July 3, 1945. H. W. COHEN 2,379,681

FOOTWEAR

Filed Oct. 18, 1944 3 Sheets-Sheet 1

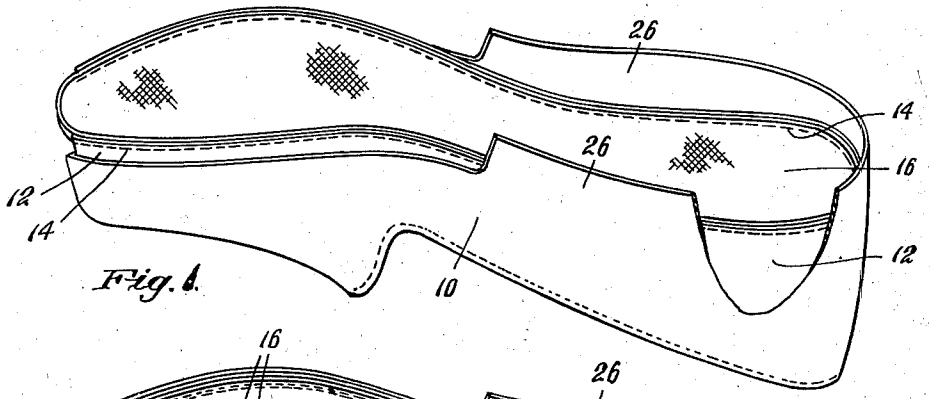


Fig. 1.

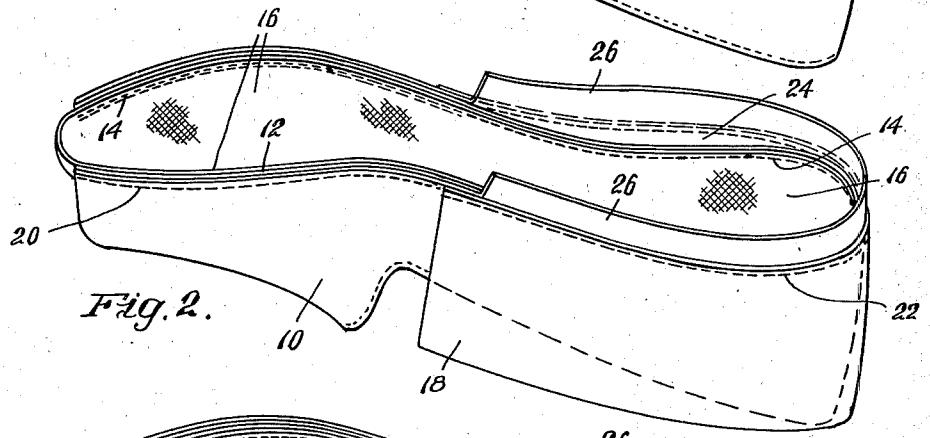


Fig. 2.

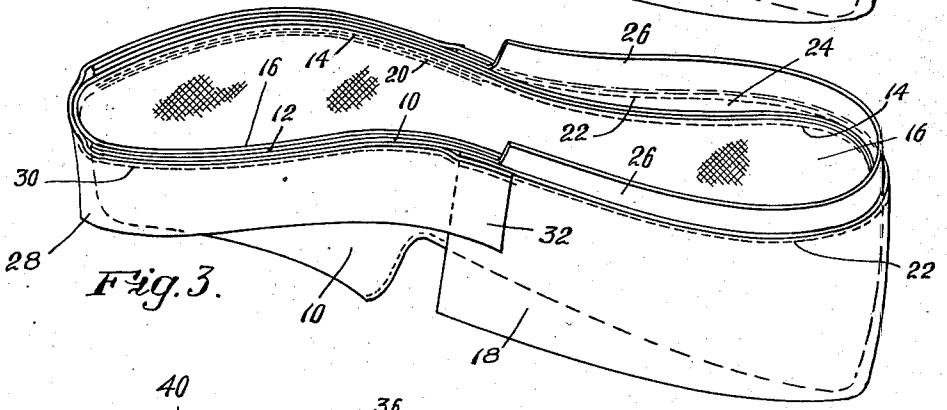


Fig. 3.

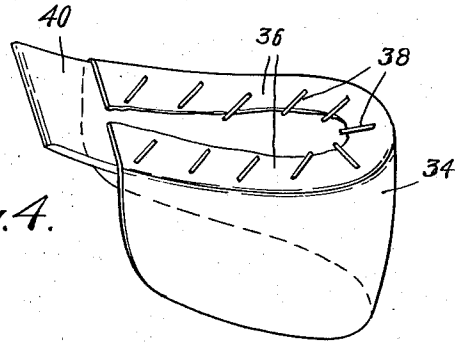


Fig. 4.

INVENTOR.
Harold W. Cohen
BY his Atty
John H. McKenna

July 3, 1945. H. W. COHEN 2,379,681

FOOTWEAR

Filed Oct. 18, 1944 3 Sheets-Sheet 2

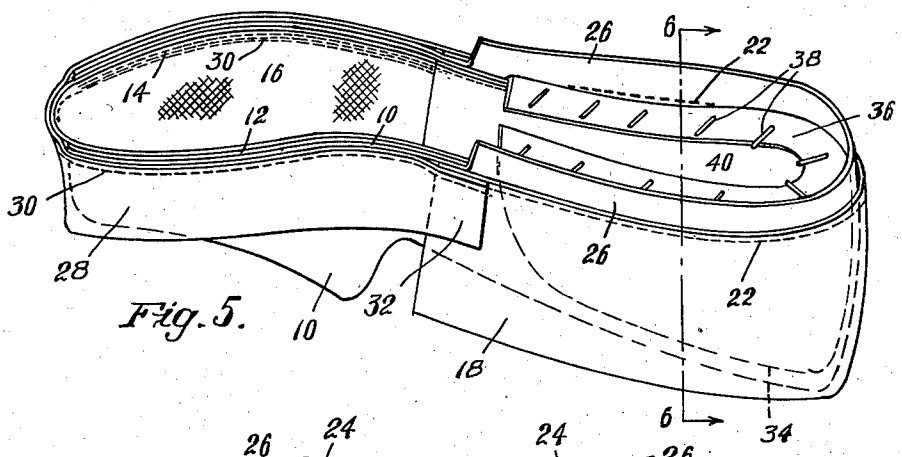


Fig. 5.

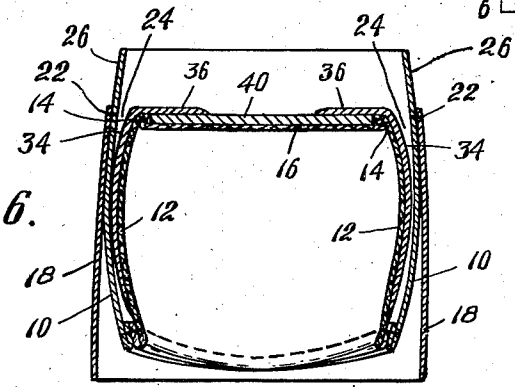


Fig. 6.

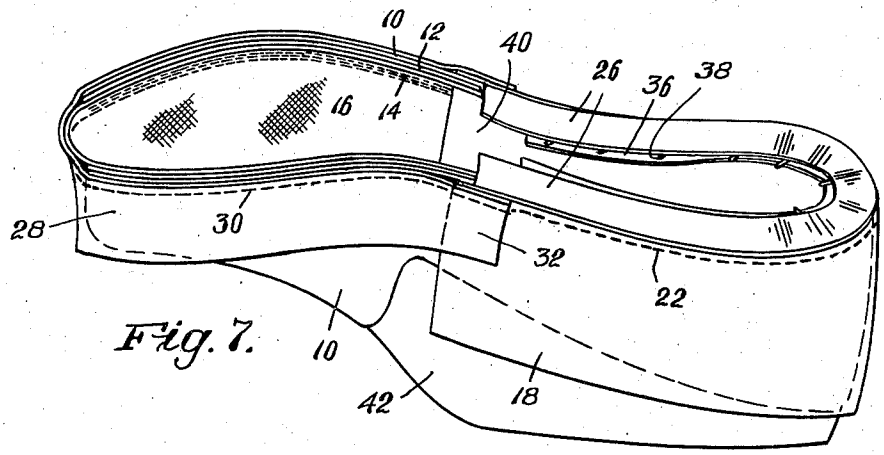


Fig. 7.

INVENTOR.
Harold W. Cohen
BY his Atty
John H. McKenna

July 3, 1945. H. W. COHEN 2,379,681

FOOTWEAR

Filed Oct. 18, 1944 3 Sheets-Sheet 3

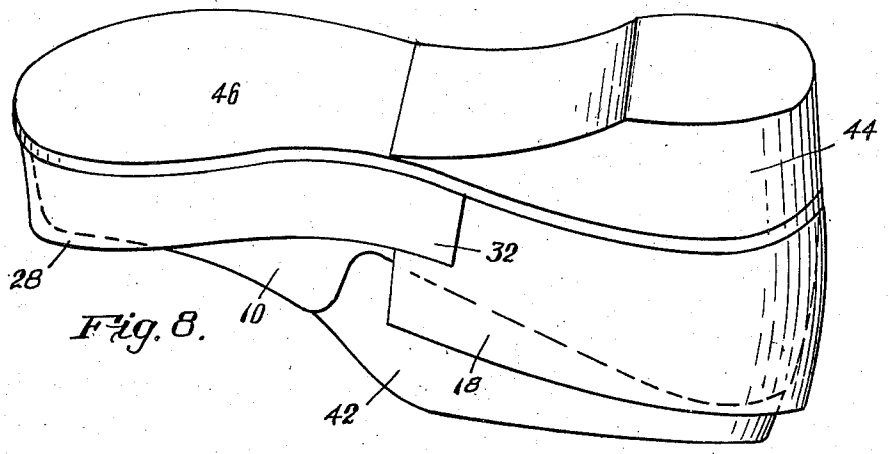


Fig. 8.

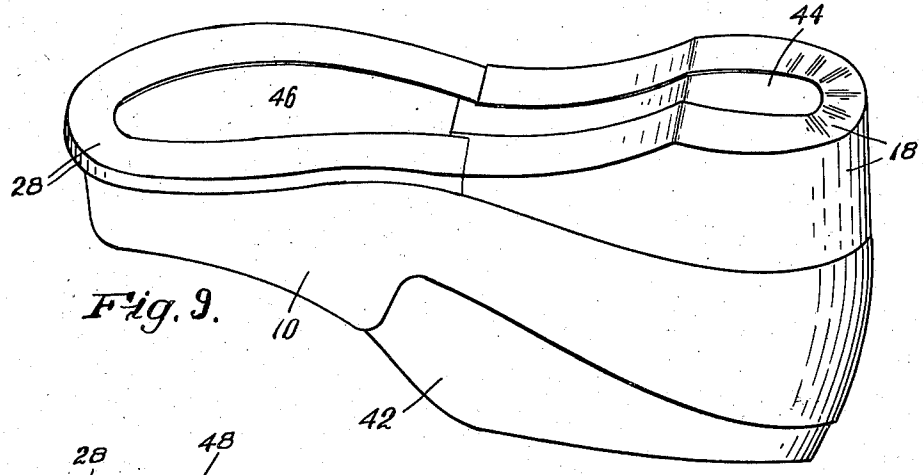


Fig. 9.

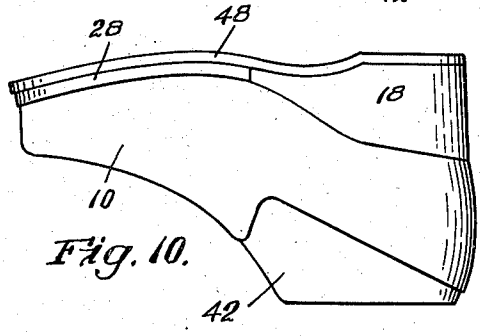


Fig. 10.

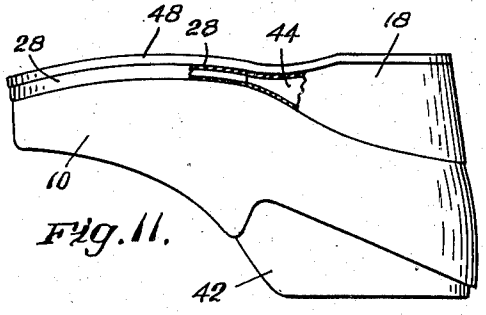


Fig. 11.

INVENTOR.
Harold W. Cohen
BY his Atty
John H. McKenna

Patented July 3, 1945 2,379,681

UNITED STATES PATENT OFFICE

2,379,681

FOOTWEAR

Harold W. Cohen, Manchester, N. H., assignor to Bee Bee Shoe Company, Manchester, N. H., a corporation of New Hampshire

Application October 18, 1944, Serial No. 559,159

8 Claims. (Cl. 36—19.5)

This invention relates to improvements in footwear and methods of making footwear. More particularly it provides improvements in shoes and slippers of the general type which have so-called slip-lasted foreparts and which have their rear parts formed on a last after the last has been slipped into the pre-formed forepart.

Shoes and slippers of the general type to which the invention relates have various advantages over other footwear and methods so far as manufacturing costs are concerned. The forepart of the upper quickly and conveniently can be stitched to an insole element or sock lining while the shoe or slipper is free of a last, after which a last is slipped into the pre-stitched forepart preliminary to a lasting of the upper at rear portions of the shoe or slipper.

However, so far as I am aware, it has not been possible according to prior methods of making such footwear to embody in the shoe or slipper construction a suitably stiff counter. The practice has been to incorporate a counter element between the upper material and its lining which counter element has had to be flexible enough or plastic enough to shape itself to the last contour during lasting of the rear part of the article. As a result, when the last is removed, the counter cannot have a desired resilient stiffness such as is provided by conventional pre-formed counters.

It is an object of my invention to provide footwear of the mentioned general type which can have a conventional pre-formed and resiliently stiff counter therein. I employ structural elements, and a method of combining them, whereby a full length sock lining may be stitched to the lining of the upper all around the shoe or slipper while the shoe is free of a last, the upper, around the forepart only, being simultaneously stitched to the sock lining, and the rear part of the upper being left unstitched so that a counter receiving pocket is provided between the stitched lining and the unstitched upper which latter, after insertion of a pre-formed counter in the pocket and after insertion of a last in the shoe, may be turned over upon the conventional counter flange and secured by cement, the sock lining providing a clean and attractive inner exposed surface throughout the extent of the shoe.

A feature is that a conventional pre-formed flanged counter may be stapled or otherwise secured to a base sheet which constitutes a bottom for the counter, and this base sheet and counter are embodied in the shoe as a unit with the base sheet underlying the sock lining at the shank and heel regions and with the counter engaged within the mentioned pocket formed between the upper and its lining at rear portions of the shoe.

Another object is to provide on the upper at rear portions thereof an edge extension for being turned over upon the flange of the counter and secured thereto after the counter has been inserted in its pocket and after a last has been inserted in the shoe.

Still another object is to provide on the upper separately stitched platform and heel covering elements, the heel-covering element being stitched to the upper exteriorly thereof with its stitch line spaced substantially from the edge of the upper so that the edge portion of the upper projecting beyond said stitch line is available within the heel-covering element for the said turning over upon the counter flange, and the platform element being separately stitched to the forepart of the upper exteriorly thereof, said covering elements being adapted to be turned over the edges of platform and heel elements and secured thereto prior to applying an outsole.

It is, moreover, my purpose and object generally to improve upon prior shoe-making methods and prior shoe and slipper structures.

In the accompanying drawings:

Figure 1 is a perspective of a shoe upper, upper lining and sock lining showing the upper lining stitched to the sock lining all around the shoe, the stitching being done while the upper and lining are free of a last;

Figure 2 is a similar view showing how the forepart of the upper is next stitched to the pre-stitched upper lining and sock lining, and showing a heel covering element stitched to the rear portion of the upper while the pre-stitched upper lining and sock lining at the rear portion are left unattached to the upper by the stitching;

Figure 3 is a view similar to Figure 2 with the addition of a platform covering element stitched to the upper around its forepart;

Figure 4 is a perspective of a pre-formed counter unit;

Figure 5 is a view similar to Figure 3 but having the pre-formed counter unit inserted in the pocket provided between the upper and upper lining;

Figure 6 is a cross-sectional view approximately on line 6—6 of Figure 5;

Figure 7 is a perspective of the shoe of Figure 5 after a last has been inserted therein and showing the rear edge-projection of the upper lasted over upon the counter flange;

Figure 8 is a similar view with platform and heel units laid in place;

Figure 9 is a similar view showing the platform and heel units covered at their edges with the covering elements;

Figure 10 is a side elevation of the shoe of Figure 9 with an outsole element thereon; and

Figure 11 is a side elevation of a slightly modified construction in which a platform extending only at the forepart is butted against the forward edge of the heel unit.

Referring to the drawings, the upper **10** may be of any suitable flexible material and may be varied as to cut and general style and design characteristics depending upon the style and design of the finished shoe which is contemplated. However, my invention and features have to do primarily with so-called slip-lasted shoes or slippers, the forepart of the uppers of which are stitched to an insole element or sock lining while the upper is free of a last and the last is subsequently slipped into the upper preliminary to lasting of rear portions of the shoe.

In the embodiment herein shown, the upper **10** has associated therewith a lining **12** which extends throughout the upper. As seen in Fig. 1, this lining **12** is stitched as at **14** to a full length sock lining **16** all around the latter while the shoe is free of a last, the upper remaining without direct connection to the sock lining after this initial stitching.

Having stitched the lining **12** and sock lining **16** together as in Fig. 1, a heel covering element **18** of flexible sheet material is arranged upon the upper around the rear part of the upper as seen in Fig. 2, the side of the sheet element **18** which is to be exposed in the shoe being toward the upper in Fig. 2. Then the upper **10** is stitched to the pre-stitched lining and sock lining all around the forepart as at **20** in Fig. 2, and this line of stitching is continued around the rear part of the shoe as at **22**, thereby to stitch the heel covering element **18** to the upper all around the rear part. However, the rear portions of the pre-stitched lining and sock lining are depressed or otherwise moved so as to be clear of the stitches **22** around the rear part of the shoe, which leaves the rear part of the upper still free from direct attachment to the pre-stitched lining and sock lining and provides an open pocket **24** between the lining **12** and the upper **10** around the counter region of the shoe. An edge projection **26** of upper material extends substantially beyond the stitch line **22** all around the counter region for a purpose which later will appear.

Fig. 3 shows a platform covering strip **28** of flexible sheet material arranged around the forepart of the upper and separately stitched thereto by the line of stitching **30**, although it may be put on prior to the stitching at **20**, **22** so as to be secured by the stitches **20**. However, I have found it preferable to separately stitch the strip **28** as in Fig. 3 and to have it over-lap a little the heel covering element **18** as shown at **32**.

According to my invention, a resiliently stiff pre-formed counter may be embodied in the shoe structure as made and assembled as herein described. Such a pre-formed counter **34**, as best seen in Fig. 4, has the conventional base flange **36** and, preferably the counter is preliminarily stapled as at **38**, or otherwise secured, to a bottoming element **40** so that the counter and its bottoming element may be inserted in the shoe as a unit.

This counter unit of Fig. 4 is arranged in the shoe as shown in Fig. 5, with the relatively stiff side walls of the counter inserted in the pocket **24** formed, as previously described, between the lining **12** and the upper **10** at the rear part of the shoe. Preferably the counter unit is put in while the shoe structure continues free of a last, after which a last **42** may be slipped into the upper preparatory to lasting of rear parts of the shoe. It is desirable in most cases to coat the interior surfaces of the counter and its bottoming element with a suitable adhesive so that the lining **12** and sock lining **16** will become securely and smoothly adhered thereto when last **42** is inserted.

The rear portion of upper **10** is now ready for lasting by turning the edge extensions **26** thereof over upon the flange **36** of the counter and securing them in their positions of Fig. 7 as by cement.

The sole and heel structures to be applied to the intermediate structure of Fig. 7 may be variously shaped and combined to vary the design and style at the base regions of the shoe. As represented in Fig. 8, a wedge type of heel block **44** is combined with a full length platform element **46**, the block **44** being secured to the platform by cement with or without additional mechanical fastenings, and the platform may be coated on each side with adhesive so that it may be stuck on the structure of Fig. 7 as shown in Fig. 8, after which the platform covering strip **28** is turned over the edge of the platform and inward against the cement-coated marginal regions of the exposed face of the platform, and the heel covering element **18** similarly is turned over the heel unit and secured to exposed marginal regions thereof, as by cement, all as illustrated in Fig. 9.

An outsole element **48** finally is adhered or otherwise secured in place to provide the completed shoe seen in Fig. 10.

If desired, the platform may have extent only at the forepart and be butted against the forward edge of the heel block as suggested in Fig. 11.

It will be obvious from the foregoing description that I have provided an economical and practical method of making and assembling shoe elements in a manner to permit embodiment in a slip-lasted shoe structure of a desirably resiliently stiff pre-formed counter, and otherwise have improved shoe making procedures and resulting shoe structures.

I claim as my invention:

1. The method of making an article of footwear comprising stitching a full length sock lining to the lining of a shoe upper all around the sock lining and stitching the upper to the sock lining only around the forepart of the sock lining and leaving the rear part of the upper free from direct attachment to the sock lining, said stitching being done while the shoe upper and lining are free of a last, followed by inserting a pre-formed resiliently stiff counter with base flange between the upper and lining at the rear portions thereof with the base flange of the counter underlying the sock lining, and then slipping a last into the upper and lasting the rear part of the upper and turning and securing edge portions thereof over upon the base flange of the counter, and completing the shoe by applying and securing thereto outsole and heel elements.

2. The method of making an article of footwear comprising stitching a full length sock lining to the lining of a shoe upper all around the sock lining and stitching the upper to the sock lining only around the forepart of the sock lining and leaving the rear part of the upper free

from direct attachment to the sock lining, stitching a heel covering element to the upper around the rear part of the upper and exteriorly thereof and leaving a substantial edge portion of upper projecting beyond the stitch line, stitching a platform covering strip to the upper around the forepart of the upper and exteriorly thereof, all of said stitching being done prior to insertion of a last in the shoe upper, followed by inserting a flanged resiliently stiff pre-formed counter between the rear portions of the upper and lining and then inserting a last in the upper, after which said rear projecting edge portion of the upper is turned over and secured to the flange of the counter, platform and heel elements applied, and said platform and heel covering elements turned over the edges of their respective elements and secured to marginal regions of the exposed sides thereof, and finally applying and securing an outsole thereon.

3. The method of making an article of footwear having a pre-stitched slip-lasted forepart and a lasted rear part, comprising stitching an upper, its lining and a platform cover strip to a full length sock lining around only the forepart of the sock lining, and stitching only the lining of the upper to the sock lining around the rear portion of the sock lining, and stitching a heel cover strip to the upper around the rear portion thereof, and leaving a substantial edge portion of upper projecting beyond the stitch line, inserting a flanged pre-formed stiff counter between the rear portions of the upper and its lining, followed by inserting a last in the upper and lasting the rear portion of upper by turning said projecting edge portion thereof over upon the flange of the counter, and then applying platform and heel elements and turning the platform and heel cover strips respectively over the edges thereof and inward over marginal regions of the exposed faces thereof, and finally applying and securing an outsole thereon.

4. The method of combining footwear elements for reception of a pre-formed counter at the rear portion thereof, comprising stitching a full length sock lining to an upper lining all around the sock lining and to the upper only around the forepart thereof, leaving the rear portions of the upper and its lining free from direct securement together so that a pre-formed counter may be inserted between them, said stitching being done prior to insertion of a last in the upper, and said rear portion of the upper having edge extent capable of being turned inward during a lasting of said rear portion of the upper subsequent to insertion of a last in the upper.

5. An article of footwear comprising an upper, a lining and a sock lining in which the upper and lining are stitched to the sock lining around the forepart of the article, and the lining only is stitched to the sock lining around the rear portion of the article, a pre-formed stiff flanged counter between the rear portions of the upper and lining with its flange underlying the sock lining, said rear portion of the upper being lasted and having an edge portion turned over upon and secured to the flange of the counter, an outsole element and heel, and means securing the outsole element and heel to the upper.

6. An article of footwear comprising an upper, a lining, a sock lining, and platform and heel covering means, in which the upper, its lining and said covering means are stitched to the sock lining around the forepart of the article, and the lining only is stitched to the sock lining around the rear portion of the article, and said covering means is stitched only to the upper around the rear portion of the article with a substantial edge portion of the upper projecting beyond the line of the latter said stitching, a preformed flanged and stiff counter between the rear portions of the upper and lining with its flange underlying the said sock lining, said rear portion of the upper being lasted and having its said projecting edge portion turned inward over and secured to the flange of the counter, a platform and a heel over the edges of which said covering means is wrapped, and an outsole secured on the platform and heel elements.

7. An article of footwear comprising an upper, a lining and a sock lining, all stitched together around the forepart only of the article, and the lining and sock lining being stitched together around the rear portion of the article, leaving the rear portion of the upper free of the latter said stitches, a stiff pre-formed flanged counter between the lining and upper around the rear portion of the article with the flange of the counter underlying the sock lining, said rear portion of upper being lasted and edge parts thereof being turned over upon and secured to the flange of the counter, a platform element and a heel, and means secured to the upper and wrapped around the edges of said platform and heel, and an outsole secured on the platform and heel.

8. An article of footwear comprising an upper, a lining, a sock lining and platform and heel covering means, all stitched together around the forepart only of the article, said sock lining and lining being stitched together around the rear portion of the article, and said upper and covering means being stitched together around the rear portion of the article, a stiff pre-formed flanged counter between the upper and lining around the rear portion of the article with its flange underlying the sock lining, the rear part of the upper being lasted and having edge parts thereof turned over upon and secured to said flange of the counter, a platform element and a heel, said covering means being turned over the edges of the platform and heel, and an outsole secured to the platform and heel.

HAROLD W. COHEN.