

May 17, 1938.

H. C. KING

2,117,333

SHOE AND METHOD OF MAKING IT

Filed July 3, 1937

2 Sheets-Sheet 1

Fig. 1

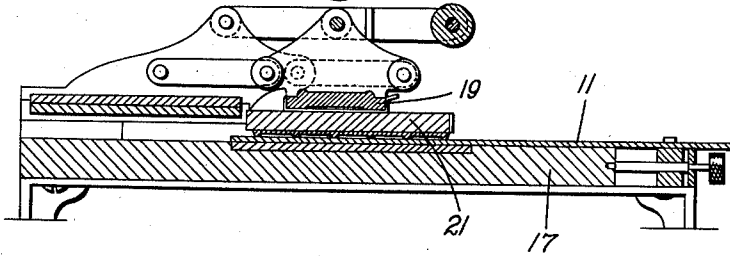


Fig. 2

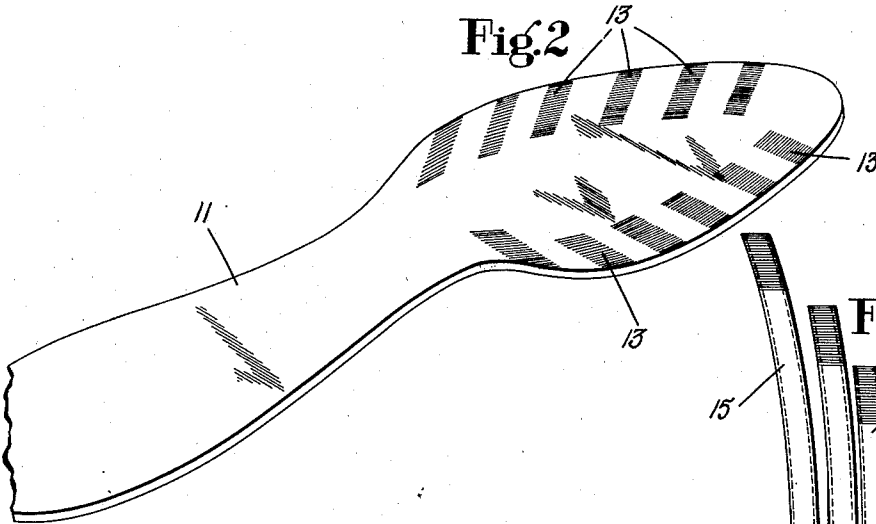


Fig. 3

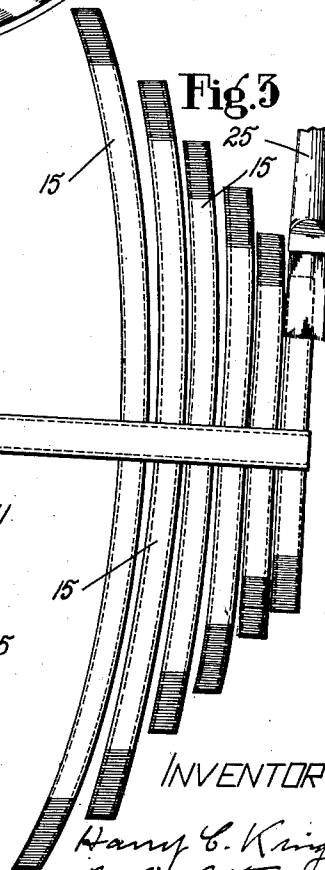
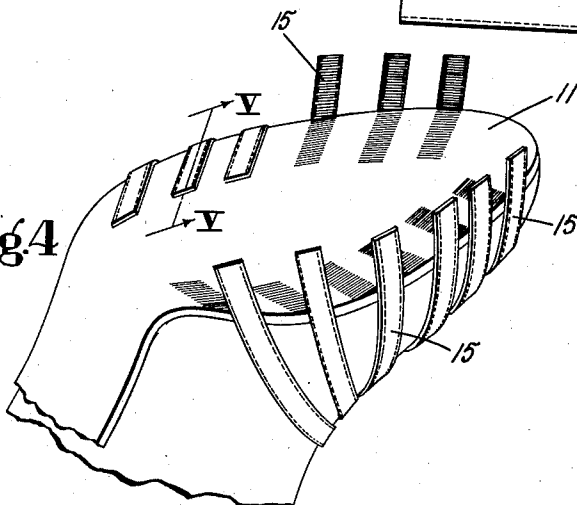


Fig. 4



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Fig. 5

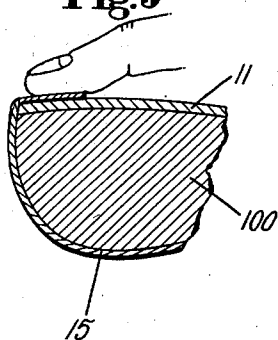


Fig. 6

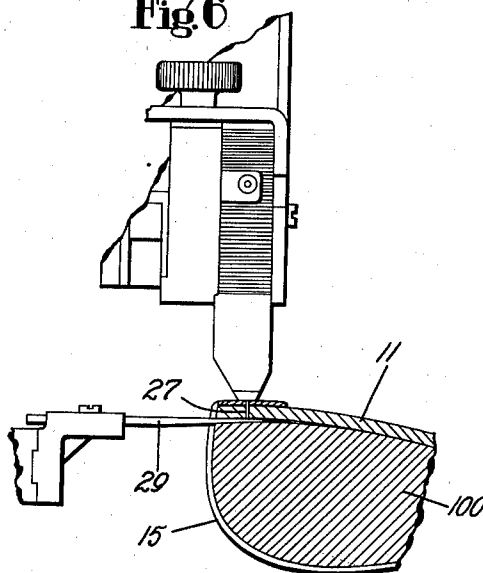


Fig. 7

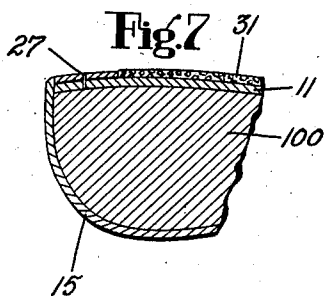
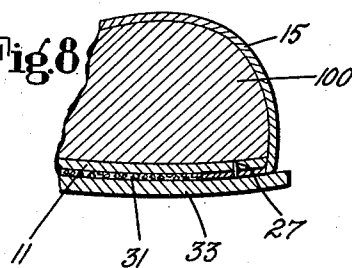


Fig. 8



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UNITED STATES PATENT OFFICE

2,117,333

SHOE AND METHOD OF MAKING IT

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Application July 3, 1937, Serial No. 151,877

10 Claims. (Cl. 12—142)

This invention relates to the manufacture of shoes the uppers of which comprise spaced portions the ends of which are overlapped upon and attached to a face of the insole and is herein illustrated in its application to the manufacture of a strap sandal.

In the lasting of strap sandals two procedures have commonly been employed. According to one procedure the ends of the straps are pulled over upon and fastened in place by tacks, after which the ends of some or all of the straps are stapled to the insole. According to the other procedure, in which no tacks are used, the end of each strap, as soon as it has been pulled over upon the bottom of the insole, is held in place by the operator's fingers and stapled to the insole.

The present invention provides a method by which the lasting operation may be simplified and speeded up. To this end the insole is provided on its sole-attaching face with a predetermined pattern of spaced coatings of cement which occupy the positions at which the ends of the straps are to be attached and which are co-extensive at least with said ends. These coatings are preferably applied simultaneously by a machine having a cement-applying die of the desired pattern; and the cement is preferably a colored cement which will contrast strongly with the color of the insole so as to indicate at a glance exactly where the ends of the straps should be placed. With the insole prepared in this manner and the ends of the straps coated with cement, the straps may be quickly tensioned about the last and their cemented ends pressed down upon the coatings to hold them temporarily in place after which the permanent fastening, for example by staples, may be carried out.

Referring now to the accompanying drawings:

Fig. 1 is a view partly in elevation and partly in longitudinal section of a machine for applying to the insole a predetermined pattern of spaced coatings of cement, an insole being shown in process of having such coatings applied;

Fig. 2 is a perspective of an insole with its spaced coatings;

Fig. 3 is a plan of the forepart of the upper of a strap sandal in process of having applied to the ends of its cross-straps coatings of cement;

Fig. 4 is a perspective of the forepart of a partly lasted strap sandal;

Fig. 5 is a cross-section on the line V—V of Fig. 4 showing the end of a strap being pressed down upon its corresponding coating of cement on the insole;

Fig. 6 is a view partly in section and partly in

elevation showing how the end of each strap may be stapled to the insole;

Fig. 7 is a section through a part of a lasted sandal after the ends of the straps have been trimmed and a filler piece applied; and

Fig. 8 is a section through part of a finished sandal.

In the manufacture of the strap sandal herein illustrated there is applied to the forepart of the sole-attaching face of an insole 11 a predetermined pattern of spaced coatings of cement 13, the pattern being such that the coatings occupy the positions at which the ends of the cross straps 15 of the forepart of the upper are to be attached. The spaced coatings 13 may be applied in any desired manner, for example by means of the cement applying machine disclosed in application Serial No. 153,611, filed July 14, 1937 in the name of Herbert E. Edwards. This machine, a portion of which is shown in Fig. 1, comprises a bed or table 17 upon which an insole is placed, a die holder 19, and a removable and replaceable die 21 having cement-applying members so located that when the die is brought down upon the insole by swinging the handle into the position shown, there is applied to the forepart of the insole the pattern of spaced coatings 13 shown in Fig. 2. The coatings 13 are preferably stripes of cement colored to contrast strongly with the color of the insole, extending from the edge of the forepart of the insole obliquely toward the rear, and of a width at least equal to that of the straps. The ends of the straps 15 which are to be lasted over upon and attached to the face of the insole are coated with cement, as shown in Fig. 3, for example by means of a brush 25. The insole 11 is tacked to the bottom of the last and the straps are tensioned one at a time and their cement-coated ends drawn over and pressed down upon the cement coatings 13 on the insole, for example by means of the operator's fingers, the pressing down of a strap being shown in Fig. 5.

After the straps have thus been fastened temporarily in place, they are permanently fastened by metallic fasteners such for example as staples. To this end a staple fastening machine such for example as that disclosed in United States Letters Patent No. 2,057,072, granted October 13, 1936, upon an application filed in the name of Dennis J. Sullivan, may be used, a portion of such a machine being shown in Fig. 6. As shown, a staple 27 is driven through each strap and through the insole, the points of the staples being clenched by means of a thin narrow anvil 29 which is adjustably fastened to the frame of the machine and

may be readily caused to enter between the insole and the bottom of the last.

After the straps have been fastened to the insole, the ends of the straps are trimmed and a filler piece 31 cemented in place. Thereafter an outsole 33 may be attached in any desired manner. As herein shown, the outsole is attached by cement, the margin of the outsole and the exposed sides of the overlapped ends of the straps 15 having been previously roughed, as is customary, to facilitate the securing of a satisfactory bond between the outsole and the straps.

Having thus described my invention, what I claim as new and desire to secure by Letters Patent of the United States is:

1. The method of making a shoe the upper of which comprises spaced portions which are attached to the sole-attaching face of the insole, said method comprising providing upon said face, prior to the lasting operation, a predetermined pattern of spaced coatings of cement, said coatings occupying the positions at which the ends of the spaced portions of the upper are to be attached, coating said ends of said portions with cement, overlasting them, pressing them down upon the coatings, and completing the manufacture of the shoe including attaching the outsole.

2. The method of making a shoe the upper of which comprises spaced portions which are attached to the sole-attaching face of the insole, said method comprising providing upon said face, prior to the lasting operation, a predetermined pattern of spaced coatings of cement colored to contrast with the color of the insole and occupying the positions at which the ends of the spaced portions of the upper are to be attached, coating said ends of said portions with cement, overlasting them, pressing them down upon the coatings, and completing the manufacture of the shoe including attaching the outsole.

3. The method of making an insole for a shoe the upper of which comprises spaced portions which are to be attached to a face of the insole, said method comprising applying simultaneously a plurality of spaced coatings of cement to said face in the localities at which the ends of the spaced portions are to be attached.

4. The method of making an insole for a shoe the upper of which comprises spaced portions

which are to be attached to a face of the insole, said method comprising applying, prior to the lasting operation, a plurality of spaced coatings of cement to said face in the localities at which the ends of the spaced portions are to be attached.

5. The method of making an insole for a shoe the upper of which comprises spaced portions which are to be attached to a face of the insole, said method comprising applying simultaneously a plurality of spaced coatings of cement of a color to contrast with that of the insole to said face in the localities at which the ends of the spaced portions are to be attached.

6. An insole for use in the manufacture of a shoe the upper of which comprises spaced portions which are to be attached to a face of the insole, said insole having upon said face a predetermined pattern of spaced coatings of cement which occupy the positions at which the ends of the spaced portions are to be attached.

7. An insole for use in the manufacture of a shoe the upper of which comprises spaced portions which are to be attached to a face of the insole, said insole having upon said face a predetermined pattern of spaced coatings of cement which occupy the positions at which the ends of the spaced portions are to be attached, said coatings extending inwardly from the edge of the insole.

8. An insole for use in the manufacture of a shoe the upper of which comprises spaced portions which are to be attached to a face of the insole, said insole having upon said face a predetermined pattern of spaced coatings of cement colored to contrast with the color of the insole, and occupying the positions at which the ends of the spaced portions of the upper are to be attached.

9. An insole for use in the manufacture of a strap sandal, said insole having on its sole-attaching face spaced stripes of cement which occupy the positions at which the ends of the straps are to be attached.

10. An insole for use in the manufacture of a strap sandal, said insole having on its sole-attaching face spaced stripes of cement colored to contrast with the color of the insole and occupying the positions at which the ends of the straps are to be attached.

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