April 5, 1949. G. B. CARSON 2,466,637

METHOD OF ASSEMBLING SHOE PARTS

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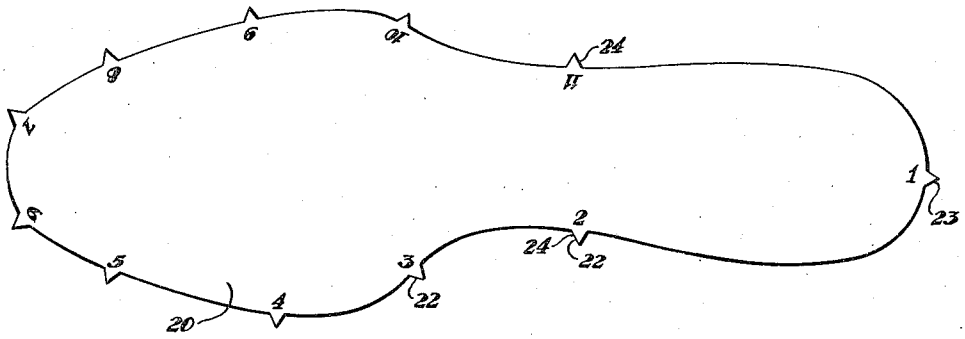


Fig. 1

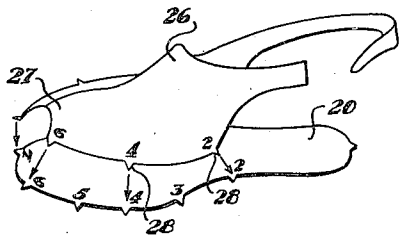


Fig. 2

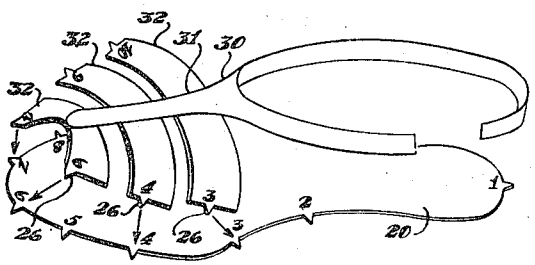


Fig. 3

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METHOD OF ASSEMBLING SHOE PARTS

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This invention relates to the manufacture of shoes and to the manufacture of sock linings for shoes. More particularly this invention is directed to the construction of slip lasted or force lasted shoes in which the sock lining and the upper are preassembled and stitched together before the shoe is put on a last.

Modern shoes, particularly women's shoes, come in a great variety of styles and shapes. The uppers of these shoes have specially styled designs and often include open spaces between narrow strips of leather, which strips are designed to give the shoe a distinctive appearance. Each strip of leather must be attached at the proper point on the sock lining if the shoe is to have a proper appearance and fit. For shoes of a given size and last style, the sock lining of all shoes have one shape and size regardless of the design of the upper. Thus, uppers of varying types and styles must be attached to a single size of sock lining.

In the past it has been customary to mark sock linings and uppers at the appropriate positions for attachment of each of the strips or parts making up the upper. This marking is done either by machine or by hand, and necessitates a second operation after the shoe uppers are cut. Each style of shoe in this system requires a separate set of marking patterns or dies, with the resultant heavy expense required by such equipment. In certain instances, match marks similar to those described herein were placed on dies to eliminate the hand marking, but these are normally good only for the one style for which they were especially intended. Thus, when styles change and a model is to be discontinued, the previously-used marking patterns or dies have to be scrapped and new ones made. The use of this invention will eliminate such wasteful procedures and result in an economic improvement in the art of shoe making.

Therefore, it is a principal objective of this invention to produces a sock lining for slip lasted or force lasted shoes which sock lining is marked automatically in a manner appropriate for use with varying types of uppers.

Briefly the sock lining of this invention includes a series of marks about the periphery of the sock lining. These marks are made in the form of small teeth or spurs projecting from the periphery of the sock lining, and sufficient teeth are provided to give sufficient marking indicia for use with varying types of uppers. The sock lining with these teeth attached can be die cut in a single operation, and thus hand marking is

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avoided. Each upper is marked with sufficient similar teeth to locate each part of the upper and properly to orient the upper with respect to the sock lining. The pattern pieces for the uppers can have the spurs or teeth numbered, so as to indicate their relationship to the basic spurs or teeth on the sock lining. Since this numbering system is basic and is used with all styles of shoes, the operators readily familiarize themselves with the numbering and it is unnecessary to mark the numbers on the actual shoe parts.

Small teeth are preferred as the marking indicia because the teeth in no way weaken the structure of upper and sock lining, because the teeth can be cut with the same die which cuts the sock lining or upper, and because once the sock lining and upper are stitched together the teeth may be removed without leaving any visible mark on the finished shoe.

Other objects and certain advantages will be more apparent in the accompanying drawings illustrating a preferred embodiment of the invention and in which:

Figure 1 is a plan view of a sock lining constructed in accordance with this invention.

Figure 2 is a perspective view showing a sock lining and upper constructed in accordance with this invention.

Figure 3 shows in perspective a sock lining and an upper of different form from the upper shown in Figure 2.

As illustrated in Figure 1 the sock lining includes a body portion 20 which is constructed of leather or other suitable material in the conventional manner except that a plurality of small spurs or teeth 22 are attached along the periphery of the sock lining 20. Each of the teeth 22 is formed from a portion of the material of the sock lining 20 and thus is an integral part of the sock lining.

The teeth are preferably arranged as shown in Figure 1 with a single spur or tooth 23 in the heel area of the shoe, a pair of teeth 24 in the shank area and a number of teeth surrounding the forepart of the foot and the toe area. More teeth are provided in the toe area because it is the forepart of a woman's shoe in which the greatest number of style variations occur. The spurs or teeth are numbered consecutively from one (1) to the maximum, the markings being explained and described on written standard practice instruction sheets which accompanying each style of shoe. Said marks are numbered consecutively in a clockwise direction around the lining of the shoe as viewed from above, although it is not

necessary to carry out this particular system, since any systematic method of numbering will produce the same result.

In Figure 2 is shown one type of upper pattern piece **26** in position above the sock lining **20**. The upper pattern piece **26** has a relatively continuous toe covering section **27** and includes marked spurs or teeth **28** which correspond with certain of the spurs or teeth **22** on the sock lining **20**. With the aid of these indicia uppers made in accordance with the pattern **26** and the sock lining can be properly, quickly, and simply oriented prior to sewing.

In the style of upper here illustrated the spurs **2**, **4**, **6**, **7**, **9** and **11** of the upper are attached to the corresponding ones of the sock lining.

In Figure 3 is shown an upper pattern piece **30** of a different construction from that shown in Figure 2. The upper pattern piece **30** includes a strip **31** to which are attached three transverse strips **32**. At each end of each of the strips **32**, is a spur or tooth **36** which corresponds to one of the teeth **22** on the sock lining **20**.

In the style of upper illustrated in Figure 3 the spurs **3**, **4**, **6**, **7**, **9** and **10** are attached to corresponding ones of the sock lining.

As can easily be seen from the drawings the one sock lining of the configuration shown in Figure 1 is adaptable for using with both the upper pattern piece **26** and the upper pattern piece **30**. Moreover, this single sock lining is suitable for use with many other types of upper construction; and, thus, by the use of the sock lining of this invention, the need for second operations, and new dies for each style is eliminated.

Having described my invention, I claim:

1. In a method of manufacturing shoes, the steps of providing a sock lining with a body portion and a basic plurality of spurs arranged around the periphery of said body portion, marking the spurs with suitable indicia, providing an upper with a plurality of corresponding spurs, matching the spurs on the upper to the appropriate marked spurs on the sock lining, fastening the upper and the sock lining together and then removing said spurs on both the upper and the sock lining.

2. The method of matching a sock lining to any upper selected from a variety of uppers of different styles and configurations, which method comprises providing the sock lining with integral locating spurs extending outwardly from the periphery of said sock lining at each of the regions of the sock lining where the sock lining is to be secured to each type of upper selected to be used, providing the selected upper with locating spurs extending outwardly from the periphery of the upper at each of the regions of the upper where the upper is to be secured to the sock lining, matching the spurs of the upper in facial engagement with the spurs on the sock lining which indicate the proper regions of attachment for that upper to the sock lining and securing the matched parts together.

3. The method of matching a sock lining to any upper selected from a variety of uppers of different styles and configurations, which method comprises providing the sock lining with integral locating spurs extending outwardly from the periphery of said sock lining at each of the regions of the sock lining where the sock lining is to be secured to each type of upper selected to be used, providing the selected upper with locating spurs extending outwardly from the periphery of the upper at each of the regions of the upper where the upper is to be secured to the sock lining, matching the spurs of the upper in facial engagement with the spurs on the sock lining which indicate the proper regions of attachment for that upper to the sock lining, securing the matched parts together and removing the spurs from both the upper and the sock lining.

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