M. M. MERRITT.

SHOE LAST.

APPLICATION FILED MAR. 27, 1917.

1,282,260. Patented Oct. 22, 1918.

Fig. 3.

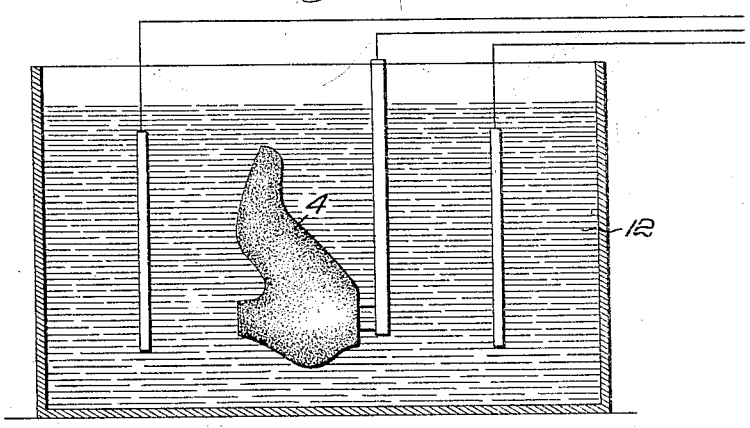


Fig. 1.

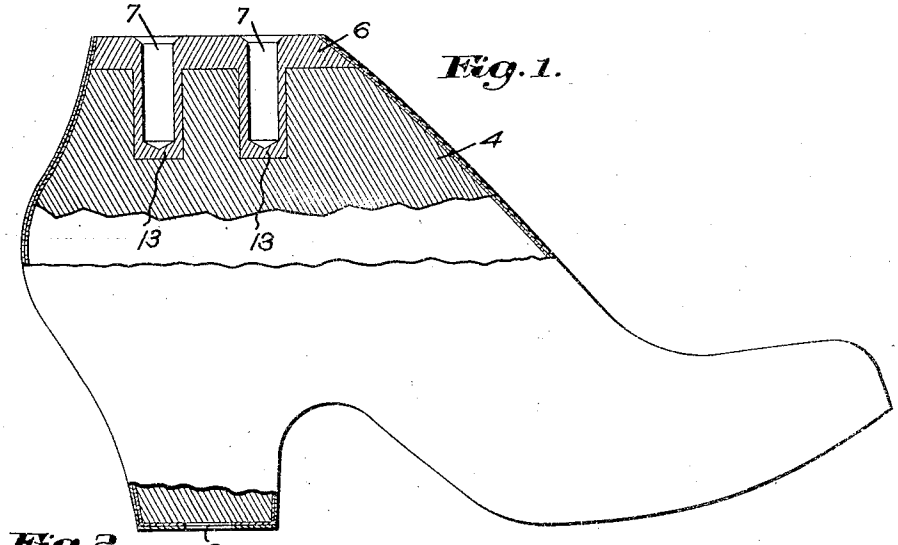
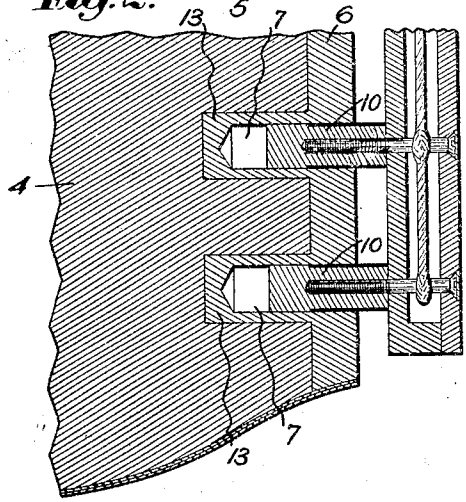


Fig. 2.



Inventor:
Matthew M. Merritt.
by Emery, Booth, Janney & Varney
Attys.

UNITED STATES PATENT OFFICE.

MATTHEW M. MERRITT, OF DANVERS, MASSACHUSETTS, ASSIGNOR TO COPPER PRODUCTS COMPANY, OF BOSTON, MASSACHUSETTS, A CORPORATION OF MAINE

SHOE-LAST.

1,282,260. Specification of Letters Patent. Patented Oct. 22, 1918.

Application filed March 27, 1917. Serial No. 157,841.

To all whom it may concern:

Be it known that I, MATTHEW M. MERRITT, a citizen of the United States, and a resident of Danvers, county of Essex, Commonwealth of Massachusetts, (whose post-office address is Danvers, Massachusetts,) have invented an Improvement in Shoe-Lasts, of which the following description, in connection with the accompanying drawings, is a specification, like characters on the drawings representing like parts.

This invention pertains to improvements in lasts and methods of making the same.

The drawings show one embodiment of a preferred construction of my invention and of a preferred method of making the same.

Figure 1 is a side elevation, partly in section of a last;

Fig. 2 is a section showing a portion of the last connected to a cathode in a preferred manner;

Fig. 3 illustrates diagrammatically the last in process of manufacture by my improved method.

In the drawings I have shown in Fig. 1 a last 4 preferably formed by the electrolytic deposit of copper or other metal over a form of any suitable material but preferably fusible, so that the last may be made hollow by melting out the contained material through any suitable aperture typified by the hole 5 drilled through the deposited metal. The copper or other metal forming the principal electrolytic deposit is preferably plated with a metal which is unaffected by the fumes incidental to the manufacture of rubber shoes and the like. Where the form is of non-conductive material I may coat it with graphite or other pulverent conductive material prior to the electrolytic process.

To provide great strength at the top of the last and also to provide spindle holes for use with the last and a convenient method of connecting the form to the cathode I provide a metallic reinforcement shaped to conform to the shape of the top of the last and having spindle holes 7 therein. The latter may and preferably do project inwardly from the reinforcing element 6 thereby providing two projections in to the form. When the latter is cast the reinforcing strip is preferably placed in the mold so that the form is strengthened and an opportunity for efficient electrical connection is provided.

I preferably manufacture lasts of the character described by the following method. I first provide a mold of the shape desired and then place the reinforcing strip in the mold with the projections therefrom extending inwardly. I then fill the mold with a plastic material, preferably adapted to be softened by heat. When the form is sufficiently hardened I remove it from the mold, smooth any imperfections and coat it with powdered graphite or other pulverent conductor. I then introduce into the spindle holes conductor terminals 10 which may be identical with those shown in my co-pending application Serial No. 64,607, filed December 3, 1915, metal surfaced article. The form is then immersed in any suitable electrolytic bath 12 and the copper or other suitable metal electrolytically applied. Where copper is used I prefer to apply electrolytically a second coating of nickel or other metal not seriously affected by the fumes incidental to the manufacture of rubber shoes. After the electrolytic deposit is completed I preferably drill through the deposit and melt out the material of which the form was composed.

The metal reinforcing strip 6 especially when provided as shown with projections 13—13 and spindle holes 7—7, is of marked advantage in any type of last coated with electrolytically deposited metal, for it provides a relatively thick top for the last having an extended connection with the deposited metal, a strong connection between the projections 13 and the form over which the last is made, and a plurality of spindle holes properly positioned relative to each other and to the rest of the last.

While I have shown and described a specific last and one method of making the same, it will be understood that changes may be made in the product and method within the scope of the appended claims.

Claims:

1. A last having a metallic reinforcing strip at the top thereof and an electrolytically deposited hollow shell, said reinforc-

ing piece providing two inwardly extending projections, and spindle holes extending through said reinforcing strip into said projections.

2. A reinforcement for the top of an electrolytically deposited last including a relatively thick strip conforming to the shape of the top of the last and provided with a projection, said strip and said projection being apertured to provide a spindle hole.

In testimony whereof I have signed my name to this specification.

MATTHEW M. MERRITT.