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(54) **INTEGRAL SHOE AND METHOD FOR THE PRODUCTION THEREOF**

(57) Integral shoe and method for manufacture thereof. Integral shoe, comprising an upper shoe (3) with an underside (3A) and an upper edge (3B); a first stocking part of fabric, knit or weave in which the upper shoe (3) is accommodated and which extends from the underside (3A) of the upper shoe (3) to the upper edge (3B) of the upper shoe (3); a second stocking part of fabric, knit or weave which extends from the upper edge (3B) of the upper shoe (3)

away from the first stocking part; a support (4) arranged on the underside (3A) of the upper shoe (3); a primary attaching means provided between the upper shoe (3) and the support (4) in order to attach the first stocking part to the upper shoe (3); and a secondary attaching means provided at the position of the upper edge (3B) of the upper shoe (3) in order to connect the first and the second stocking part to the upper shoe (3).



FIG. 1

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Description

[0001] The present invention relates to an integral shoe with an upper shoe and two stocking parts, and to a method for manufacturing such integral shoes.

[0002] Integral shoes are footwear wherein lower leg covering and upper shoe are integrated in that the stocking continues on around the upper shoe, or at least creates that impression. In known integral shoes the stocking consists of material which is stiff rather than flexible. Because of such a stiffness the material can be sufficiently strong per se that a user can pull thereon in order to put the integral shoe on. However, the use of such a stiff material impairs the appearance of the integral shoe because determined material choices are precluded and because the stiff material makes it more difficult for the stocking to be worn otherwise than extending along the lower leg.

[0003] An object of the present invention is to provide an integral shoe which does not have these drawbacks.

[0004] Provided for this purpose in a first embodiment of an integral shoe are: an upper shoe with an underside and an upper edge; a first stocking part manufactured from fabric, knit or weave in which the upper shoe is accommodated and which extends from the underside of the upper shoe to the upper edge of the upper shoe; a second stocking part manufactured from fabric, knit or weave, which second stocking part extends from the upper edge of the upper shoe away from the first stocking part; a support arranged on the underside of the upper shoe; a primary attaching means provided between the upper shoe and the support in order to attach the first stocking part to the upper shoe; and a secondary attaching means provided at the position of the upper edge of the upper shoe in order to connect the first and the second stocking part to the upper shoe.

[0005] It is also possible in this way to opt for fabrics, knits or weaves so as to nevertheless provide a stocking (with two parts) which can be integrated sufficiently strongly with the upper shoe to form an integral shoe. This extends the choice of material to rather flexible materials such as lace, which can also be worn in other manner than rather stiff materials such as thick cotton. Because the fabric, knit or weave is flexible, the stocking or at least a part thereof must be secured sufficiently firmly to the upper shoe. The primary and secondary attaching means provide herefor, whereby respectively the first stocking part is attached firmly between the underside of the upper shoe and the support, so that this first stocking part does not detach, and the first and second stocking parts are connected firmly to the upper edge of the upper shoe so that they do not detach and/or can shift only to a small extent.

[0006] According to a preferred embodiment, the first stocking part and the second stocking part are manufactured from the same piece of fabric, knit or weave.

[0007] The integral shoe is in this way not impaired by a conspicuous stitched seam or the like at the position

of the upper edge of the upper shoe where the first stocking part and the second stocking part must otherwise each be connected. Also thus avoided in some embodiments is that the appearance of the first stocking part contrasts sharply with the appearance of the second stocking part.

[0008] According to another preferred embodiment, at least one stocking part of the first stocking part and the second stocking part is manufactured from an openwork fabric, an openwork knit or an openwork weave. Both the first stocking part and the second stocking part are preferably manufactured from an openwork fabric, an openwork knit or an openwork weave. Because the fabric, knit or weave is openwork, it is flexible so that the attachment or connection with the respective attaching means imparts strength to the respective stocking part or the respective stocking parts.

[0009] According to another embodiment, at least one stocking part of the first stocking part and the second stocking part is manufactured from a material chosen from: lace, jersey, fabric á jour, perforated alcantara and perforated stretchable leather. The at least one stocking part is preferably manufactured from lace.

[0010] According to a further developed embodiment, the fabric, knit or weave is provided with a pattern.

[0011] According to a preferred embodiment, the fabric, knit or weave has meshes of a first size and meshes of a second size, and the first size and the second size differ from each other.

[0012] According to another embodiment, the underside of the upper shoe comprises a sole. The sole can be single-layered or preferably multilayered, and can for instance comprise a cardboard layer, a plastic layer and/or a cork layer, can comprise a leather layer or a plurality of leather layers, can comprise a shock-absorbing layer. When the lower edge of an upper shoe shoe piece form is folded back, it thus forms at least a portion of the underside of the upper shoe. This underside can otherwise be formed by, among others, a mid-sole of for instance cardboard, plastic or cork, on which further layers (for instance of leather) can rest. Another single-layered or multilayered part of for instance plastic can if desired also be arranged between the underside of the upper shoe and the (actual) support.

[0013] According to a further developed embodiment, the support has a heel. This heel can be a wedge heel or a short heel (e.g. a kitten heel), a high heel (so that the upper shoe with the support together have the appearance of a pump) or a spike heel (such as a stiletto heel). According to other embodiments the support is flat, with or without a platform.

[0014] According to another embodiment, the support is covered with a natural material such as cork, leather, jute or fabric.

[0015] According to a preferred embodiment, the primary attaching means comprises at least one of the following attaching means: staples, wire nails, adhesive, stitching, tensioning clamps or a combination of two or

more of these attaching means.

[0016] According to another preferred embodiment, the secondary attaching means comprises at least one of the following attaching means: stitching, adhesive or a combination of these attaching means. According to another embodiment, a strengthening band is provided on the second stocking part, which strengthening band extends from at least the secondary attaching means, and which strengthening band serves to strengthen the second stocking part when the second stocking part is pulled. The strengthening band preferably extends along a stitched seam of the second stocking part in order to provide better strengthening thereof and to provide a more attractive appearance.

[0017] According to a further developed embodiment, the strengthening band is likewise provided on the first stocking part for strengthening thereof, and preferably extends from the primary attaching means. The strengthening band can in this case be incorporated either within the upper shoe or into the periphery of the upper shoe, or be arranged on the outside thereof, for instance with stitching, in accordance with the desired appearance of the integral shoe.

[0018] According to a further developed embodiment, a stocking hold-up means is provided on the second stocking part in order to at least partially hold up the second stocking part on a leg of a wearer in a situation of use, and the stocking hold-up means is preferably provided in the vicinity or at the position of an upper edge of the second stocking part. Such a stocking hold-up means can be embodied as an elastic band with a width which is sufficiently great that the elastic band does not give the sensation of cutting into a wearer, for instance at least 0.5 cm, preferably at least 1 cm, more preferably at least 1.5 cm. Such a stocking hold-up means can for instance also further be embodied as a plastic band which is preferably manufactured from rubber or silicones and which is configured to cling to the leg of a wearer through adhesion so as to thus at least partially hold up and prevent the second stocking part slipping down in a situation of use.

[0019] According to a preferred embodiment, the second stocking part is manufactured from one piece of fabric, knit or weave which is stitched so as to form a tubular lower leg covering.

[0020] At least one opening is preferably provided in a periphery of the upper shoe between the underside and the upper edge, for instance to leave clear the toes of a foot or to provide a better ventilation to the side of the foot or to provide an upper shoe of less heavy appearance. At least one corresponding opening is then preferably provided in the first stocking part. A tertiary attachment means is then preferably provided at the position of an edge of the at least one opening in order to attach the stocking to the upper shoe. The tertiary attachment means then preferably comprises at least one of the following attaching means: adhesive, stitching or a combination of these attaching means.

[0021] Provided in order to achieve one or more of the stated objects in a first embodiment of a method for manufacturing an integral shoe are: manufacturing an upper shoe with an underside and an upper edge on a last; arranging a first stocking part manufactured from fabric, knit or weave on the upper shoe, which first stocking part at least substantially corresponds to an outer periphery of the upper shoe from the underside of the upper shoe to the upper edge of the upper shoe such that the upper shoe can be accommodated in the first stocking part; attaching the first stocking part to the underside of the upper shoe using a primary attaching means; connecting respectively the first stocking part and a second stocking part which is manufactured from fabric, knit or weave to the upper shoe at the position of the upper edge of the upper shoe using a secondary attaching means, and which second stocking part is embodied in a manner such as to at least partially accommodate a lower leg; and arranging a support on the underside of the upper shoe. The first stocking part and the second stocking part are connected to the upper shoe in the sense that the fabric, knit or weave from which they are respectively manufactured is held in place by the secondary attaching means.

[0022] According to another embodiment, the first stocking part and the second stocking part are manufactured from the same piece of fabric, knit or weave.

[0023] According to another preferred embodiment, at least one stocking part of the first stocking part and the second stocking part is manufactured from an openwork fabric, an openwork knit or an openwork weave. Both the first stocking part and the second stocking part are preferably manufactured from an openwork fabric, an openwork knit or an openwork weave. Because the fabric, knit or weave is openwork, it is flexible so that the attachment or connection with the respective attaching means imparts strength to the respective stocking part or the respective stocking parts.

[0024] According to a preferred embodiment, at least one stocking part of the first stocking part and the second stocking part is manufactured from a material chosen from: lace, jersey, fabric à jour, perforated alcantara and perforated stretchable leather. The at least one stocking part is preferably manufactured from lace.

[0025] According to a further developed embodiment, the fabric, knit or weave is provided with a pattern.

[0026] According to another embodiment, the fabric, knit or weave has meshes of a first size and meshes of a second size, and the first size and the second size differ from each other.

[0027] According to a preferred embodiment, manufacture of the upper shoe moreover comprises of: cutting out an upper shoe piece form with a lower edge and an upper edge, which upper shoe piece form is preferably manufactured from leather; optionally stitching the upper shoe piece form on a heel side thereof; arranging the upper shoe piece form around the last, wherein the lower edge of the upper shoe piece form is folded round the last in order to form at least a portion of the underside of

the upper shoe, and wherein the upper edge of the upper shoe piece form forms the upper edge of the upper shoe. Following arrangement of the support, the method further comprises here of: removing the last; and following removal of the last the method further comprises here of: arranging an inner sole.

[0028] According to another embodiment, the method moreover comprises of: cutting to size a piece of fabric, knit or weave; and stitching the piece of fabric, knit or weave in order to form the first and/or second stocking part.

[0029] According to a preferred embodiment, the method comprises of arranging a strengthening band on the second stocking part from at least the secondary attaching means, which strengthening band serves to strengthen the second stocking part when the second stocking part is pulled. The strengthening band preferably extends along a stitched seam of the second stocking part in order to provide better strengthening thereof and to provide a more attractive appearance. The strengthening band is preferably arranged on an outer side of the second stocking part and the second stocking part is subsequently turned inside out so that the strengthening band comes to lie on an inner side of the second stocking part.

[0030] According to a further developed embodiment, the strengthening band is likewise arranged on the first stocking part for strengthening thereof, and preferably extends from the primary attaching means. The strengthening band can in this case be incorporated either within the upper shoe or into the periphery of the upper shoe, or be arranged on the outside thereof, for instance with stitching, in accordance with the desired appearance of the integral shoe.

[0031] According to another preferred embodiment, the method comprises of arranging a stocking hold-up means on the second stocking part in order to at least partially hold-up the second stocking part on a leg of a wearer in a situation of use, and wherein the stocking hold-up means is preferably arranged in the vicinity or at the position of an upper edge of the second stocking part.

[0032] According to a further developed embodiment, the support is arranged on the underside of the upper shoe such that the primary attaching means is received between the support and the upper shoe. The support is optionally covered with a natural material such as cork, leather, jute or fabric.

[0033] According to another further developed embodiment, the method comprises of arranging an outsole on at least one underside of the support.

[0034] According to another embodiment, the primary attaching means comprises at least one of the following attaching means: staples, wire nails, adhesive, stitching, tensioning clamps or a combination of two or more of these attaching means.

[0035] According to a further developed embodiment, the secondary attaching means comprises at least one of the following attaching means: stitching, adhesive or

a combination of two or more of these attaching means.

[0036] The invention will be further described on the basis of a number of by no means limitative exemplary embodiments of an integral shoe according to the present invention with reference to the accompanying drawings, in which:

Figure 1 is a partial side view of an embodiment of an integral shoe according to the invention;
 Figure 2 is a partial side view of another embodiment of an integral shoe according to the invention;
 Figure 3 is a partial rear view of an embodiment of an integral shoe according to the invention;
 Figure 4 is a partial rear view of another embodiment of an integral shoe according to the invention;
 Figure 5 is a side view of an embodiment of an integral shoe according to the invention;
 Figures 6A-B show examples of performing a step of an embodiment of a method for manufacturing an integral shoe according to the invention;
 Figures 7A-B show examples of performing another step of an embodiment of a method for manufacturing an integral shoe according to the invention;
 Figures 8A-C show examples of performing another step of an embodiment of a method for manufacturing an integral shoe according to the invention;
 Figure 9 shows an example of performing another step of an embodiment of a method for manufacturing an integral shoe according to the invention; and
 Figure 10 shows an example of performing another step of an embodiment of a method for manufacturing an integral shoe according to the invention.

[0037] For the sake of clarity several terms used below are further explained here. The word 'stocking' is understood to mean 'an article of clothing for foot and/or lower leg'. The word 'fabric' is understood to mean 'a piece of material (textile) manufactured by interlacing threads'. Examples of fabrics are lace, crochet work (fabric manufactured with loops) etc. The word 'knit' is synonymous with knitwear and is understood to mean 'a piece of material manufactured by entwining threads using long needles such that they form a connected whole'. The word 'weave' is understood to mean 'a piece of material manufactured by crosswise interlacing of long flexible objects (such as threads) so that they form a connected whole'. Weaves can also be manufactured from strips of leather. The word 'lace' is understood to mean 'a fine light fabric typically manufactured from cotton yarn, linen or silk or from synthetic fibres such as polyamide, elastane, nylon or viscose (but for instance also from decorative metal threads) with openwork patterns'. 'Staples' are '(typically bracket-shaped) metal pins'. Other usable metal pins are for instance rivets, or brads and tacks, which can be arranged using a tacker. The word 'stitching' is understood to mean 'an attaching means arranged by stitching'. 'Stitch' is understood to mean 'sew, wherein thread is drawn repeatedly through the same openings'. Methods

of sewing other than stitching can optionally also be used for the purpose of sufficiently strong attachment or connection.

[0038] Figure 1 is a partial side view of an embodiment of an integral shoe according to the invention. The shown integral shoe comprises an upper shoe 3, a first stocking part 1 and a second stocking part 2, and a support 4. Upper shoe 3 has an underside 3A and an upper edge 3B. First stocking part 1 is manufactured from openwork fabric. Opted for in this embodiment is a lace fabric with an openwork pattern, although this choice is non-limitative; other optionally openwork types of textile, such as knit or weave, are also possible choices and it is also possible to opt for a material without pattern. A choice is made in this preferred embodiment for the optional measure that the lace fabric has meshes of a first size and meshes of a second size, wherein the first size and the second size differ from each other. Upper shoe 3 is accommodated in first stocking part 1, i.e. first stocking part 1 covers upper shoe 3 at least on its periphery between underside 3A and upper edge 3B. In other words, the first stocking part extends from the underside 3A of the upper shoe to upper edge 3B of the upper shoe. Second stocking part 2 is manufactured from openwork fabric. Also opted for in this embodiment is a lace fabric with an openwork pattern, although this choice is non-limitative; other optionally openwork types of textile, such as knit or weave, are also possible choices and it is also possible to opt for a material without pattern. Second stocking part 2 extends from upper edge 3B of the upper shoe away from first stocking part 1 so as to thus follow the contours of a lower leg (not shown) of a wearer. Depending on the wishes of the wearer, second stocking part 2 can also be worn in other manner, for instance partly folded back, in order to thus impart another appearance to the integral shoe, for instance by giving second stocking part 2 the appearance of an ankle scarf. Support 4 is arranged on the underside 3A of the upper shoe. Opted for in this embodiment is a support 4 with a heel, although flat supports (without heel) are also possible in other embodiments. Also arranged under support 4 in this embodiment is an optional outsole 5, and the choice is also made for an optional covering of jute (a natural material, such as also cork, leather and fabric) to be provided on at least an upper outer periphery of support 4.

[0039] A primary attaching means (not shown in this figure) is provided between upper shoe 3 and support 4 in order to attach first stocking part 1 to upper shoe 3. The choice of such a primary attaching means can be made from such attaching means as staples, wire nails, adhesive, stitching, tensioning clamps or a combination of two or more of these attaching means.

[0040] A secondary attaching means (which is shown in this figure) is provided at the position of upper edge 3B of the upper shoe and serves the purpose of connecting first stocking part 1 and second stocking part 2 to upper shoe 3. The choice of such a secondary attaching means can be made from such attaching means as stitch-

ing and adhesive, or a combination of these attaching means. Opted for in this embodiment is fine stitching along upper edge 3B of the upper shoe. This fine stitching in this way respectively connects each of the first stocking part 1 and second stocking part 2 to upper shoe 3 in a manner such that the connection is sufficiently strong that excessive shifting or even stretching of at least first stocking part 1 can be prevented, while second stocking part 2 is connected sufficiently strongly to upper shoe 3 so that they are not detached from each other during use.

[0041] A choice is made in the shown embodiment for the optional measure of manufacturing first stocking part 1 and second stocking part 2 from the same piece of fabric. This means that a choice is made here of using a stocking which comprises the two stocking parts 1,2 in one piece. It is in this way possible to ensure that a pattern continues (at least visually) over the boundary between first stocking part 1 and second stocking part 2 along upper edge 3B of the upper shoe. The choice of the fine stitching makes this continuation of the same piece of fabric even more apparent.

[0042] Figure 2 shows a partial side view of another embodiment of an integral shoe according to the invention. This other embodiment partially corresponds to the embodiment shown in figure 1, with the proviso that a choice is made here that first stocking part 1 and second stocking part 2 are not manufactured from the same piece of fabric. Further opted for in the embodiment shown here is a type of heel (a wedge heel) differing from the heel of figure 1, and support 4 is provided with a covering (of jute) along the whole outer periphery of support 4. This has the result that in this embodiment the secondary attaching means connects both first stocking part 1 and second stocking part 2 to upper shoe 3 at the position of its upper edge 3B. The secondary attaching means can connect both stocking parts 1,2 together or separately to upper shoe 3, for instance by providing one respective stitching for both stocking parts 1,2 or a separate stitching for each of the two stocking parts, or for instance adhesive for the one stocking part (e.g. first stocking part 1, or vice versa) and stitching for the other stocking part (e.g. second stocking part 2, or vice versa).

[0043] Figure 3 shows a partial rear view of an embodiment of an integral shoe according to the invention. This embodiment corresponds to the embodiment shown in figure 1. The heel side of the integral shoe can be discerned more clearly in this figure. In this embodiment a strengthening band 6 is also provided on second stocking part 2. Strengthening band 6 extends from at least the secondary attaching means, in other words from upper edge 3B of the upper shoe. In the shown embodiment strengthening band 6 extends on the rear side (the heel side) of second stocking part 2, although in other embodiments strengthening band 6 can also extend elsewhere, for instance on the side of second stocking part 2 which faces toward the other leg of a wearer during use. Strengthening band 6 serves to strengthen second stocking part 2 when it is pulled. Strengthening band 6 pref-

erably extends along a stitched seam of second stocking part 2 in order to provide better strengthening thereof and to provide a more attractive appearance. In other embodiments strengthening band 6 can however also extend in other manner, for instance in a spiral shape. Strengthening band 6 is preferably manufactured from leather as here, although it is also possible to opt for a herringbone band or a band of satin, canvas or cotton. According to a further developed embodiment as shown here, strengthening band 6 is optionally also provided on first stocking part 1 for strengthening thereof, and preferably extends from the primary attaching means. The strengthening band can in that case be incorporated either within upper shoe 3 or into the periphery of upper shoe 3, or arranged on the outside thereof (as shown here), for instance with stitching, in accordance with the desired appearance of the integral shoe. Strengthening band 6 is preferably arranged on an outer side of second stocking part 2 and second stocking part 2 is subsequently turned inside out so that strengthening band 6 comes to lie on an inner side of second stocking part 2. When second stocking part 2 and first stocking part 1 are manufactured from the same piece of fabric, knit or weave, it is likewise the case that first stocking part 1 is then turned inside out.

[0044] Figure 4 shows a partial rear view of another embodiment of an integral shoe according to the invention. This embodiment corresponds to the embodiment of figures 1 and 3 so that the same comments also apply here, and shows a part of second stocking part 2 in elongated form, in which a lower leg (not shown) of a wearer can be at least partially accommodated. In the preferred embodiment shown here second stocking part 2 is manufactured from one piece of fabric which is stitched with a stitched seam so as to form a tubular lower leg covering. The pattern of second stocking part 2 is clearly discernible in this figure. Also provided in the embodiment shown here are the optional measures of a strengthening band 6 and a stocking hold-up means 7. Strengthening band 6 corresponds to strengthening band 6 as discussed with reference to figure 3. The stocking hold-up means 7 is provided on second stocking part 2 in order to at least partially hold it up on a leg of a wearer (not shown) in a situation of use. As in this embodiment the stocking hold-up means 7 is preferably provided in the vicinity or at the position of an upper edge of second stocking part 2. Such a stocking hold-up means 7 can, as here, be embodied as an elastic band with a width sufficiently great that the elastic band does not give the sensation of cutting into a wearer. The skilled person can use an elastic band for this purpose with a width of for instance at least 0.5 cm, preferably at least 1 cm and more preferably at least 1.5 cm.

[0045] Figure 5 is a side view of an embodiment of an integral shoe according to the invention. This embodiment corresponds to the embodiments of figures 1, 3 and 4, so that the same comments also apply here. Clearly discernible in this figure is how second stocking part 2

extends from upper edge 3B of the upper shoe and is able to accommodate the upper leg of a wearer from the instep to the thigh bone (so above the knee) of the wearer. In some embodiments second stocking part 2 can also take a shorter form, i.e. second stocking part 2 extends over a lesser length and extends for instance from the ankle of a wearer and/or for instance extends to below the knee of a wearer or only to a height between the ankle and the knee of the wearer.

[0046] Figures 6A to 10 show examples of performing several steps of an embodiment of a method for manufacturing an integral shoe according to the invention. The whole method comprises of: manufacturing an upper shoe 3 with an underside 3A and an upper edge 3B on a last (of wood, plastic or metal such as aluminium); arranging a first stocking part manufactured from openwork fabric, knit or weave on upper shoe 3, which first stocking part 1 at least substantially corresponds to an outer periphery of upper shoe 3 from the underside 3A of the upper shoe to the upper edge 3B of the upper shoe, such that upper shoe 3 can be accommodated in first stocking part 1; attaching first stocking part 1 to the underside 3A of the upper shoe using a primary attaching means; connecting respectively first stocking part 1 and a second stocking part 2 which is manufactured from openwork fabric, knit or weave to upper shoe 3 at the position of upper edge 3B of the upper shoe using a secondary attaching means, and which second stocking part 2 is embodied in a manner such as to at least partially accommodate a lower leg (not shown); and arranging a support 4 on the underside 3A of the upper shoe.

[0047] The skilled person will appreciate that the steps of some embodiments of a method for manufacturing an integral shoe according to the invention which are not explicitly illustrated here, such as for instance the manufacture of upper shoe 3 on a last, cutting out an upper shoe piece form (for instance of leather) with a lower edge and an upper edge; stitching of the upper shoe piece form on a heel side thereof; arranging the upper shoe piece form around the last, wherein the lower edge of the upper shoe piece form is folded round the last (for instance by heating the lower edge of the upper shoe piece form), so as to form at least a portion of the underside of the upper shoe, and wherein the upper edge of the upper shoe piece form forms the upper edge of the upper shoe; and removing the last following arrangement of the support.

[0048] Figures 6A-B show examples of arranging first stocking part 1 over the outer periphery of upper shoe 3. In figure 6A a separate first stocking part 1 is shown; shown in figure 6B is a first stocking part 1 manufactured from the same piece of fabric, knit or weave as second stocking part 2. In both cases first stocking part 1 comprises a downward hanging stocking edge 10 because first stocking part 1 is open on its underside. In other embodiments first stocking part 1 can be closed on its underside so that a stocking edge 10 is not formed.

[0049] Figures 7A-B show examples of attachment 11

of first stocking part 1 to the underside 3A of the upper shoe using a primary attaching means. Stocking edge 10 of first stocking part 1 is for this purpose folded round and attached to the underside 3A of the upper shoe. Figure 7A shows the case of a separately manufactured first stocking part 1; figure 7B shows the case of a first stocking part 1 manufactured from the same piece of fabric, knit or weave as second stocking part 2.

[0050] Figures 8A-C show examples of connecting respectively first stocking part 1 in figure 8A, second stocking part 2 in figure 8B, and both the first stocking part 1 and second stocking part in figure 8C, in each case to upper shoe 3, this at the position of upper edge 3B of the upper shoe. Use is made for the connection of a secondary attaching means 12 which in the shown embodiment comprises stitching along upper edge 3B of the upper shoe.

[0051] Figure 9 shows an example of arranging a support 4 on the underside 3A of the upper shoe such that the primary attaching means (not shown) is received between support 4 and upper shoe 3. Support 4 can be arranged while upper shoe 3 is still placed round a last (not shown). Use can be made for arranging purposes of attaching means such as adhesive, staples, wire nails and/or stitching 12. In some embodiments support 4 is covered beforehand and/or afterwards with a natural material such as cork, leather, jute or fabric. In further embodiments an outsole can be arranged beforehand or afterwards on at least one underside of support 4.

[0052] Figure 10 shows an example of arranging an inner sole 13 in upper shoe 3 after a support 4 (with a high heel) has been arranged on the underside of upper shoe 3 and a last (not shown) has been taken out of upper shoe 3. This inner sole 13 serves to support the foot (not shown) of a wearer, and can be provided for this purpose with damping material. Inner sole 13 can be arranged with staples, wire nails or the like, stitching and/or adhesive.

[0053] The skilled person will appreciate that the present invention is not limited to the above described embodiments and that the scope of protection is defined solely by the following claims.

Claims

1. An integral shoe, comprising:

- an upper shoe with an underside and an upper edge;
- a first stocking part of fabric, knit or weave in which the upper shoe is accommodated and which extends from the underside of the upper shoe to the upper edge of the upper shoe;
- a second stocking part of fabric, knit or weave which extends from the upper edge of the upper shoe away from the first stocking part;
- a support arranged on the underside of the

upper shoe;

- a primary attaching means provided between the upper shoe and the support in order to attach the first stocking part to the upper shoe; and
- a secondary attaching means provided at the position of the upper edge of the upper shoe in order to connect the first and the second stocking part to the upper shoe.

2. The integral shoe as claimed in claim 1, wherein the first stocking part and the second stocking part are manufactured from the same piece of fabric, knit or weave.
3. The integral shoe as claimed in either of the claims 1-2, wherein at least one stocking part of the first stocking part and the second stocking part is manufactured from an openwork fabric, an openwork knit or an openwork weave.
4. The integral shoe as claimed in any of the claims 1-3, wherein the fabric, knit or weave is provided with a pattern.
5. The integral shoe as claimed in any of the claims 1-4, wherein a strengthening band is provided on the second stocking part, which strengthening band extends from at least the secondary attaching means, which strengthening band serves to strengthen the second stocking part when the second stocking part is pulled.
6. The integral shoe as claimed in any of the claims 1-5, wherein at least one stocking part of the first stocking part and the second stocking part is manufactured from a material chosen from: lace, jersey, fabric á jour, perforated alcantara and perforated stretchable leather.
7. The integral shoe as claimed in any of the claims 1-6, wherein the second stocking part is manufactured from one piece of fabric, knit or weave which is stitched so as to form a tubular lower leg covering.
8. A method for manufacturing an integral shoe, comprising of:

- manufacturing an upper shoe with an underside and an upper edge on a last;
- arranging a first stocking part of openwork fabric, knit or weave on the upper shoe, which first stocking part at least substantially corresponds to an outer periphery of the upper shoe from the underside of the upper shoe to the upper edge of the upper shoe such that the upper shoe can be accommodated in the first stocking part;
- attaching the first stocking part to the underside of the upper shoe using a primary attaching

means;

- connecting a second stocking part of openwork fabric, knit or weave to the upper shoe at the position of the upper edge of the upper shoe using a secondary attaching means, which second stocking part is embodied in a manner such as to at least partially accommodate a lower leg; and
- arranging a support on the underside of the upper shoe.

9. The method as claimed in claim 8, wherein manufacture of the upper shoe comprises of:

- cutting out an upper shoe piece form with a lower edge and an upper edge; and
 - arranging the upper shoe piece form around the last, wherein the lower edge of the upper shoe piece form is folded round the last in order to form at least a portion of the underside of the upper shoe, and wherein the upper edge of the upper shoe piece form forms the upper edge of the upper shoe;
- wherein following arrangement of the support the method further comprises of:
- removing the last; and
- wherein following removal of the last the method further comprises of:
- arranging an inner sole.

10. The method as claimed in either of the claims 8-9, wherein the first stocking part and the second stocking part are manufactured from the same piece of fabric, knit or weave.

11. The method as claimed in any of the claims 8-10, wherein at least one stocking part of the first stocking part and the second stocking part is manufactured from an openwork fabric, an openwork knit or an openwork weave.

12. The method as claimed in any of the claims 8-11, wherein the fabric, knit or weave is provided with a pattern.

13. The method as claimed in any of the claims 8-12, comprising of:

- arranging a strengthening band on the second stocking part from at least the secondary attaching means, which strengthening band serves to strengthen the second stocking part when the second stocking part is pulled.

14. The method as claimed in any of the claims 8-13, wherein at least one stocking part of the first stocking part and the second stocking part is manufactured from a material chosen from: lace, jersey, fabric á

jour, perforated alcantara and perforated stretchable leather.

15. The method as claimed in any of the claims 8-14, comprising of:

- cutting to size a piece of fabric, knit or weave; and
- stitching the piece of fabric, knit or weave in order to form a first and/or second stocking part.



FIG. 1

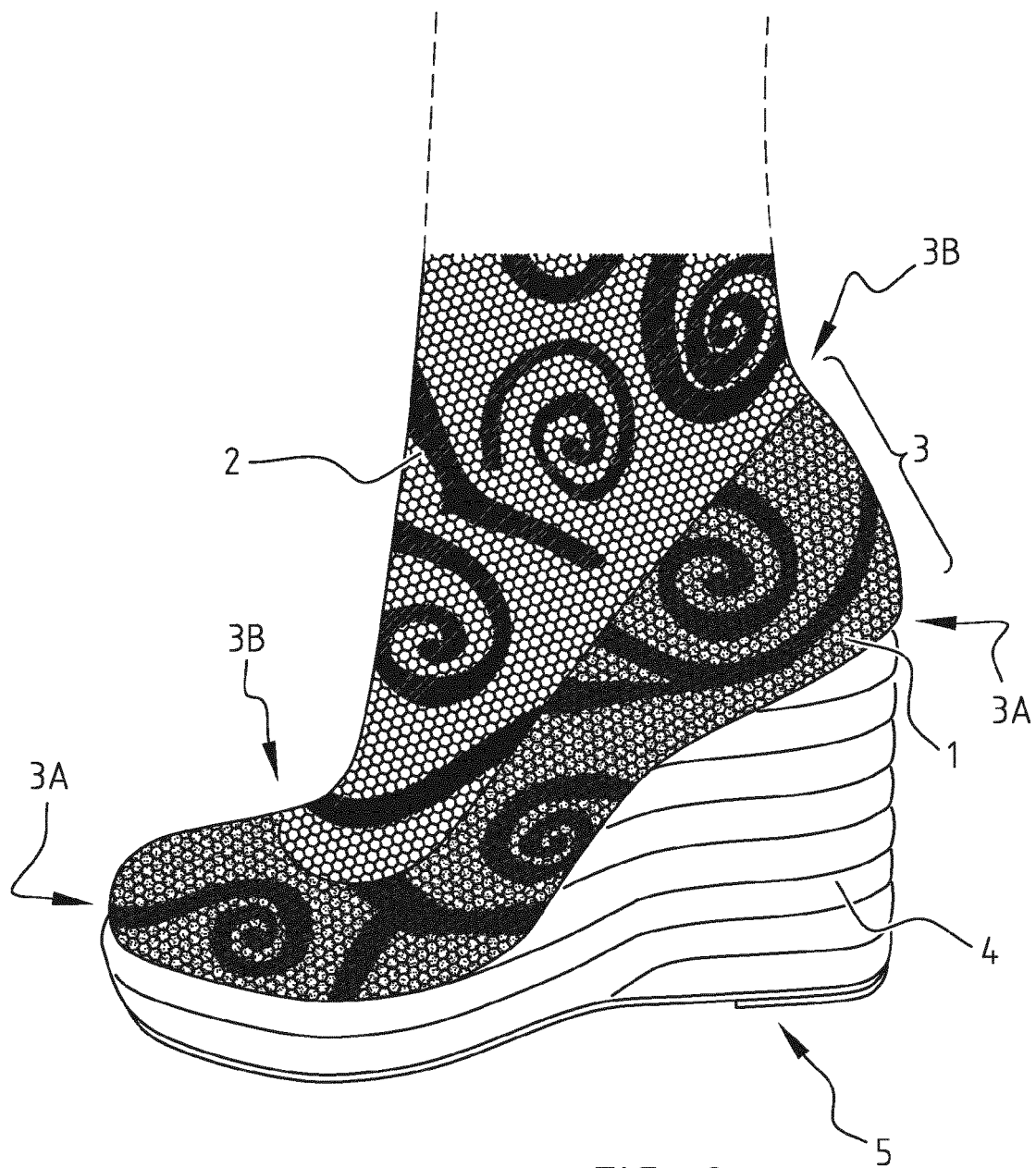


FIG. 2

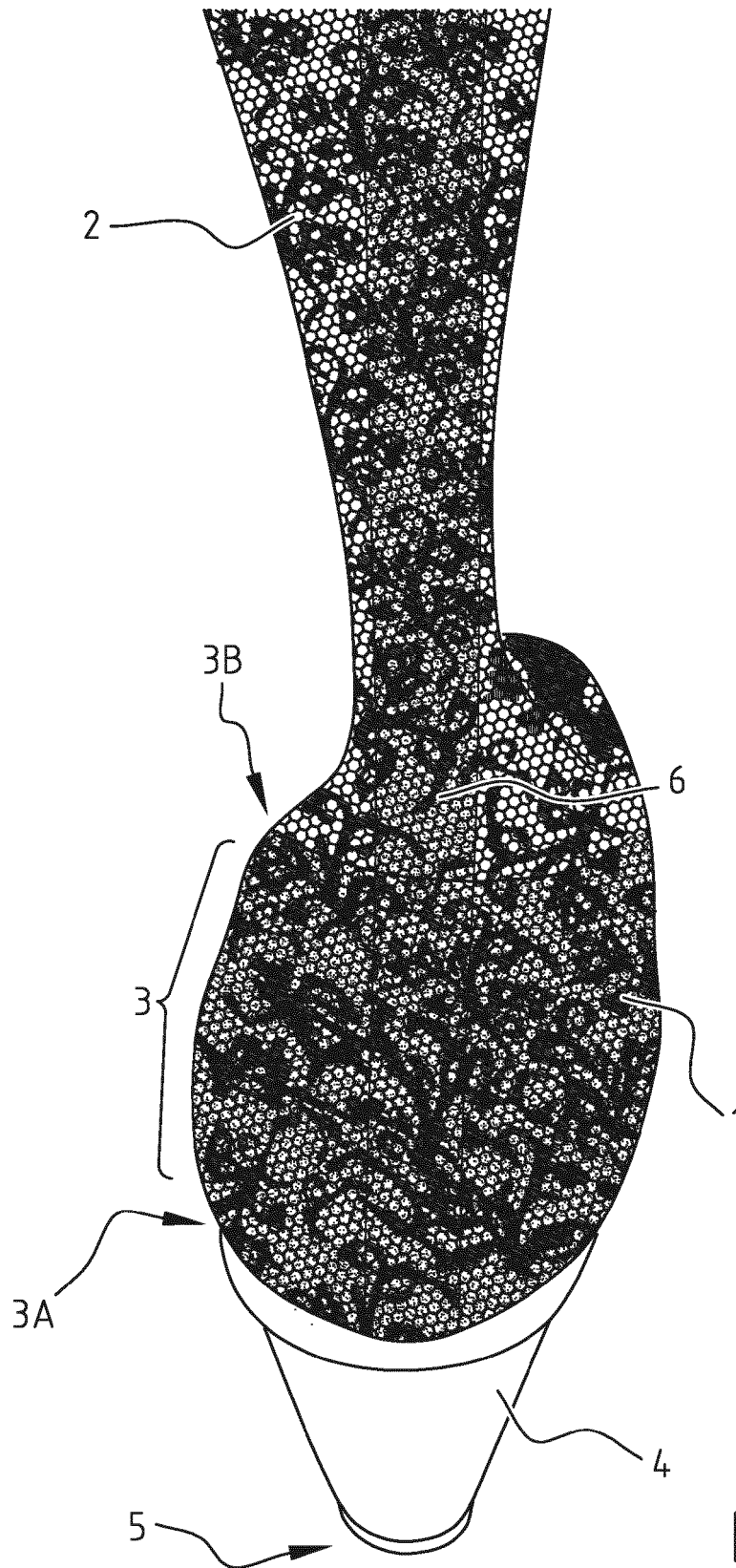


FIG. 3

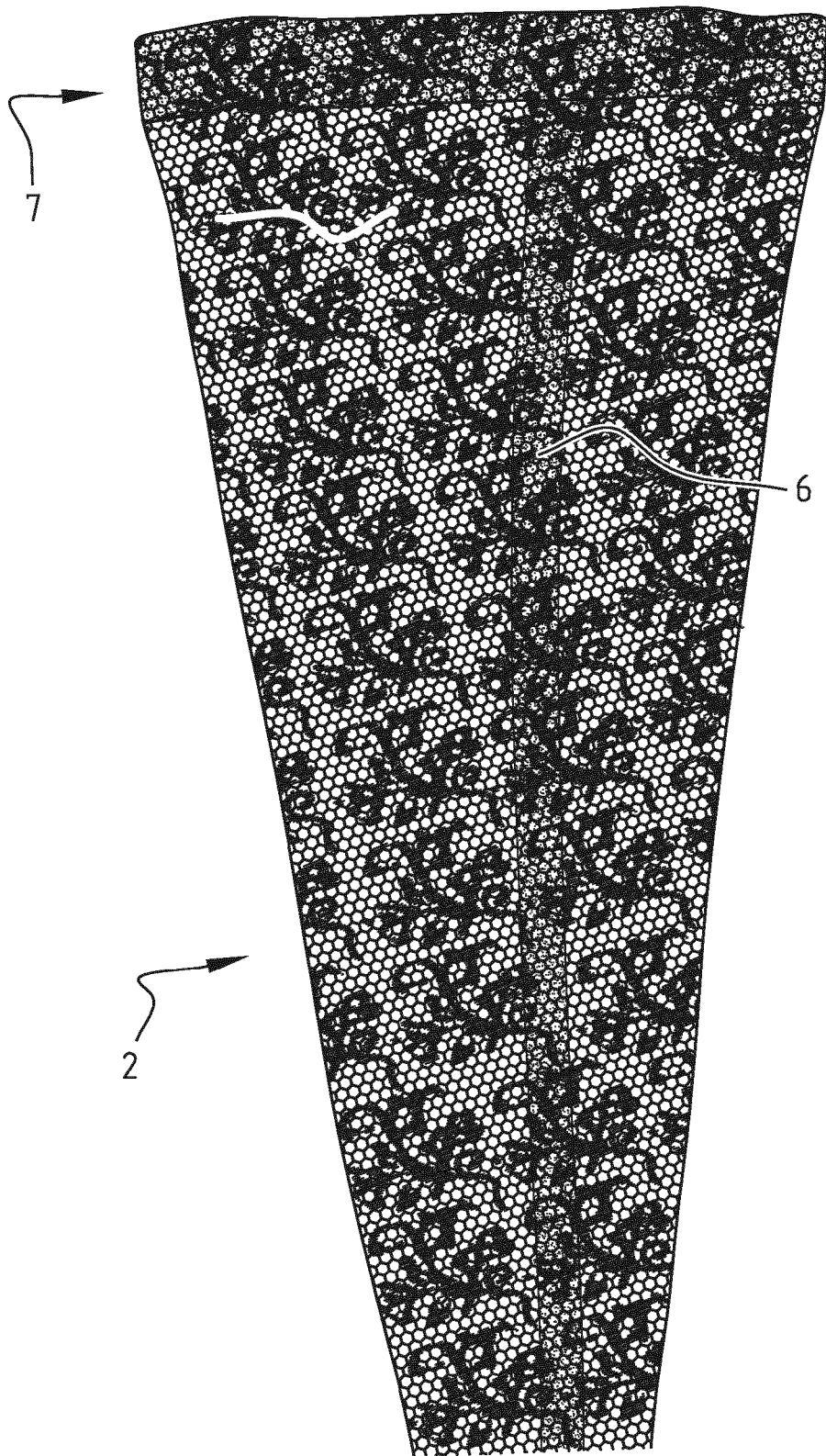


FIG. 4

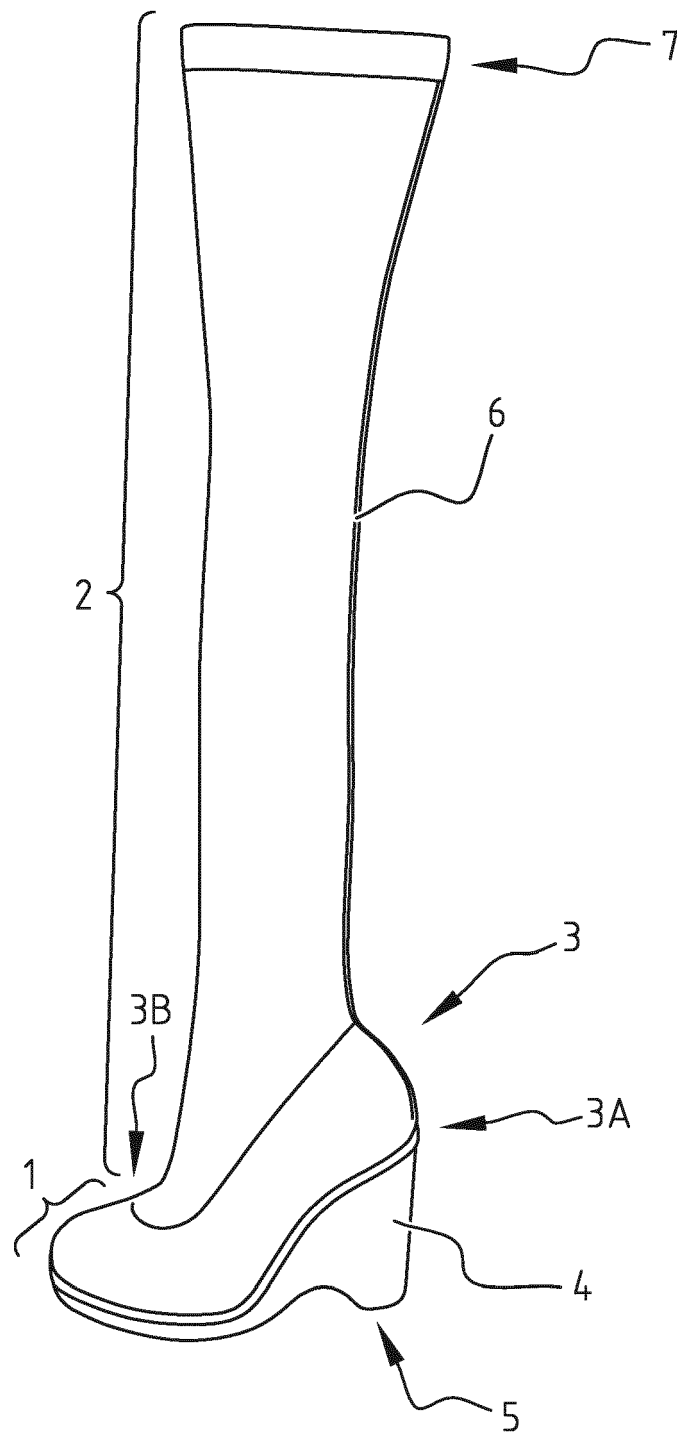


FIG. 5

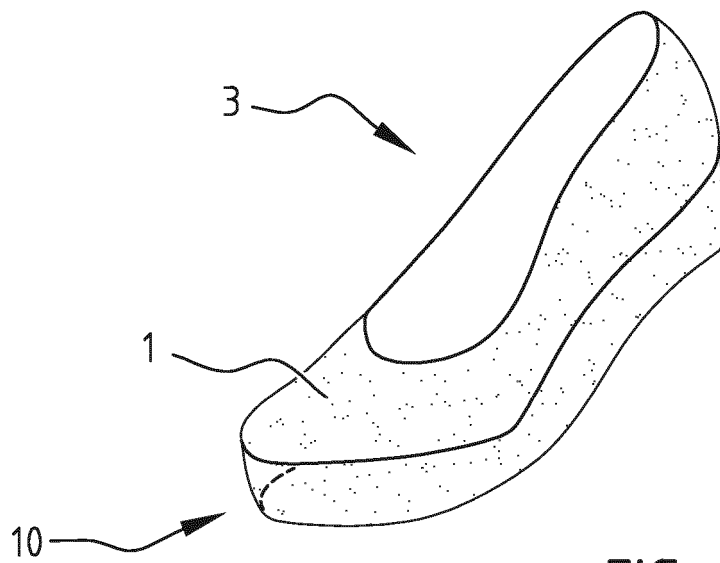


FIG. 6A

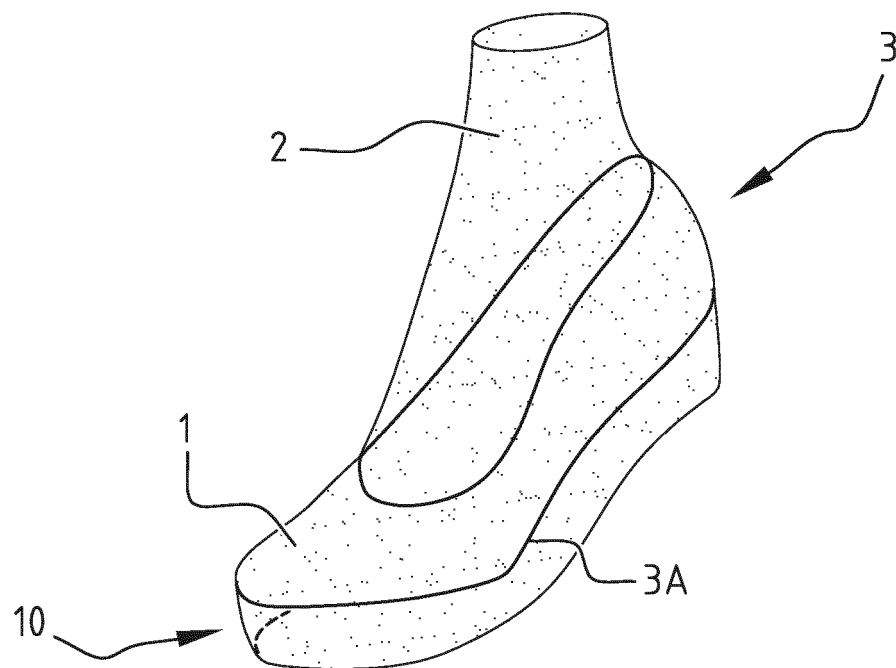


FIG. 6B

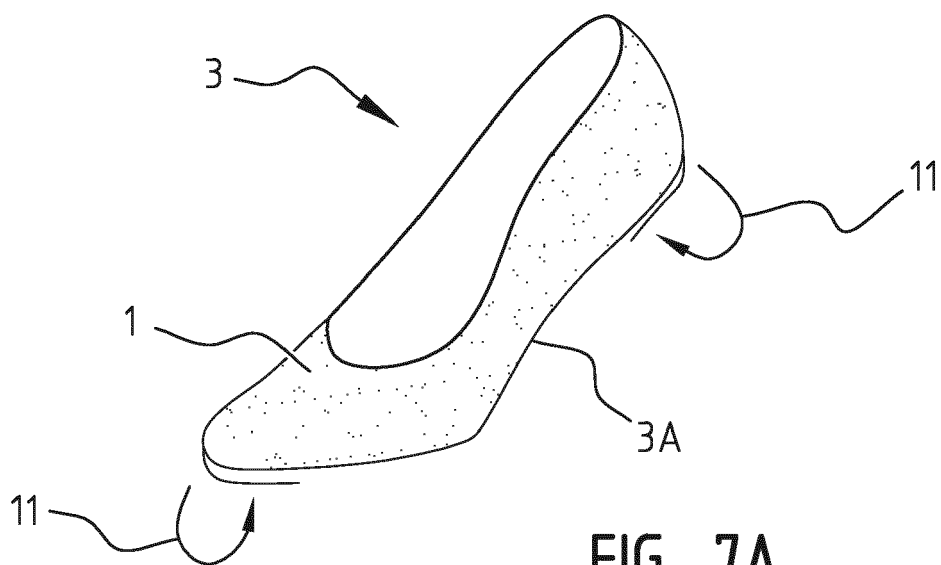


FIG. 7A

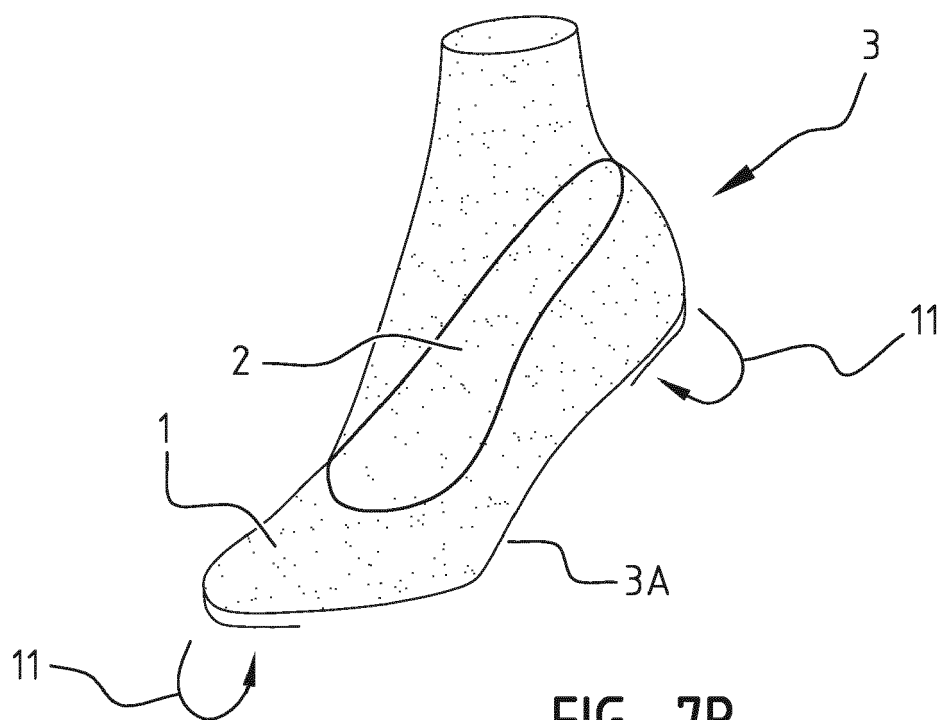


FIG. 7B

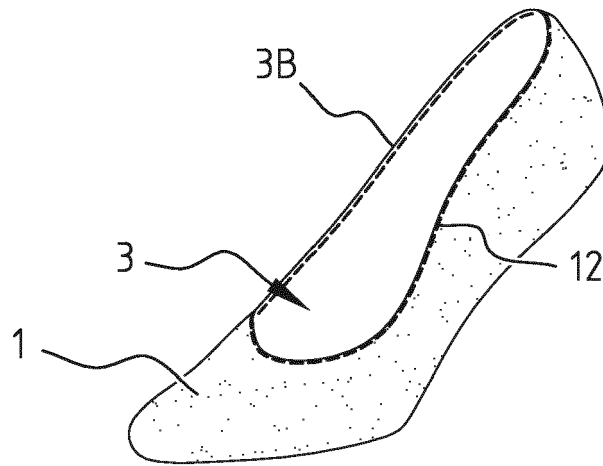


FIG. 8A

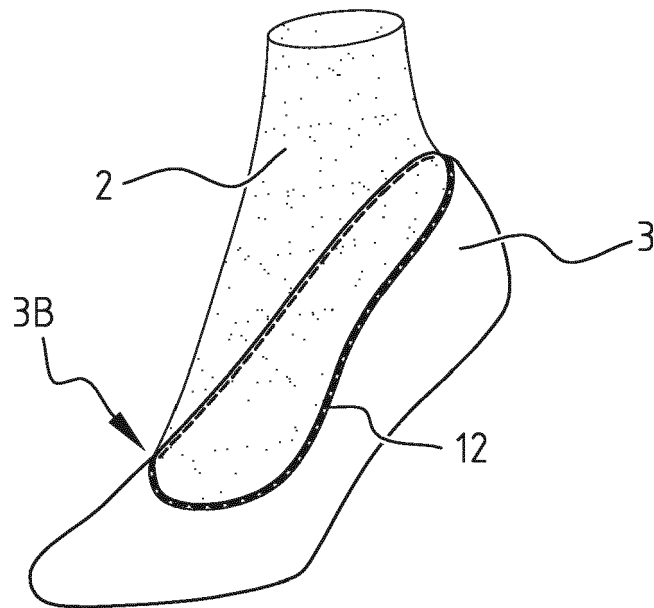


FIG. 8B

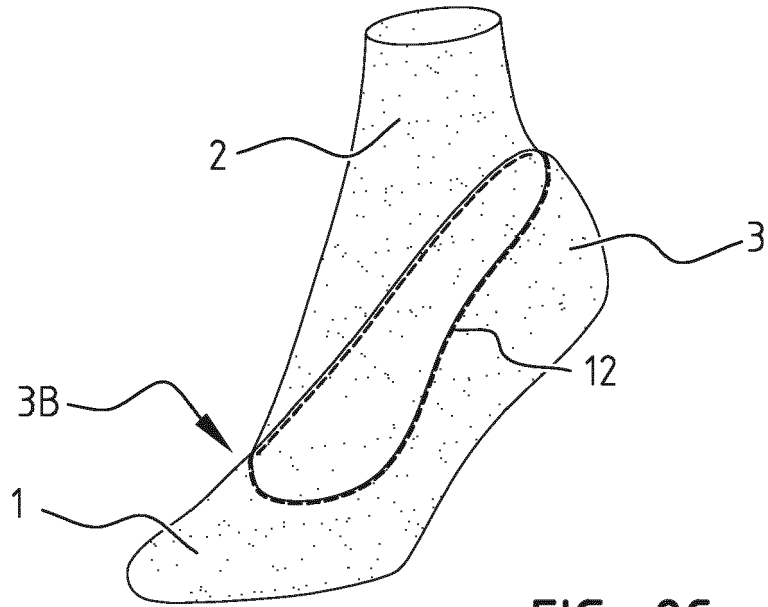


FIG. 8C

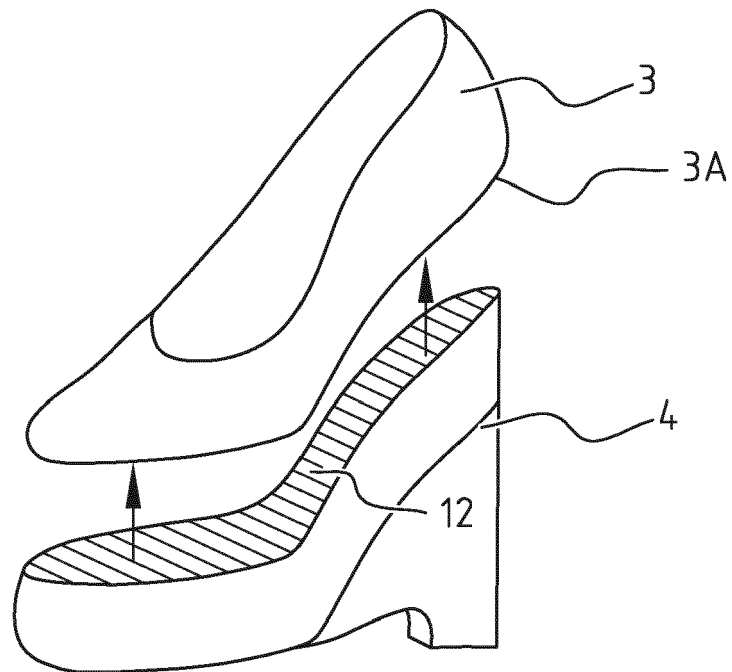


FIG. 9

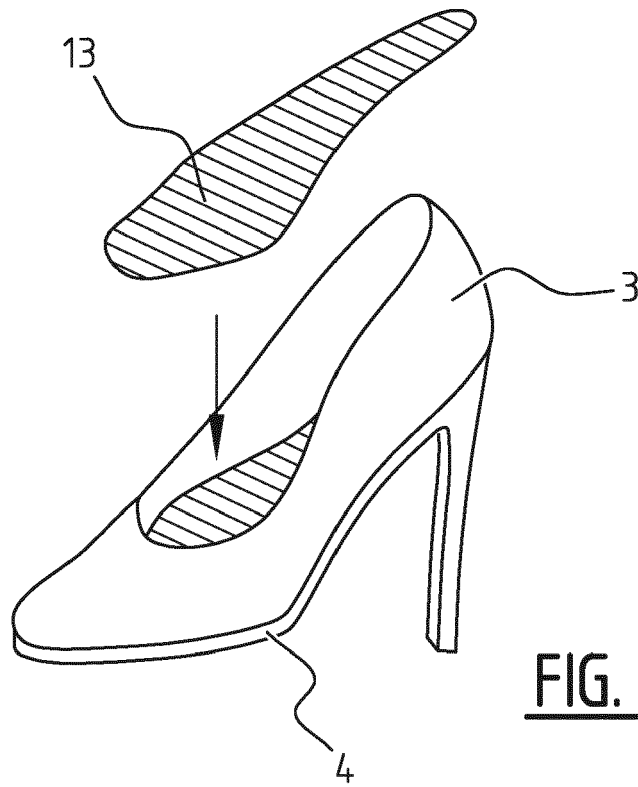


FIG. 10



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Application Number
EP 15 18 9748

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			A43B
The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of the search 24 February 2016	Examiner Claudel, Benoît
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The members are as contained in the European Patent Office EDP file on
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