

Feb. 6, 1951

J. J. WALSH  
METHOD OF MAKING PREPARED VAMPS FOR INCORPORATION  
IN SLIP LASTED SHOES

2,540,850

Filed July 17, 1948

2 Sheets-Sheet 1

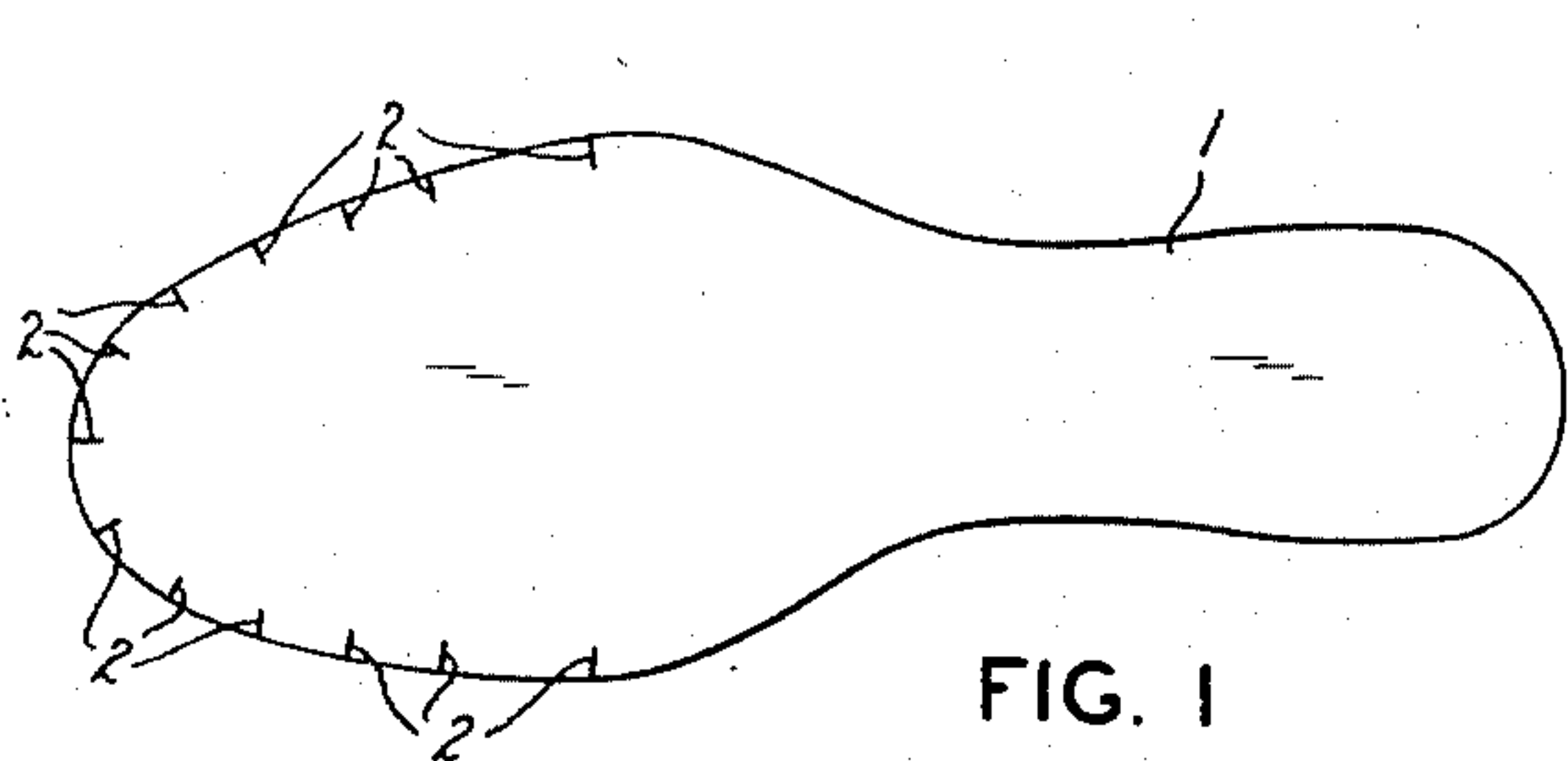


FIG. 1

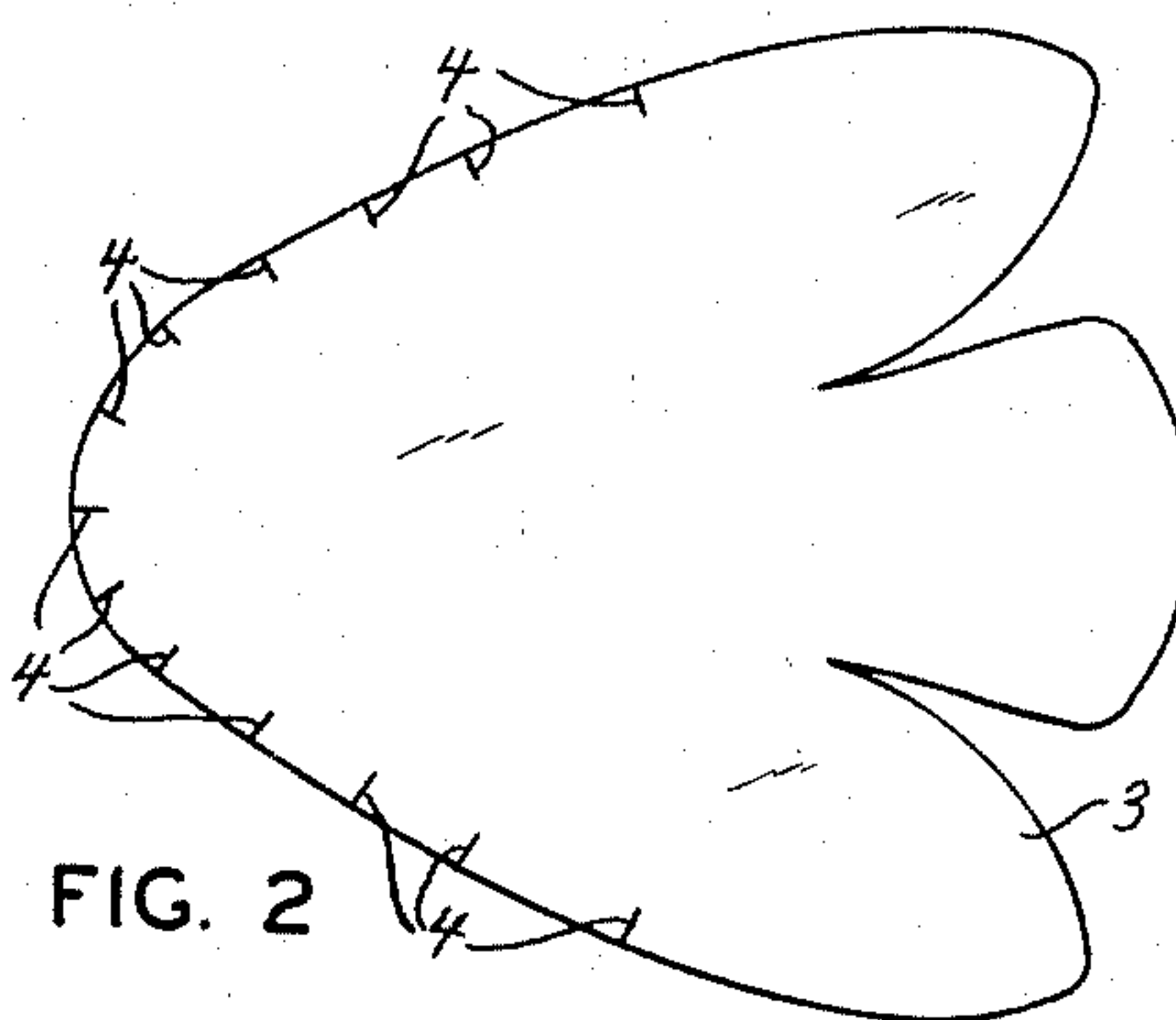


FIG. 2

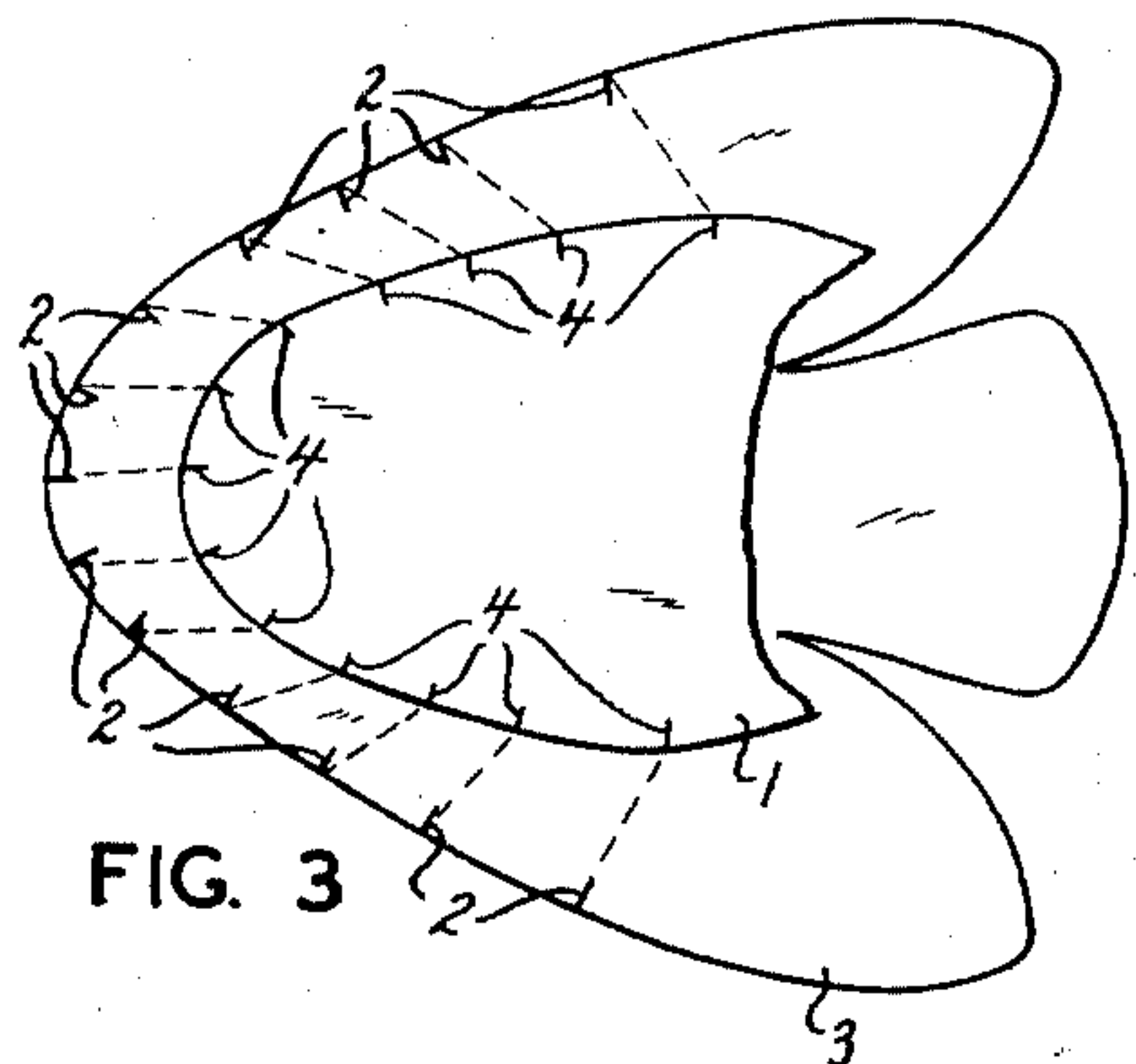


FIG. 3

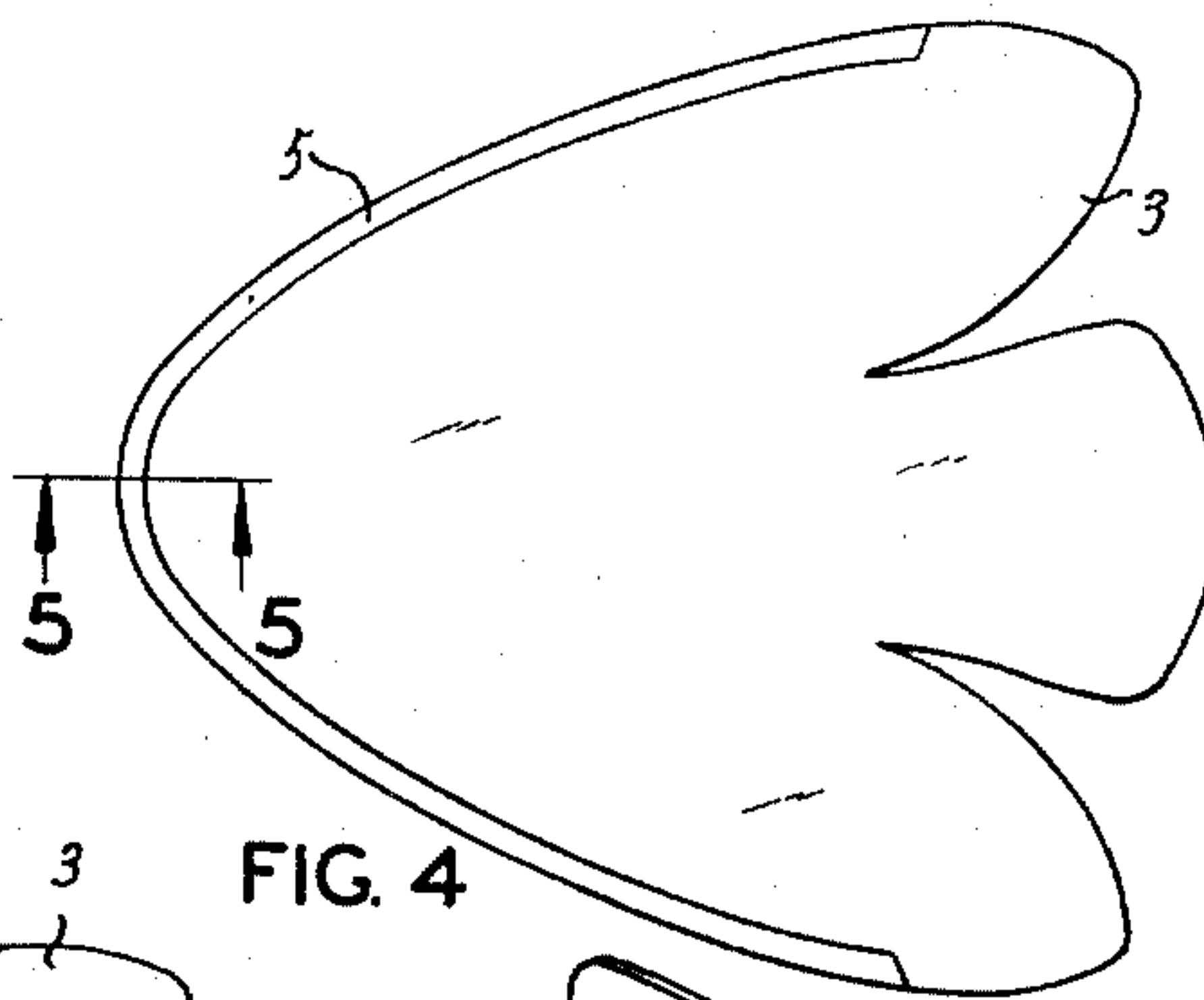


FIG. 4



FIG. 5

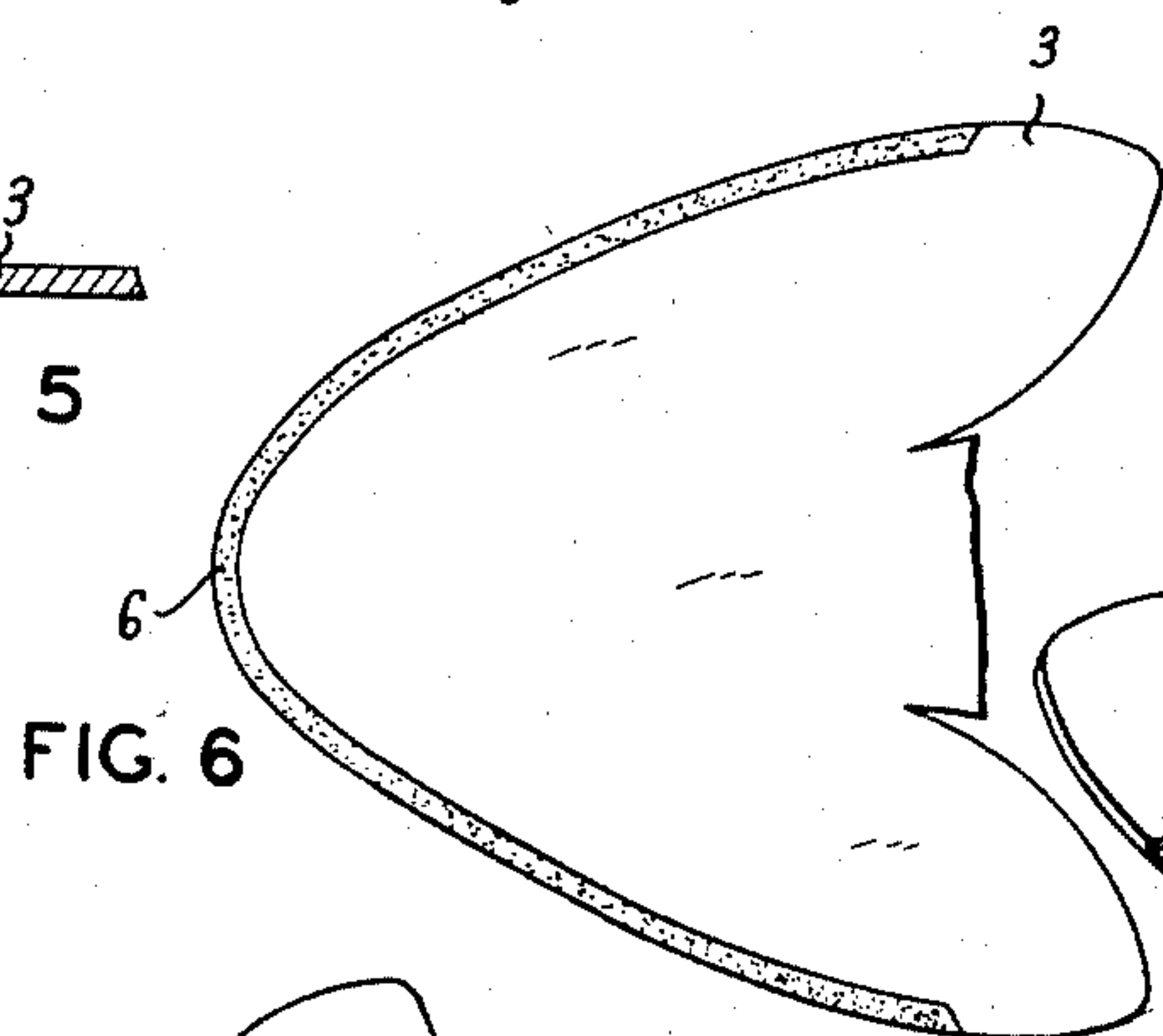


FIG. 6

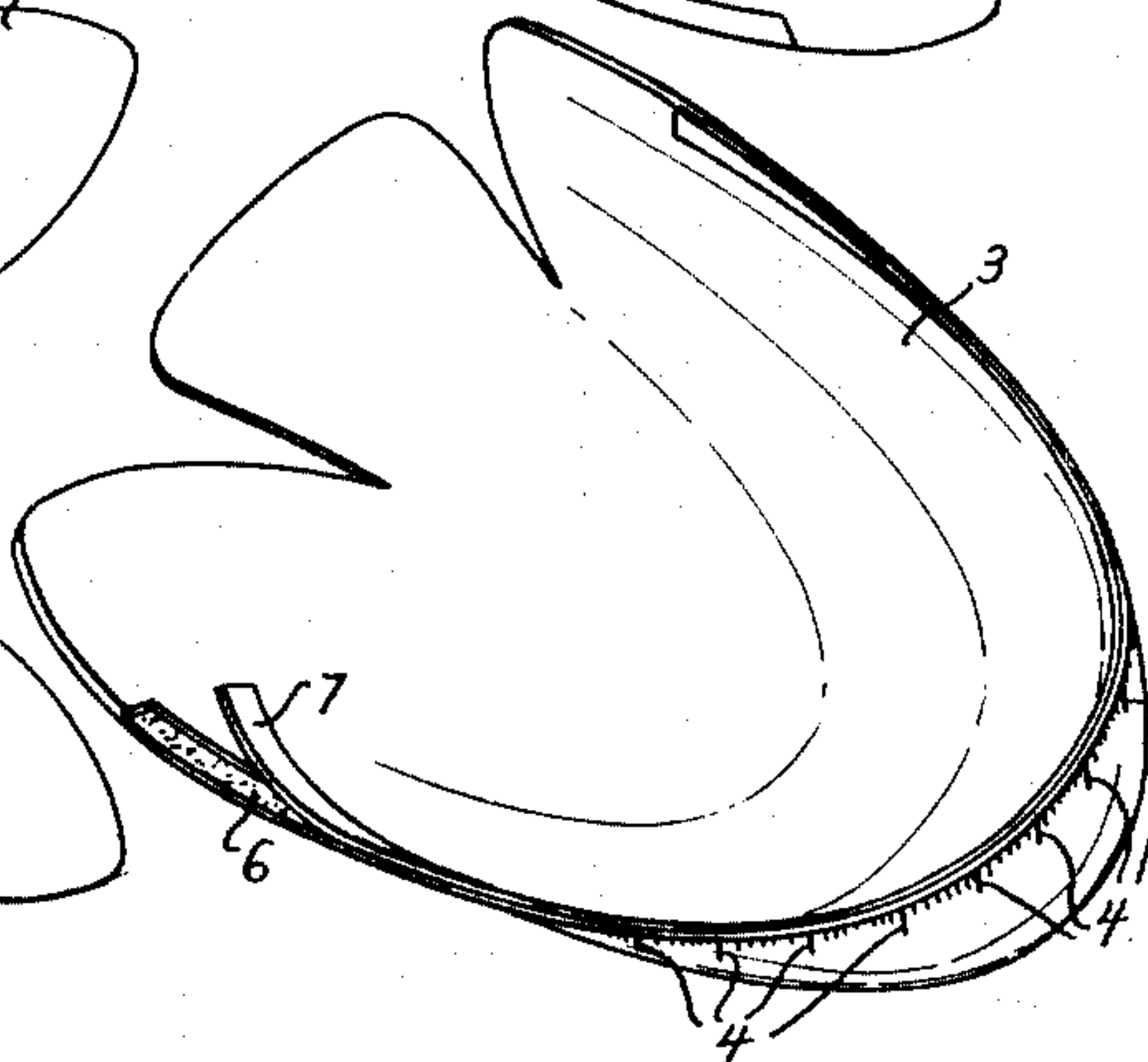


FIG. 8

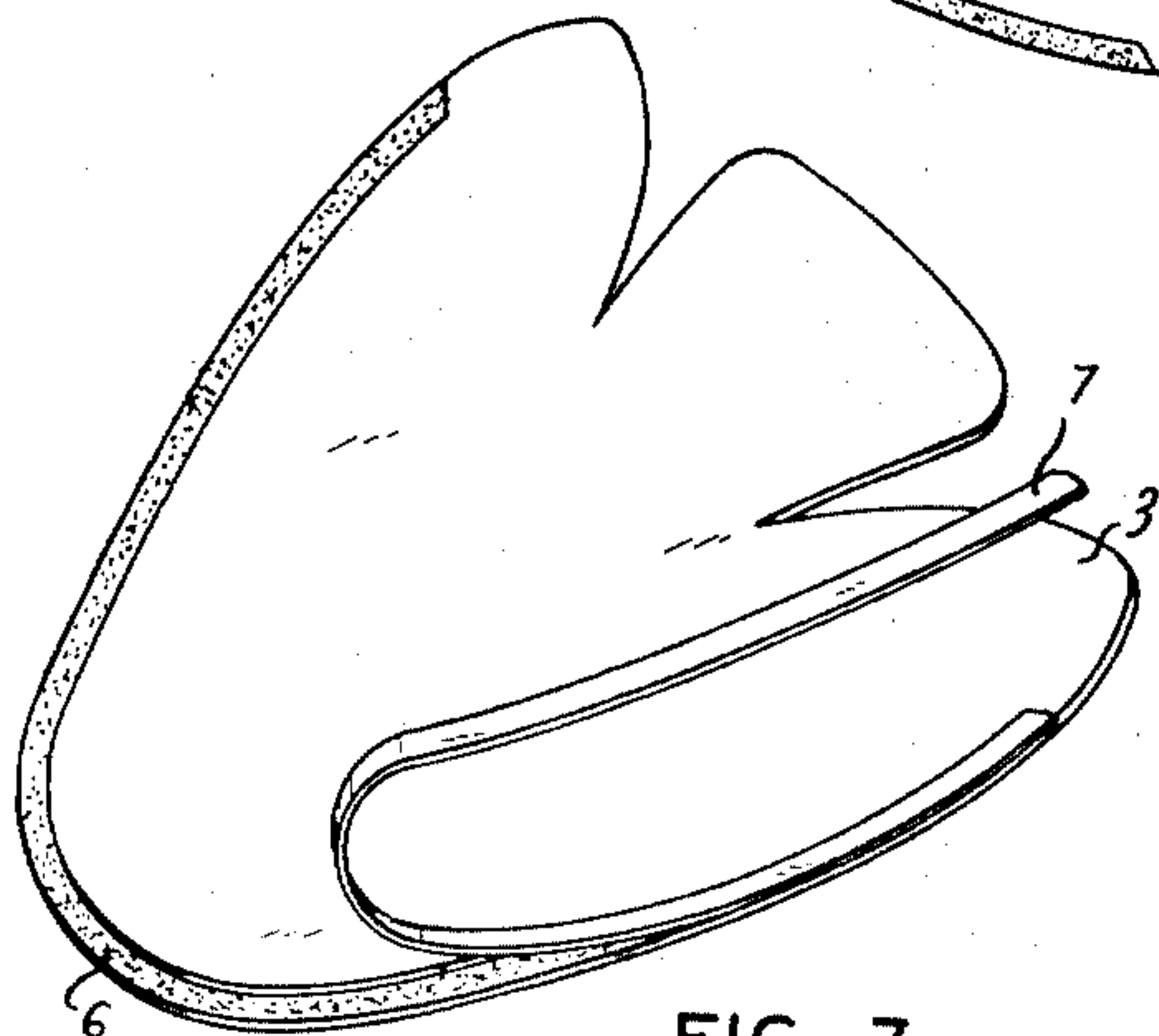


FIG. 7

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2 Sheets-Sheet 2

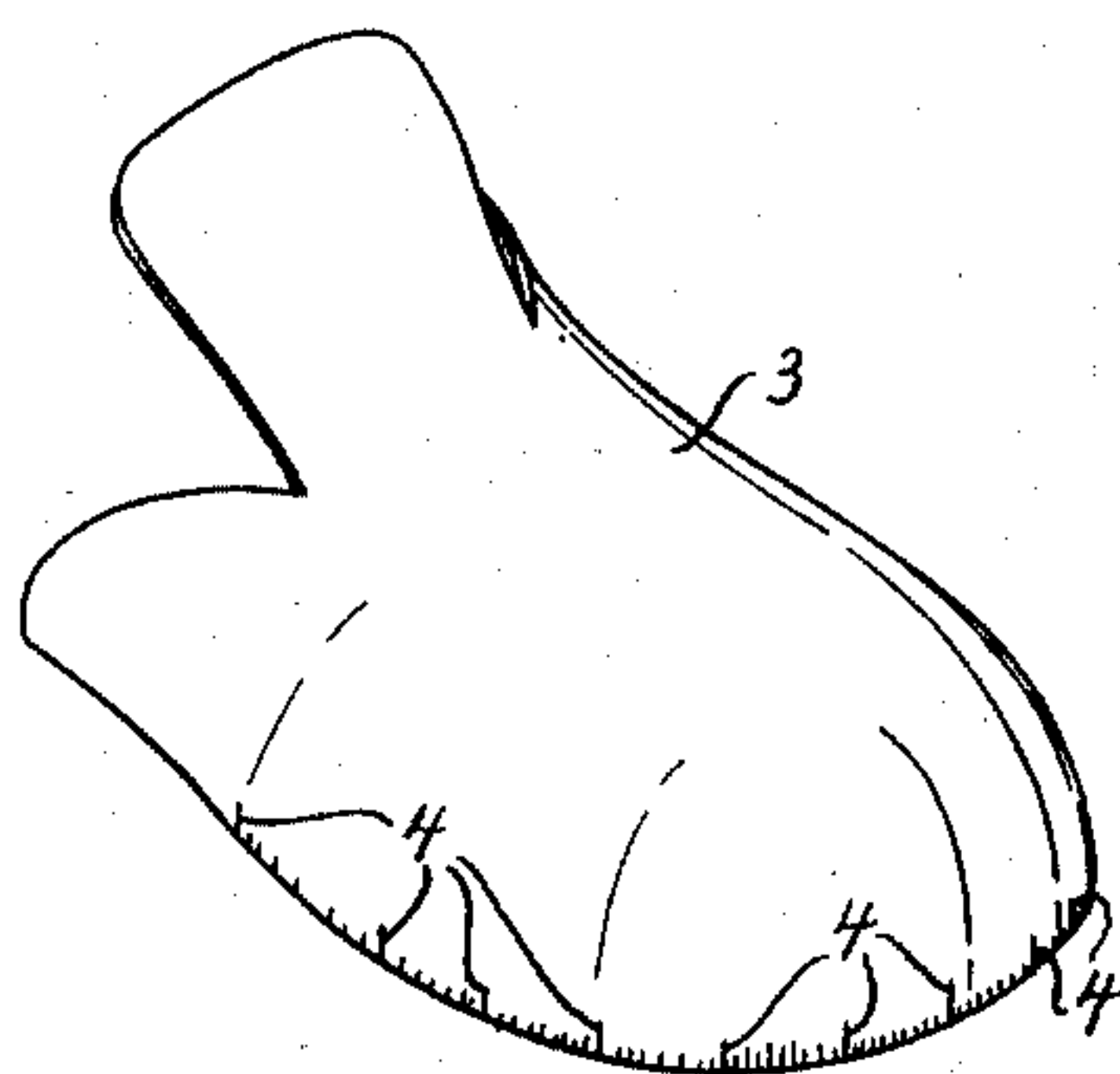


FIG. 9

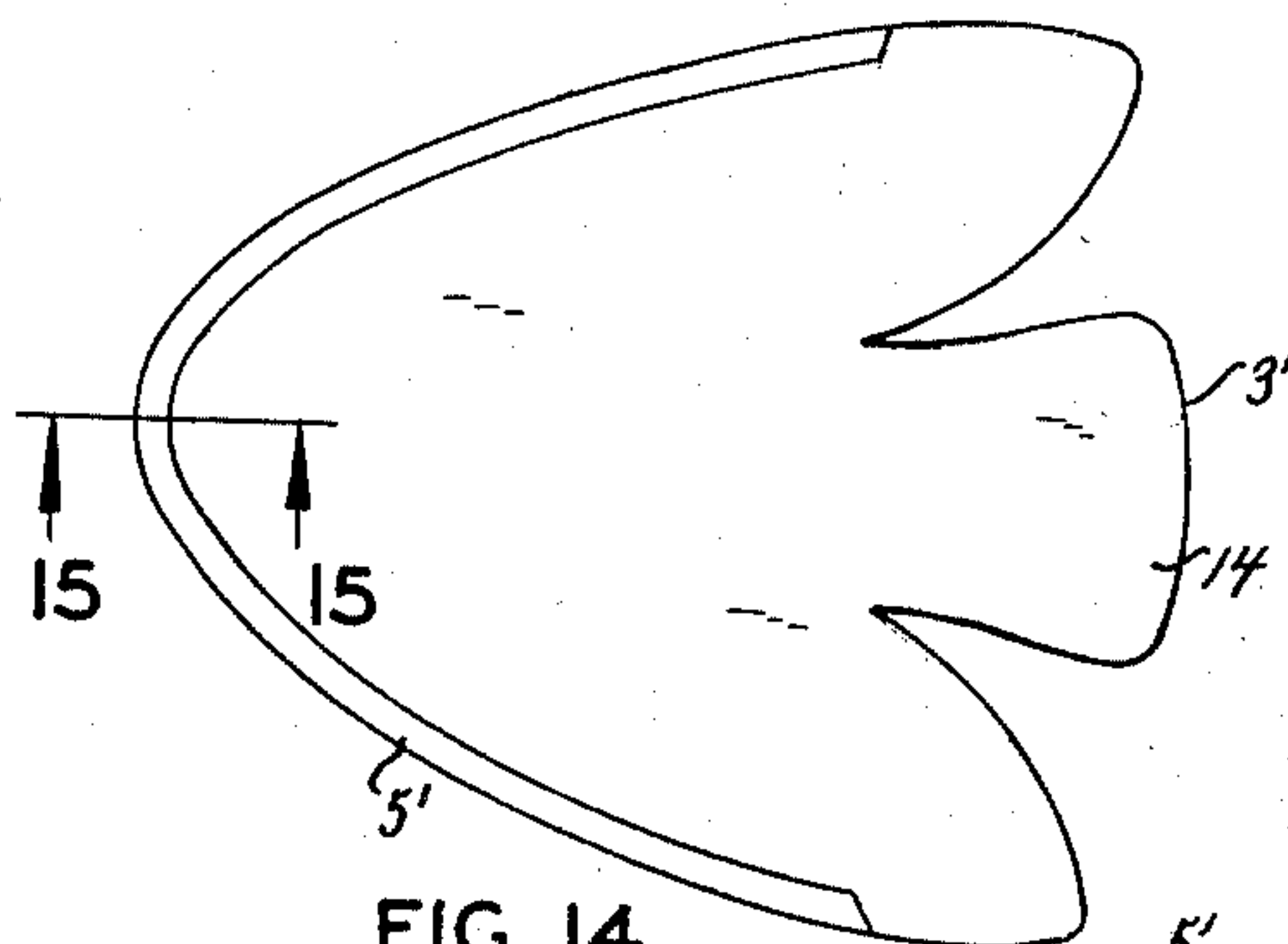


FIG. 14

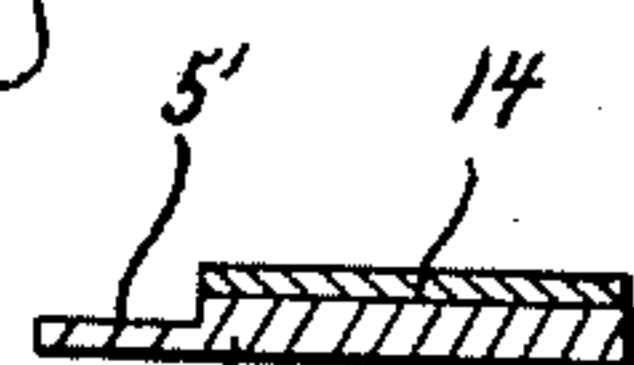


FIG. 15

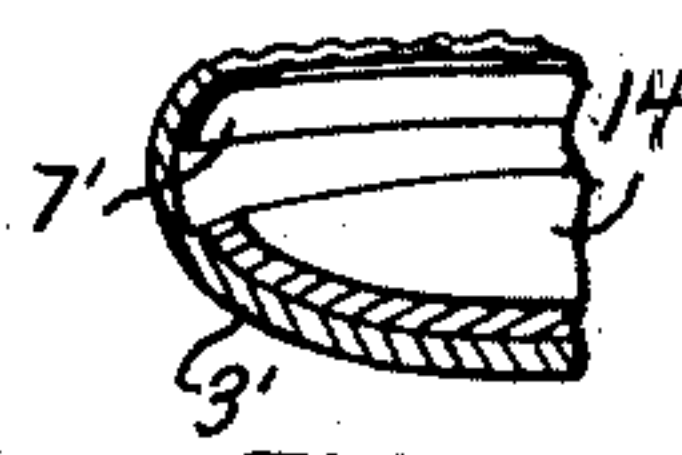


FIG. 16

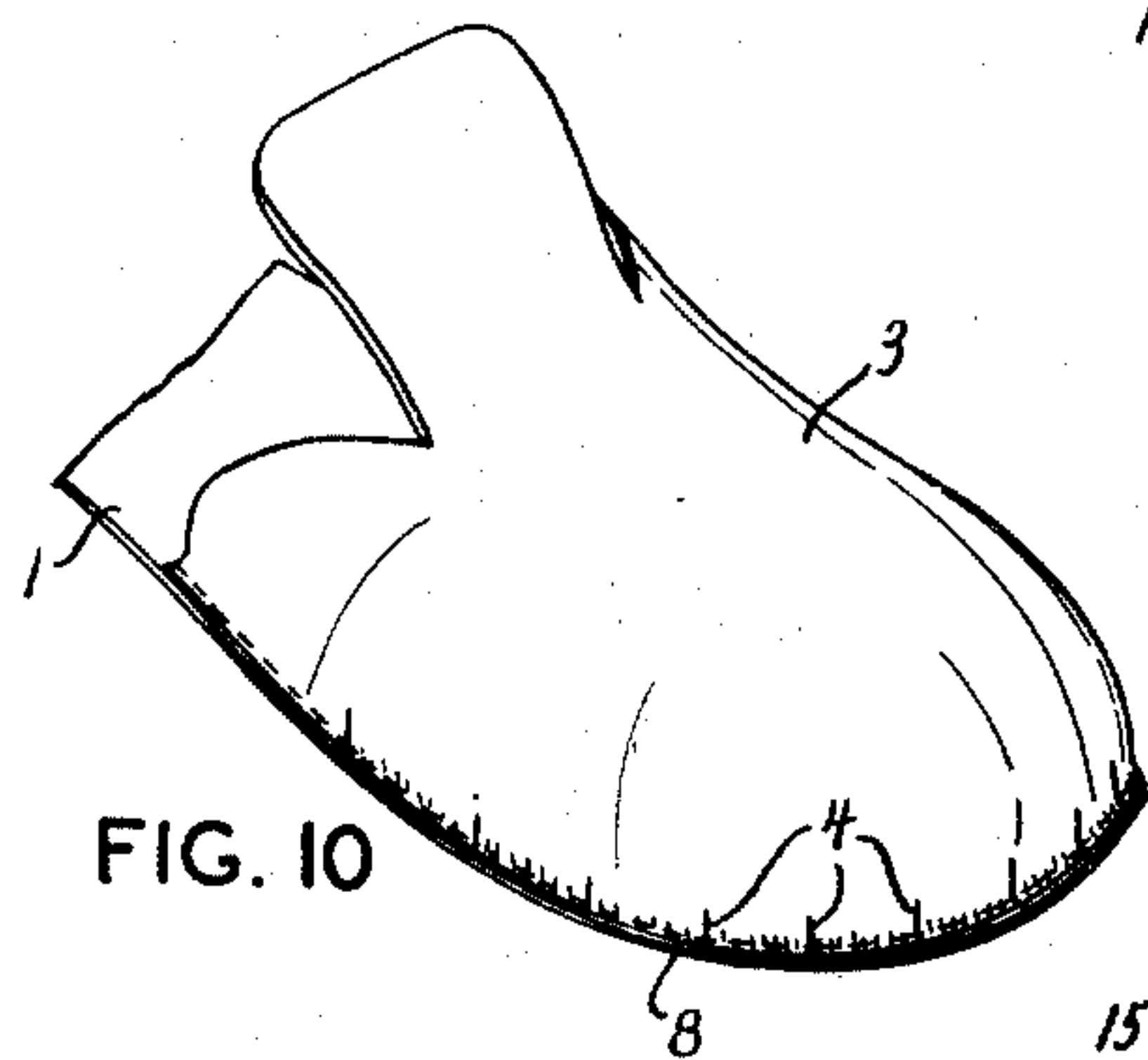


FIG. 10

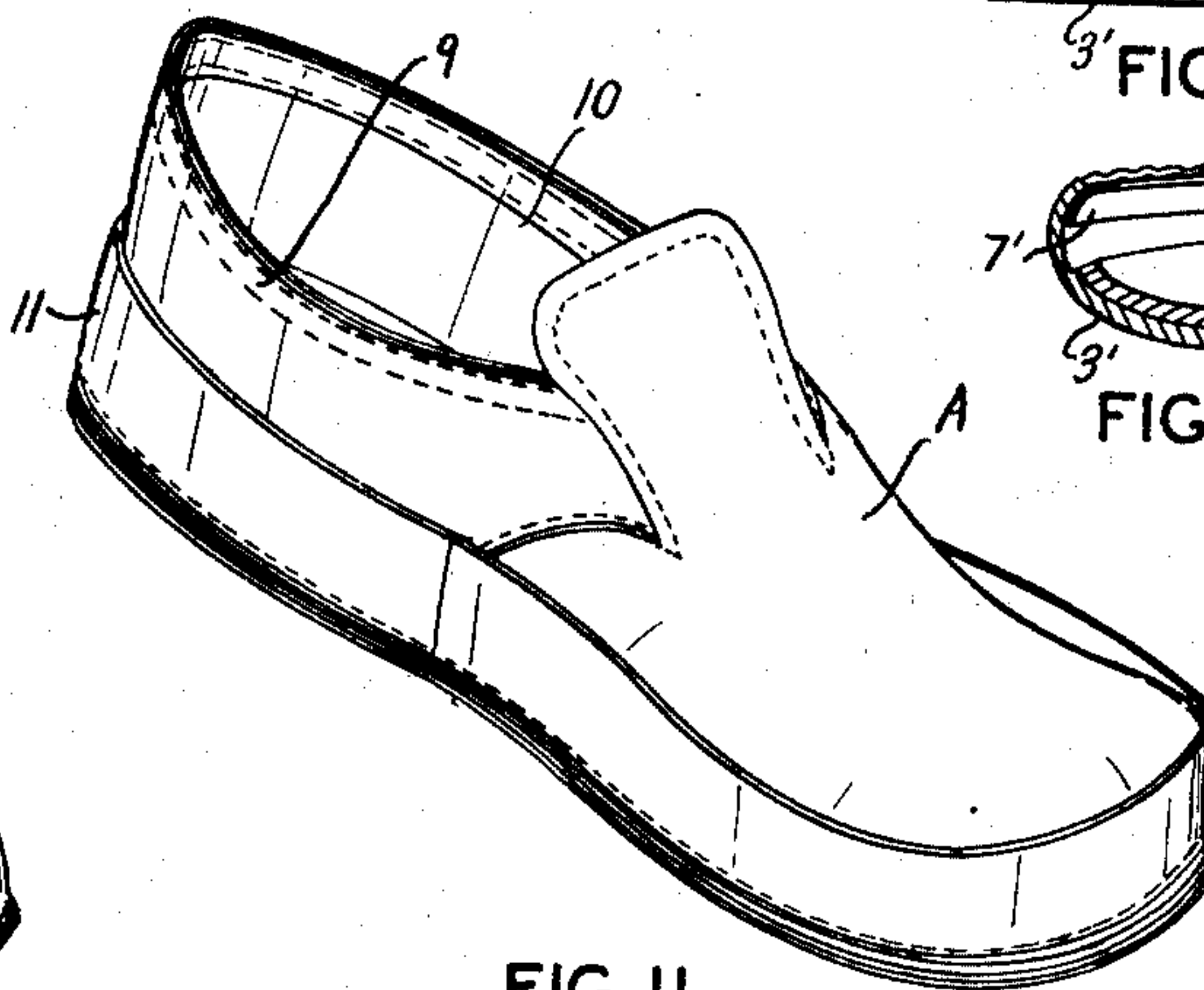


FIG. 11

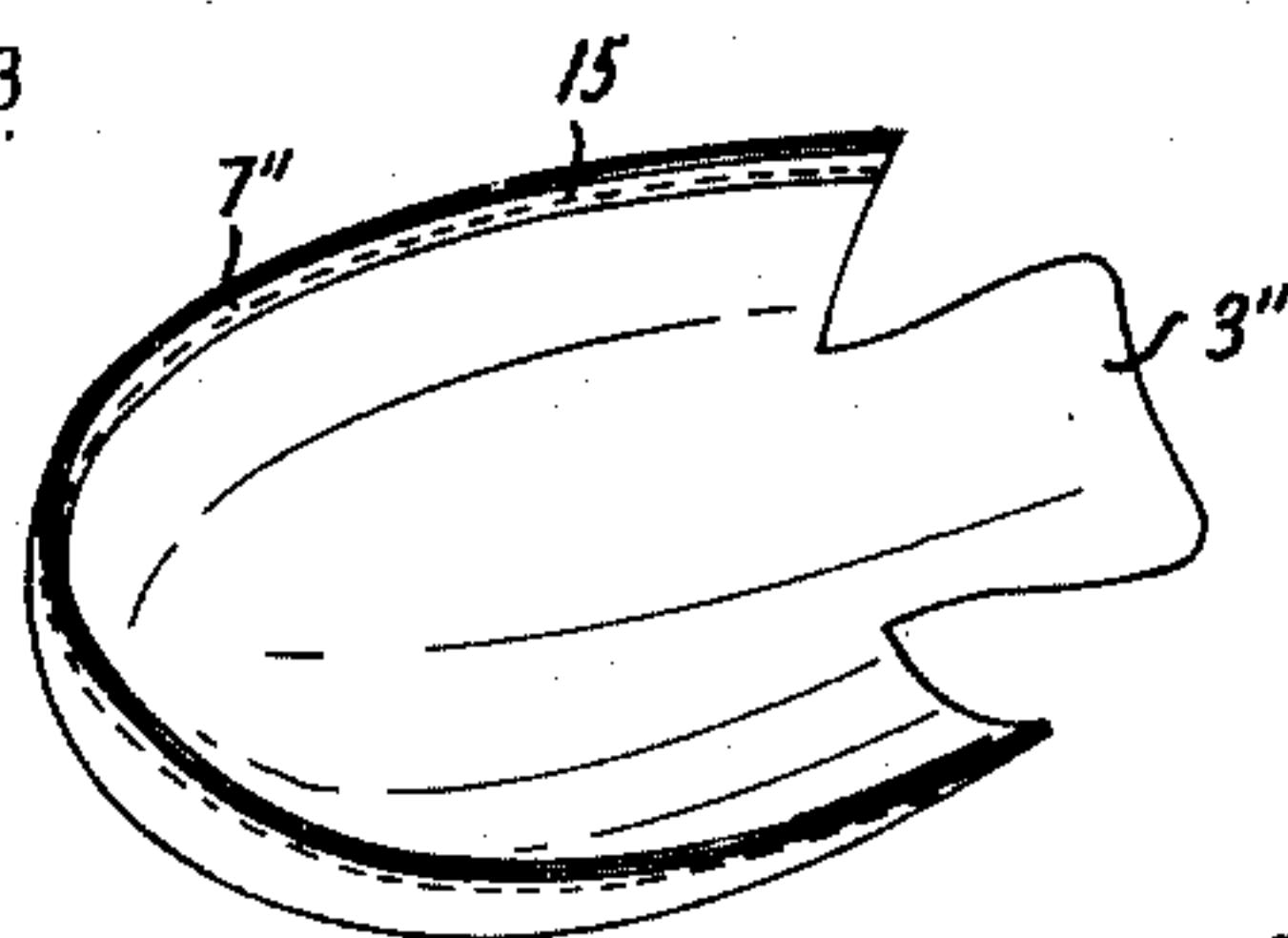


FIG. 17

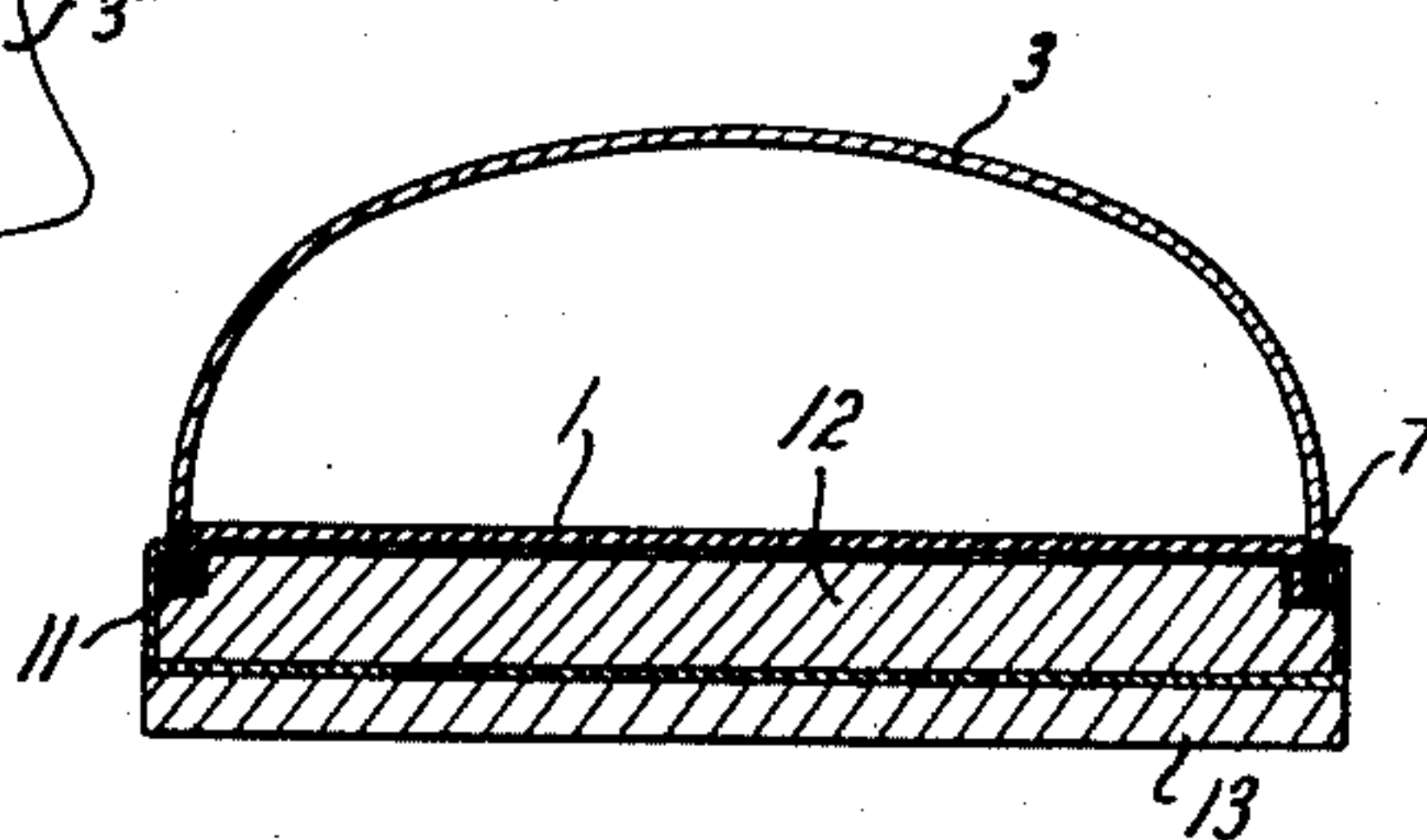


FIG. 13

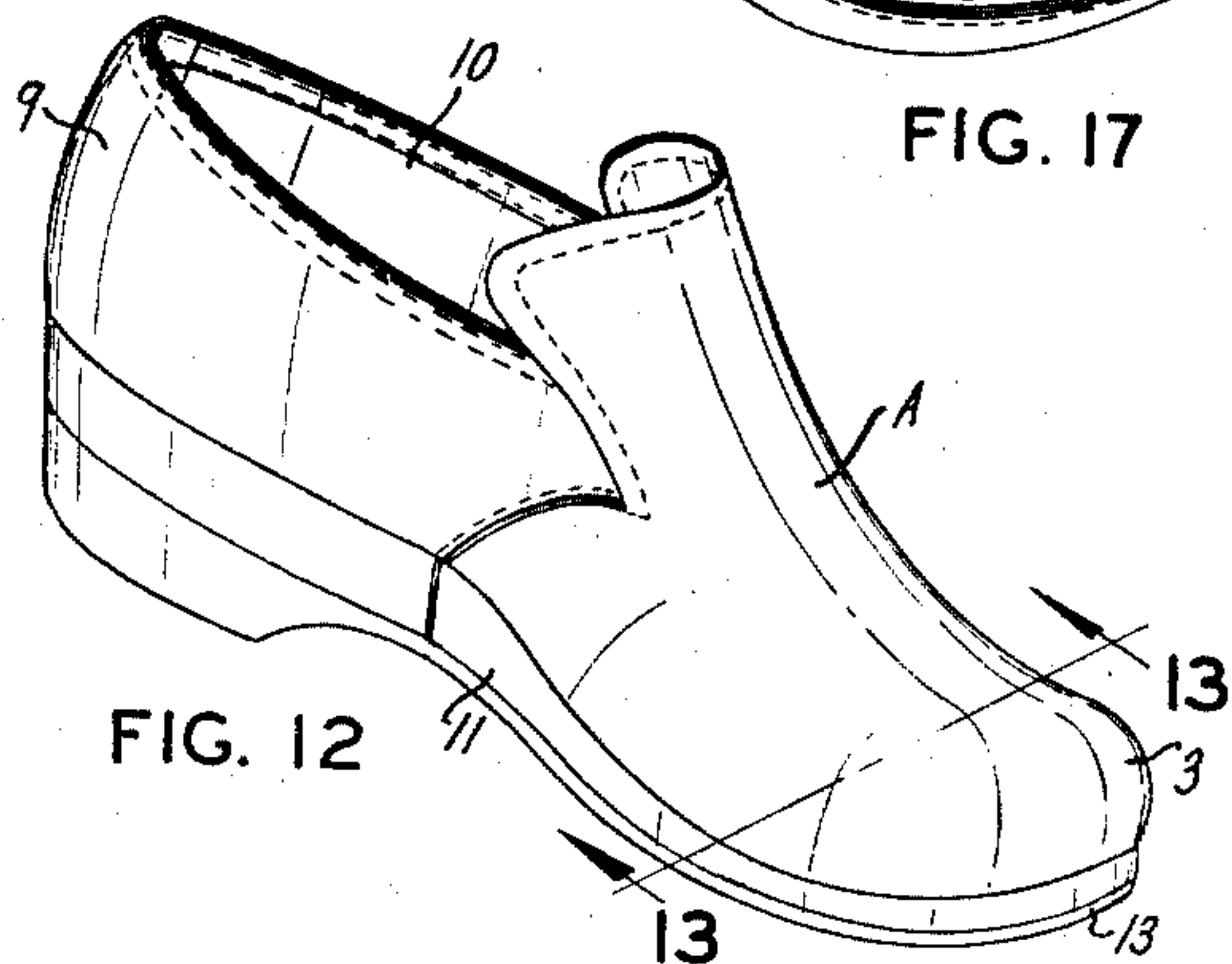


FIG. 12

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## UNITED STATES PATENT OFFICE

2,540,850

METHOD OF MAKING PREPARED VAMPS  
FOR INCORPORATION IN SLIP LASTED  
SHOES

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Application July 17, 1948, Serial No. 39,283

1 Claim. (Cl. 12—146)

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This invention relates in general to certain new and useful improvements in slip-lasted shoes and methods of making vamps for incorporation in slip-lasted shoes.

As has become well known in the shoe-making art, slip-lasted shoes are ordinarily made by marginally stitching the upper-forming members to a sock lining or insole and then slipping the assembly onto a last for application of the platform or sole, or both, as the case may be. Up to the present time, most slip-lasted shoes have been of the open toe and open heel variety because it is relatively simple and easy to adapt such types or styles to the slip-lasting process or method of construction. On the other hand, it has always been extremely difficult and costly to manufacture so-called closed toe shoes by slip-lasting methods because it is virtually impossible in most cases to stitch the vamp of a closed toe shoe to the sock lining or mid-sole cover in such a manner as to provide elevation around the extreme forward portion of the toe. In lasted shoes of conventional "pulled over" construction, the last provides the necessary elevation and in many cases the retention of this elevation is preserved by the insertion of a toe box into the shoe. In slip-lasted shoes, however, such expedients are inapplicable. Accordingly, numerous unsuccessful attempts have been made in recent years to provide a closed toe slip-lasted shoe, the toe of which is neatly arched or elevated in exactly the manner of the toe of a conventionally lasted shoe.

It is, therefore, the primary object of the present invention to provide a method of making slip-lasted shoes having a closed toe which is arcuately rounded and elevated to give the appearance and comfort of a conventionally lasted shoe.

It is a further object of the present invention to provide a slip-lasted shoe having a closed toe which is arcuately rounded and elevated to provide the comfort and appearance of a conventionally lasted shoe.

It is another object of the present invention to provide a simple, inexpensive method for making slip-lasted shoes of the closed toe type and with a toe construction rendering the shoe extremely comfortable, neat in appearance, and long wearing.

It is a further object of the present invention to provide a method for making closed toe slip-lasted shoes which is applicable to all types of upper materials and is not particularly limited to uppers made of leather.

With the above and other objects in view, my

2

invention resides in the novel features of form, construction, arrangement, and combination of parts presently described and pointed out in the claim.

5 In the accompanying drawings:

Figure 1 is a top plan view of a sock lining stamped out and marked in accordance with the present invention;

10 Figure 2 is a top plan view of a vamp member stamped and marked in accordance with the present invention;

15 Figure 3 is a schematic fragmentary view of the sock lining and vamp member arranged in superposed relation to illustrate the relationship of the guide marks thereon;

Figure 4 is an inverted plan view of the vamp member;

Figure 5 is a fragmentary sectional view taken along line 5—5 of Figure 4;

20 Figure 6 is a fragmentary inverted plan view of the vamp member showing a line of adhesive applied thereto;

Figures 7, 8, and 9 are perspective views of the vamp member in successive stages of completion;

25 Figure 10 is a perspective view showing the completed vamp member stitched to the sock lining;

Figure 11 is a perspective view of the completed upper prior to lasting;

30 Figure 12 is a perspective view of a completed slip-lasted shoe constructed in accordance with and embodying the present invention;

Figure 13 is a transverse sectional view taken along line 13—13 of Figure 12;

35 Figure 14 is an inverted plan view of a lined vamp member;

Figure 15 is a fragmentary sectional view taken along line 15—15 of Figure 14;

40 Figure 16 is a fragmentary sectional view of the lined vamp member after the toe elevating operation has been completed; and

Figure 17 is a further modified form of vamp member constructed in accordance with and embodying the present invention.

45 Referring now in more detail and by reference characters to the drawings, which illustrate practical embodiments of the present invention, 1 designates a sock lining die-cut or otherwise formed in any conventional manner from suitable leather stock or fabric, as may be desired. Around the toe portion, the sock lining 1 is provided upon its upper face with a series of short radially inwardly extending guide marks 2. Similarly die-cut or otherwise formed from suitable upper stock is a vamp member 3 also provided

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around its toe portion with a series of short radially inwardly extending guide marks 4.

By reference to the schematic view in Figure 3, it will be evident that each of the guide marks 2 corresponds to one of the guide marks 4 and it will be further noted that the distance or space between any two adjacent guide marks 2 is substantially smaller than the distance or spacing between the corresponding two guide marks 4. The vamp member 3 is turned upon its under or so-called flesh side and peripherally skived to provide a sharp cornered marginal channel 5, as best seen in Figures 4 and 5. This channel is then coated with a layer 6 of pressure sensitive adhesive, such as latex cement, and when the adhesive layer 6 has dried to the proper degree of tackiness, a narrow ribbon-like strip of elastic tape 7 is stretched or placed under tension and pressed into the channel 5, being held securely therein by means of the adhesive 6. As this operation is being carried out, the stretching tension of the already cemented portion of the strip 7 will, of course, be released and the tape will contract, pulling a uniformly distributed series of very slight puckers into the peripheral edge of the upper, and, when the strip 7 has been completely laid into the channel 5, the upper will be uniformly puckered along the entire length of the channel 5 and drawn into a symmetrical cupped shape, substantially as shown in Figures 8 and 9. It should be noted in this connection that the degree of tension applied to the strip 7 and the resilient elongation thereof as it is being inserted in the channel 5 will depend to some degree upon the strength of the elastic material used therein, the thickness of the upper stock used in making the vamp member 3, and the depth to which the vamp member 3 is skived in forming the channel 5. By taking such factors into account, however, the strip of elastic 7 should be selected both as to strength and length, so that, when said strip has been affixed to the vamp member 3 within the channel 5, it will draw up and cup the vamp member 3 to such a degree that its peripheral length in the region of the guide marks 4 will be reduced to match almost exactly the corresponding peripheral length of the sock lining 1, so that the guide marks 4 will line up each with its corresponding guide mark 2 and the intervening extra distance therebetween will have been taken up in puckers.

The vamp member 3 thus cupped is then superimposed upon the sock lining 1 with the guide marks 4 and 2 thereof respectively aligned. The vamp member 3 and sock lining 1 are then marginally stitched by a line of stitches 8, as shown in Figure 10. The quarter members 9, 10, and platform cover or wrapper 11 are then stitched in place by conventional methods to form a completed upper A, as shown in Figure 11.

The wood last is thereupon slipped into the completed upper A and the shoe conventionally finished by the installation of a platform member 12 and an outer sole 13 to form a finished shoe, as shown in Figures 12 and 13. As will be seen by reference to Figure 13, when the platform cover or wrapper 11 is pulled over and cemented down upon the platform 12, the peripheral seam between the outsole 13, the vamp member 3, and the platform cover 11 will be pulled down into more or less vertical position and forced to press

itself into the more or less spongy resilient material of the platform 12, imparting to the interior of the shoe a comfortable level contour and providing in the forward portion of the toe a hitherto unattainable degree of elevation and roundness, which is both more comfortable on the foot and artistic in appearance.

If desired, the present invention may be applied to the manufacture of lined vamp members, in which case a vamp member 3' is cut out substantially in the same manner as the previously described vamp member 3 and a peripherally registering section of lining 14 is adhesively secured thereto. The lined vamp member 3' is then peripherally skived in the same manner heretofore described to provide a channel 5', as shown in Figure 15. It should be noted that the peripheral margin of the lining 14 is coincident with the inner shoulder line of the channel 5'. The channel 5' is similarly coated with latex cement or other similar pressure sensitive adhesive and a section of elastic tape 7', substantially similar to the previously described section of elastic tape 7, is inserted under tension in the channel 5' in the same manner as previously described, drawing the lined vamp member 3' into a series of small peripheral puckers and causing it to cup, as shown in Figure 16.

It is also possible to provide a modified form of vamp member 3'', as shown in Figure 17, which is substantially identical with the previously described vamp member 3, except that it is provided with a section of elastic tape 7'' which is secured in place by means of a line of stitches 15 rather than by latex cement. Any other equivalent means for securement of the tape 7'' may, of course, be employed.

It should be understood that changes and modifications in the form, construction, arrangement, and combination of the several parts of the shoe and in the steps of its production may be made and substituted for those herein shown and described without departing from the nature and principle of my invention.

Having thus described my invention, what I claim and desire to secure by Letters Patent is:

The method of making a prepared vamp for lasting which method comprises forming a vamp member having a peripheral toe portion of substantially greater length than the corresponding length of the toe portion of the sock lining of a shoe in which it is designed to be incorporated, lining the inner face of the vamp member, turning the vamp member upon its under face, skiving the turned under face of the peripheral toe portion of the lined vamp member, stitching an elastic member under tension within the skived portion of the vamp member, and releasing the elastic member and thereby causing the vamp member to cup at the toe.

JOHN J. WALSH.

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The following references are of record in the file of this patent:

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