improvement over the method disclosed in Patent No. 2,493,497 granted to me on January 3, 1950.

A general object of the invention is to provide a method of forming a slip-lasted article of footwear in which there is a full length sock lining stitched to the upper throughout the full extent of the upper's lower edge, and in which the advantages of such a stitched-in sock lining are coupled with the advantages of a pre-formed flanged counter in the heel region or other region of the shoe.

In the procedure outlined in my said earlier patent, a preliminary step consists in stitching a platform cover to the lower edge of a counter-covering element, to form a subordinate assembly which is subsequently stitched to the upper. In practice, the subordinate assembly is not always used immediately, and if there is an appreciable lapse of time between the formation of the subordinate assembly and its securement to the upper, a disadvantage arises from the possibility that the counter-covering element may stretch or shrink in the interim period. Leather has a tendency to stretch, some fabrics have a tendency to shrink. In either case, an alteration in length of the counter-covering element makes it difficult properly to position it relative to the upper. If its top edge is correctly positioned relative to the upper, the platform cover will be too high or too low; and if the platform cover is first brought to proper position, the desired location of the upper edge of the counter-covering element will not be achieved. This disadvantage results in slowing of the manufacturing process, and often requires the discard of subordinate assemblies, often of completed shoes.

It is an object of the present invention to provide an improved method of assembling shoes of the character referred to, which obviates the foregoing disadvantages.

A more particular object of the invention is to provide a simplified method of making a slip-lasted shoe of the character described which will be of neat appearance and fit regardless of any stretching or shrinkage which may have taken place in the counter-cover element prior to the final sewing operations.

Another object of the invention is to provide a method which requires less skill and care on the part of the operator to produce shoes of requisite neatness and quality, and which thus minimizes losses due to defective shoes.

A further object of the invention is to provide a method of making slip-lasted shoes which lends itself readily to variations in the sequence of operations so that factory help trained in particular

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operations may be kept working in their own operations out of normal sequence to avoid bottlenecking that might arise from a method requiring a fixed sequence of operations.

A method of achieving these general objects and advantages, and such other objects and advantages as may hereinafter appear or be pointed out, is illustratively exemplified in the accompanying drawings, in which:

Figure 1 is a perspective view of an illustrative article of footwear which may be produced by means of the present invention;

Figure 2 is an elevational view of an assembly of parts involved in the making of the shoe of Figure 1;

Figure 3 is a partial cross-section taken substantially along line 3—3 of Figure 2;

Figure 4 is a view similar to Figure 2 and showing another stage in the process of making the shoe;

Figure 5 is a cross-sectional view taken substantially along line 5—5 of Figure 4;

Figures 6, 8 and 9 are views similar to Figure 2 and illustrate other stages in the process;

Figure 7 is a cross-section taken substantially on line 7—7 of Figure 6;

Figure 10 is a perspective view of a typical preformed flanged counter;

Figure 11 is a cross-section similar to that of Figure 7 showing the parts in their positions after insertion of the counter;

Figure 12 is a cross-section similar to Figure 11 showing the parts in the relationship they assume after addition of the outer sole structure;

Figures 13 and 15 are partial elevations similar to Figure 4 showing the equivalent stage in the fabrication of shoes employing counter-covering elements which are respectively higher and lower than the upper to which they are sewn; and

Figures 14 and 16 are cross-sections taken substantially along lines 14—14 of Figure 13 and 16—16 of Figure 15 respectively.

In the shoe shown by way of illustration in Figure 1, the upper comprises a vamp 10 and a spaced quarter 11. It will be understood however that so far as the present invention is concerned the upper may be continuous, if desired, and may be formed of a single element or of separate parts stitched together. The upper may be preliminarily formed in any desired fashion by procedures which are well known per se, and of any desired material.

An early stage in carrying out the present procedure, although not necessarily the first stage, lies in stitching a sock lining 12 along its margin, as by stitches 13, to the lower edges of the upper parts 10 and 11. Preferably the stitches 13 are formed in one operation and in a continuous line about the entire periphery of the sock lining regardless of spaces which may exist

such as those between parts 10 and 11 of the upper. Regardless of the nature of the upper, whether continuous or discontinuous, the sock lining is stitched to the upper throughout the full extent of the upper's lower edge.

As indicated in Figures 4 and 5, a counter-covering element 15, which is here shown as being substantially the same in size as the quarter, is attached to the quarter 11 along its top edge only, as by a line of stitches 16. The counter-covering element may be of leather or other suitable or ornamental material and may have any appropriate shape or size. For example, in Figure 13 there is illustrated an element 25 which is larger than and extends above the upper or quarter 11, while in Figure 15 there is shown an element 35 smaller than and whose top edge is below the top edge of the quarter. In these cases the first attaching stitches are placed along the top edges of the quarter (upper) or counter-cover element whichever is lowermost, as indicated by the stitching 26 and 36 in these figures.

The importance of first attaching the counter-covering element in this manner will now be explained. If this element is formed of leather, precut and stocked, it is susceptible to stretching. If it is formed of other materials it may be subject to either stretching or shrinkage. As a result, if a platform wrapper is first sewn to the counter-cover element as in the process described in my Patent 2,493,497 it may subsequently be found, during assembly or after completion of the shoe, that the upper edge of the counter-cover element does not lie properly on the upper (or quarter) or that the platform wrapper is sewed at an improper level.

By placing a short line of stitches such as those at 16, 26 or 36 at the top or appropriate level of the counter-covering element, to tack it down in proper location upon the upper, the lower edge of the counter-covering element is left free for subsequent attachment of the platform wrapper at exactly the level desired, and in this way the parts are properly located, both at the top and at the bottom, regardless of any previous enlargement, shrinkage or other distortion of the counter-cover element that may have taken place.

Thus, the position and extent of stitches 16, 26 or 36 is such as to permit the counter-cover element 15 to be folded away from the quarter 11 so that the platform cover or wrapper 17 may be easily stitched to the element at the appropriate level near its bottom edge as indicated at 18 in Figures 6 and 7. This bending of the element 15 away from the quarter 11 provides space for the use of a sewing machine without difficulty and without requiring unusual skill. The wrapper 17 is preferably although not necessarily long enough to extend completely around the periphery of the shoe. However, it is desirable to start and terminate the stitches 18 at points slightly spaced from the side edges 20 of the counter covering element 15, as indicated at 19, in order to facilitate further sewing of the element along its side edges.

This step may be next performed, as illustrated by the stitches 21 in Figure 8, which leaves the counter-covering element 15 attached to the quarter 11 on all sides except its bottom edge which is free of stitches other than those connecting it to the wrapper 17. During the operation of stitching the sides 20 of the counter-cover 15 to the quarter 11 the ends of the wrapper 17 may be raised out of the way as indicated in Figure 8.

It is now desirable to secure the unattached portions of the wrapper 17, forwardly of the breast-line of the heel, to the sock lining and the portions of the upper forward of the heel region. This securement is by means of stitches 22 (Figure 9) which extend through the vamp 10 and through the margin of the sock lining 12 and are preferably spaced slightly above the line of stitching 13 (not shown in this figure). The stitches 22 may extend to the points 19 (Figure 6) and thereby stitch down to the element 15 those parts of strip 17 which were left detached by terminating the stitches 18 short of the side edges 20.

The next step lies in the positioning of a preformed flanged counter 27 (Figure 10) into the space or pocket beneath the element 15. This space is most clearly indicated in Figure 7 and is designated 29. The counter 27 can be of well-known type, of suitable stiff material, and of a shape which fits snugly into pocket 29 with its flange 28 overlying the sock lining as shown in Figure 11.

At this stage the entire assembly is applied to a last and the shoe structure is then completed as indicated in Figure 12. A platform pad or sole 30 is positioned over the sock lining 12 and counter flange 28. The platform wrapper 17 is then pulled around and over the pad 30 to enclose the periphery of the platform in the usual way, and an outer sole 31 is ultimately applied. The usual adhesive means and pressure are utilized for this assembly of parts.

It is to be understood that in Figure 12 and the other sectional views the sizes of the seams are exaggerated for clarity and are merely representative, in diagrammatic fashion, of the relative positions of the parts. In actual practice, the parts are pulled over the last and assume flattened relationships, closer together than the figures indicate, as is well known in the art.

Shoes such as those partially illustrated in Figures 13–16, in which the shape and size of the counter-covering element is different, may nevertheless be formed and completed by processes identical with those described above.

While the process of the invention has been described as a series of consecutive steps, it will be readily understood that the particular manner of assembling the counter-covering element lends itself to variations in the sequence of steps as well as in the shapes and sizes of the shoe parts involved. For example, instead of sewing the sock lining to the upper first, this may be done after the counter-covering element and the upper have been partially or completely assembled. If desired, the sock lining, upper and unattached portions of the platform wrapper, forwardly of the breast-line of the heel, may be stitched together in one operation after the counter-covering element and upper have been first secured together. And in those instances where the upper is composed of several parts as herein illustrated, one part may be attached to the counter-covering element prior to or subsequent to the attachment of the sock lining to either or both parts or the attachment of such parts to each other. This flexibility is of great advantage in permitting maximum use of lesser skilled operators and in scheduling factory assembly operations to maintain a full force busy without interruption or delay.

The process serves to reduce losses due to re-

jection of parts and completed shoes necessitated by stretching or other distortion of the counter-covering elements while awaiting final use. Other advantages of the procedure lie in its applicability to shoes of varying design and to the placement of reinforcement counters in regions other than the heel. The finished article of footwear has a neat appearance in the part rigidified by the counter, whether this be in the heel region, in the toe region or elsewhere, and the shoe always has a soft and comfortable interior, since the sock lining is not susceptible to displacement and is devoid of edges which might curl and thereby cause discomfort or impair the attractiveness of shoes having openings at the toe or elsewhere. The invention is suitable for a variety of shoes, slippers, sandals and similar items intended for either street wear or indoor use, and obviously the materials used and the styles employed are widely variable.

In general, it will be understood that those skilled in the art may readily make changes in many of the details herein described and illustrated, without necessarily departing from the scope and spirit of the invention as expressed in the appended claims.

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

1. In a procedure for making a slip-lasted shoe, the sequence of steps which includes stitching a counter-covering element to an upper but only along the top edge of the element, thereafter stitching a platform wrapper to the lower edge of the element, subsequently stitching the side edges of said element to the upper, thereby attaching said element to the upper along all sides except its bottom edge and forming a pocket between said upper and said counter-covering element open only along said bottom edge, and thereafter inserting a counter into said pocket.

2. In a procedure for making a slip-lasted shoe, the sequence of steps which includes juxtaposing an upper and a counter-covering element in the relative positions desired in the finished shoe, stitching them together only along the top edge of the one which is lowermost, turning said element away from the upper and stitching a platform wrapper along the bottom edge of the element, the stitches starting and ending intermediate the side edges of said element, subsequently stitching the side edges of said element to the upper, thereby attaching said element to the upper along all sides except its bottom edge and forming a pocket between said upper and

said counter-covering element open only along said bottom edge, and thereafter inserting a counter into said pocket.

3. In a procedure for making a slip-lasted shoe, the sequence of steps which includes juxtaposing an upper and a counter-covering element in the relative positions desired in the finished shoe, stitching them together only along the top edge of the one which is lowermost, turning said element away from the upper and stitching a platform wrapper along the bottom edge of the element, the stitches starting and ending intermediate the side edges of said element, thereby attaching said element to the upper along all sides except its bottom edge and forming a pocket between said upper and said counter-covering element open only along said bottom edge, subsequently stitching the side edges of said element to the upper, stitching the unstitched portions of the wrapper to the lower edges of said upper forward of the breast-line of the heel and throughout the extent of the shoe, and thereafter inserting a counter into said pocket.

4. In a procedure for making a slip-lasted shoe having a sock lining secured along its periphery to an upper throughout the full length of the lower edge of the upper, the sequence of operations which includes juxtaposing the upper and a counter-covering element in the final relative positions desired in the finished shoe, stitching them together only along the top edge of the one which is lowermost, and thereafter stitching a platform wrapper to the bottom edge of said element, whereby the upper edge of said element and the line of stitching on said wrapper will be properly positioned in the finished shoe regardless of any stretching of said counter-covering element prior to either of said stitching operations.

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