



(12) **EUROPEAN PATENT APPLICATION**
published in accordance with Art. 153(4) EPC

(43) Date of publication:
20.02.2013 Bulletin 2013/08

(51) Int Cl.:
A43B 9/12 (2006.01) A43B 7/12 (2006.01)

(21) Application number: **10843782.3**

(86) International application number:
PCT/ES2010/070713

(22) Date of filing: **04.11.2010**

(87) International publication number:
WO 2011/089286 (28.07.2011 Gazette 2011/30)

(84) Designated Contracting States:
AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

(72) Inventor: **GUIRADO MARTINEZ, Jorge**
E-07300 Inca (Balears) (ES)

(30) Priority: **19.01.2010 ES 201030056**

(74) Representative: **Temino Cenicerros, Ignacio**
Calle Amador de los Rios 1-1°
28010 Madrid (ES)

(71) Applicant: **Camper, S.L.**
07300 Inca (Balears) (ES)

(54) **FOOTWEAR PRODUCTION METHOD**

(57) Shoe making procedure that is characterized in that it includes at least the stages of stitching the insole to build the internal cover (1) of the list, where said stitching (2) is executed outward; a second stage of gluing the

sole (4) to the insert, base of the shoe's internal cover (1); and a third stage of gluing the perimeter flange of the sole (4) to the shoe's outer upper material (3) in an outward direction.

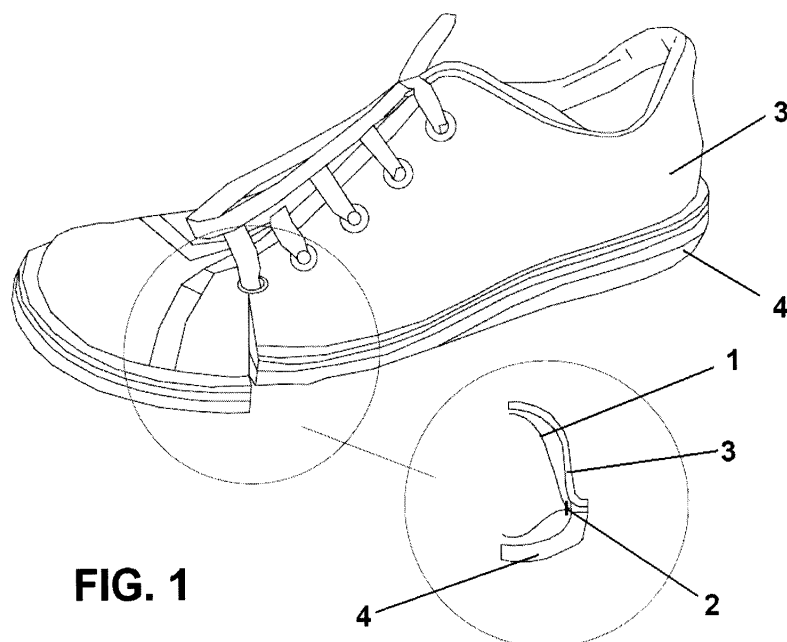


FIG. 1

Description

[0001] The purpose of this invention is a procedure for making shoes, which by combining the characteristics of two known shoe making methods, such as the "strobel" method and the "stitch down" method, an improved look and waterproofing of the shoe is obtained.

PRIOR STATE OF THE ART

[0002] Different types of shoe making processes are known and two of these methods are known as the "strobel" method and the second one is called the "stitch down" method.

[0003] The "strobel" method essentially consists of creating a cover or "sock" by stitching an insole in zigzag to the upper material. Assemble it in a last and glue it to a sole. Then, an insert is installed that covers up the "strobel" stitch.

[0004] With this method, a high flexibility is achieved, it is lighter, uses fewer components and fewer raw materials. However, the modelling depends on each specific model and the soles must have a minimum amount of shell.

[0005] The shoe making method known as "stitch down" essentially consists of fastening the insole to the last insert to subsequently tighten the upper material over the last, glue the sole and stitch the sole with the stitches facing outward and therefore visible, creating an aesthetic effect that is not very adequate for many types of shoes. However, the greatest problem encountered with this manufacturing method stems from its lack of water-proofing.

DESCRIPTION OF THE INVENTION

[0006] To prevent the aforementioned problems, below we provide a description of the new shoe making procedure, which by combining characteristics of the "strobel" and "Stitch down" manufacturing methods allows obtaining a shoe with water-proofing properties and an appropriate aesthetic, where the presence of the external stitch is eliminated even though the gluing of the upper material to the sole is maintained on its external part and also, the internal zigzag stitch of the sole, which is characteristic of the "strobel" method has been eliminated.

[0007] To obtain these favourable effects, the shoe making procedure includes at least the following stages:

- (a) a first stage of stitching the insole to build the internal cover of the upper material, and where this stitching is executed outward;
- (b) a second stage of gluing the sole to the insert, base of the shoe's internal cover; and
- (c) a third stage of gluing the perimeter flange of the sole to the shoe's outer upper material in an outward direction.

[0008] In other words, using the described procedure, on one hand we prevent the zigzag stitches inside the shoe from being visible and on the other hand, we avoid the outer stitch of the sole, obtaining an important aesthetic effect. Also, with the proper materials in the cover; in other words, making the cover water-proof and transpirable and, because the joint between the upper material and the sole is sealed, the shoe is made impermeable.

[0009] The cover is glued to the inside part of the upper material, creating a sort of sock in the last, so that it can be subsequently glued to the sole.

[0010] Throughout the description and claims, the word "encompasses" and its synonyms do not intend to exclude other technical characteristics, additions, components or steps. For experts in the field, other objectives, advantages and characteristics of this invention will in part be derived from the description and in part from placing the invention into practice. The following examples and drawings provide an illustration and are not intended to limit this invention. Additionally, this invention covers all the possible combinations of particular and preferred embodiments indicated herein.

BRIEF DESCRIPTION OF THE DRAWINGS

[0011]

FIG1. Shows a view of a shoe made using the manufacturing method described in this invention along with a detailed view of a last section of the shoe.

DETAILED DESCRIPTION OF THE APPLICATION METHODS

[0012] As can be seen in the attached figure, the shoe list includes an interior cover (1) stitched in such a manner that the stitch (2) is oriented outside the shoe, preventing it from being seen internally and also preventing in this manner if desired, the presence of an insert.

[0013] This cover is glued to the body (3) of the shoe as well as to the sole (4) itself and they are joined together by externally gluing both elements; in other words, a perimeter flange exists, which in a preferred embodiment of this invention will be sealed, in a manner that in combination with the internal impermeable and transparent cover (1), the shoe will also be impermeable.

[0014] Therefore, in a particular embodiment of this invention, the shoe making procedure includes a first stage for stitching the insole to build the internal cover of the list, where said stitching is executed outward. The list will include the interior cover (1), which is joined to the list. In a subsequent stage, the sole (4) is glued to the insole, base of the interior cover (1) of the shoe, while in a final stage, the perimeter flange of the sole (4) is glued to the outer list (3) of the shoe.

Claims

1. Shoe making procedure **characterized in that** it includes at least the following stages:

5

- (a) a first stage of stitching the insole to build the internal cover (1) of the upper material, and where this stitching (2) is executed outward;
- (b) a second stage of gluing the sole (4) to the insert, base of the shoe's internal cover (1); and
- (c) a third stage of gluing the perimeter flange of the sole (4) to the shoe's outer upper material (3) in an outward direction.

10

2. Shoe making procedure in accordance with claim 1 **characterized in that** the gluing of the sole is executed outside the shoe, creating a perimeter flange, which will be sealed, in a manner that in combination with the internal impermeable and transpirable cover (1), the shoe will also be impermeable.

15

20

3. Shoe **characterized in that** it has been manufactured using the procedures described in claims 1 and 2.

25

30

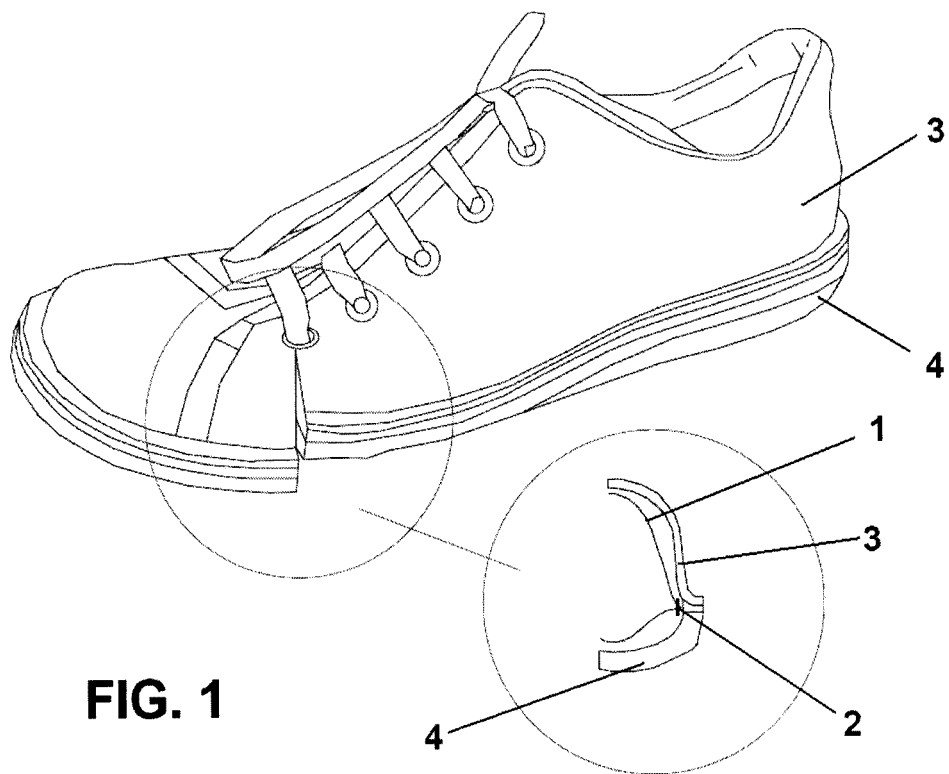
35

40

45

50

55



INTERNATIONAL SEARCH REPORT

International application No.

PCT/ES2010/070713

A. CLASSIFICATION OF SUBJECT MATTER

A43B9/12 (2006.01)

A43B7/12 (2006.01)

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

A43B+, A43B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPODOC, INVENES, WPI

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	EP 1300091 A1 (CALZATURIFICIO ORION S P A) 09/04/2003, description: paragraphs[15-17, 22-23]; figures.	1-3
A	ES 2287655 T3 (WOLVERINE WORLD WIDE INC) 16/12/2007, description: column 2, lines 21 - 24; column 3, line 18-21; lines 54-64; column 4, line 30-33; column 5, line 31-34, lines 48-61; column 6, lines 33 - 39; figures.	1-3
A	ES 2250135 T3 (GORE W L & ASS GMBH) 16/04/2006, description; column 5, line 5-14; column 10, line 4-10; column 12, line 16 - column 13, line 30; figures.	1-3

☒ Further documents are listed in the continuation of Box C.☒ See patent family annex.

* Special categories of cited documents:	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"A" document defining the general state of the art which is not considered to be of particular relevance.	
"E" earlier document but published on or after the international filing date	
"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"O" document referring to an oral disclosure use, exhibition, or other means.	"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other documents , such combination being obvious to a person skilled in the art
"P" document published prior to the international filing date but later than the priority date claimed	"&" document member of the same patent family

Date of the actual completion of the international search
04/04/2011Date of mailing of the international search report
(19/04/2011)

Name and mailing address of the ISA/

OFICINA ESPAÑOLA DE PATENTES Y MARCAS
Paseo de la Castellana, 75 - 28071 Madrid (España)
Facsimile No.: 91 349 53 04Authorized officer
E. Pértica Gómez

Telephone No. 91 3493271

Form PCT/ISA/210 (second sheet) (July 2009)

INTERNATIONAL SEARCH REPORT

International application No.
PCT/ES2010/070713

C (continuation).		DOCUMENTS CONSIDERED TO BE RELEVANT
Category *	Citation of documents, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	ES 2240591 T3 (SYMPATEX TECHNOLOGIES GMBH) 16/10/2005, description: column 1, line 31-44, column 1, line 56 - column 2, line 43; claim 1, figures.	1-3
A	ES 2215553 T3 (SYMPATEX TECHNOLOGIES GMBH) 16/10/2004, description; column 1, line 3-10; column 2, line 57 - column 3, line 27; figures.	1-3
A	US 2003029058 A1 (LIN MIN-CHOU) 13/02/2003, description; paragraphs[7, 23, 27] figures.	1-3
A	US 5285546 A (HAIMERL FRANZ) 15/02/1994, description; column 7, line 52 - column 8, line 35; column 9, line 66 - column 10, line 6; figure 5,	1-3

Form PCT/ISA/210 (continuation of second sheet) (July 2009)

EP 2 559 349 A1

INTERNATIONAL SEARCH REPORT

International application No.

PCT/ES2010/070713

Information on patent family members

Patent document cited in the search report	Publication date	Patent family member(s)	Publication date
EP1300091 AB	09.04.2003	EP20010830630 AT326151 T DE60119737 T	05.10.2001 15.06.2006 26.04.2007
-----	-----	-----	-----
ES2287655 T	16.12.2007	CA2476157 AC CA2476155 AC EP1502517 A EP20040254590 EP1502516 AB EP20040254540 US2005022429 A US7096602 B US2005022425 A US7010867 B US2005086836 A US7076889 B CL19522004 A US2006265908 A AT367104 T HK1074356 A DE602004007588 T	31.01.2005 31.01.2005 02.02.2005 30.07.2004 02.02.2005 29.07.2004 03.02.2005 29.08.2006 03.02.2005 14.03.2006 28.04.2005 18.07.2006 06.05.2005 30.11.2006 15.08.2007 07.12.2007 20.03.2008
-----	-----	-----	-----
ES2250135 T	16.04.2006	WO0112002 A AU4918000 A DE19938139 A EP1202643 AB EP20000931139 JP2003506176 T AT311779 T DK1202643 T SI1202643 T US7219446 B	22.02.2001 13.03.2001 26.04.2001 08.05.2002 08.05.2000 18.02.2003 15.12.2005 27.12.2005 30.06.2006 22.05.2007
-----	-----	-----	-----
ES2240591 T	16.10.2005	EP1340434 AB EP20020004707 US2003163880 A US6823551 B CN1442099 A CN100528021 C AT298211 T	03.09.2003 01.03.2002 04.09.2003 30.11.2004 17.09.2003 19.08.2009 15.07.2005
-----	-----	-----	-----
ES2215553 T	16.10.2004	EP1216627 AB EP20000127682 US2002078593 A US6769201 B	26.06.2002 18.12.2000 27.06.2002 03.08.2004
-----	-----	-----	-----
US2003029058 A	13.02.2003	JP2003052408 A TW563440 U	25.02.2003 21.11.2003
-----	-----	-----	-----
US5285546 A	15.02.1994	DE3840087 A	31.05.1990

Form PCT/ISA/210 (patent family annex) (July 2009)

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No.

PCT/ES2010/070713

Patent document cited in the search report	Publication date	Patent family member(s)	Publication date
		WO9006067 A	14.06.1990
		EP0445198 AB	11.09.1991
		EP19900900132	28.11.1989
		AT81753 T	15.11.1992
-----	-----	-----	-----

Form PCT/ISA/210 (patent family annex) (July 2009)