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(72) Inventor: **GUIRADO MARTINEZ, Jorge**
E-07300 Inca (Baleares) (ES)(30) Priority: **19.01.2010 ES 201030056**(74) Representative: **Temino Ceniceros, Ignacio**
Calle Amador de los Rios 1-1°
28010 Madrid (ES)

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

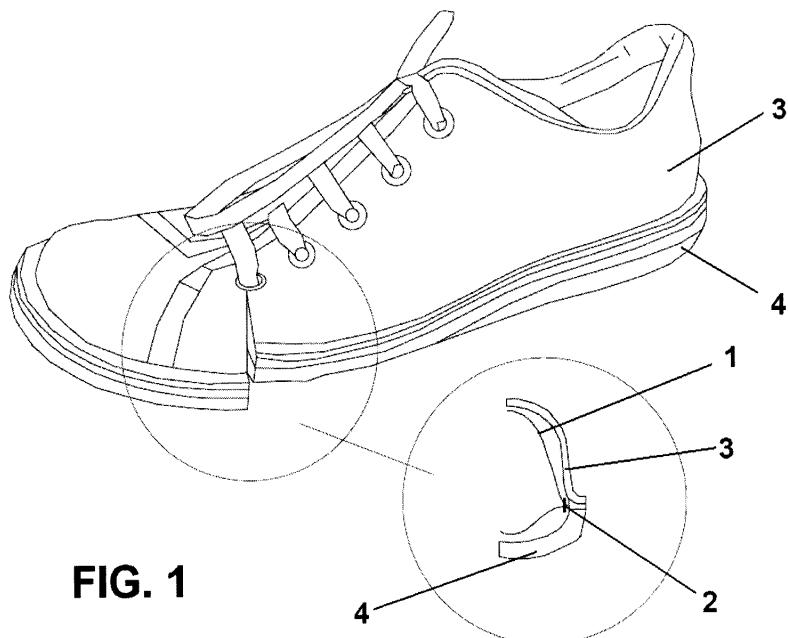


FIG. 1

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.

25 BRIEF DESCRIPTION OF THE DRAWINGS

[0011]

30 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

35 [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:

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(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.

2. Shoe making procedure in accordance with claim 1 15
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. 20

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

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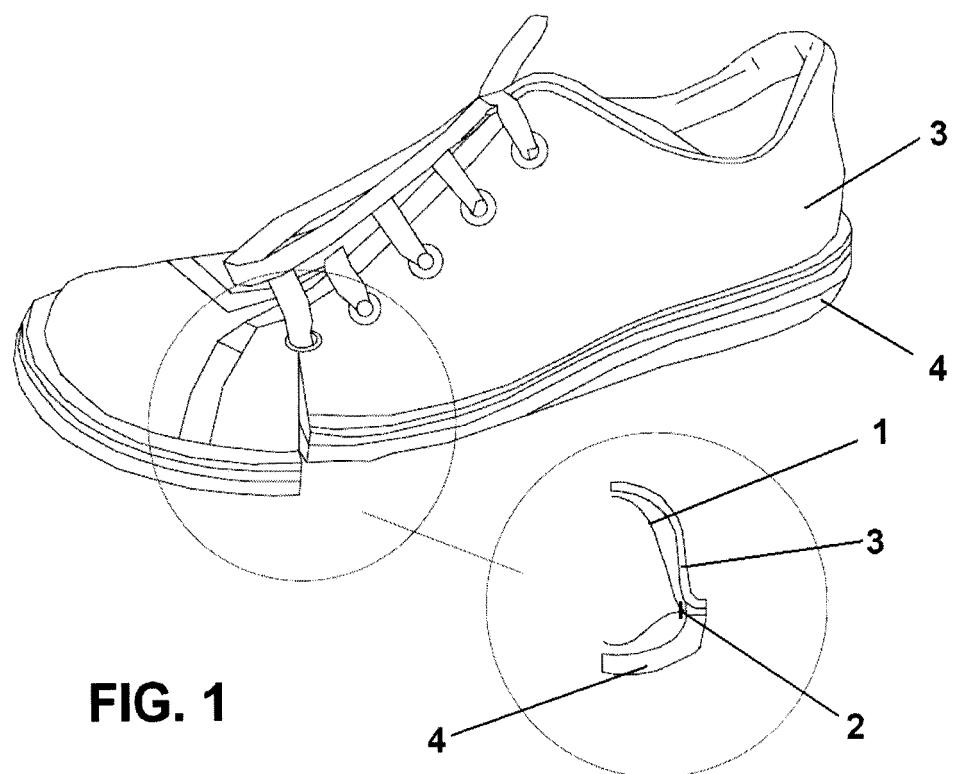


FIG. 1

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)
"O"		document referring to an oral disclosure use, exhibition, or other means.
"P"		document published prior to the international filing date but later than the priority date claimed
	"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
	"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
	"&"	document member of the same patent family

Date of the actual completion of the international search
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(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

INTERNATIONAL SEARCH REPORT

International application No.
PCT/ES2010/070713

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

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