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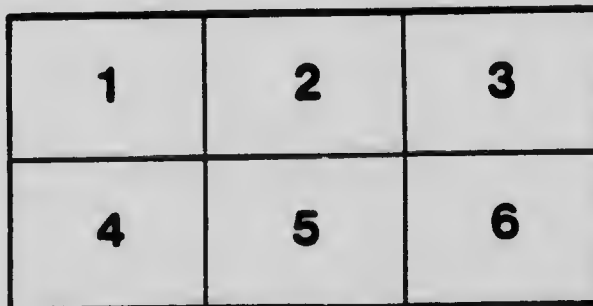
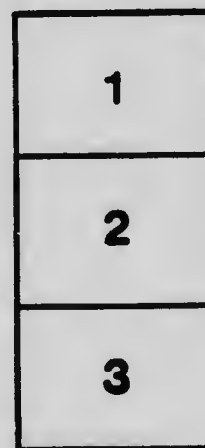
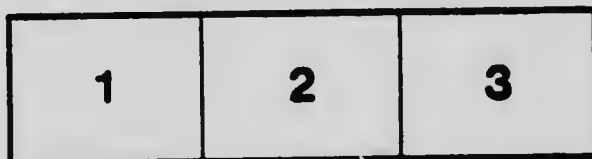
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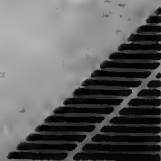
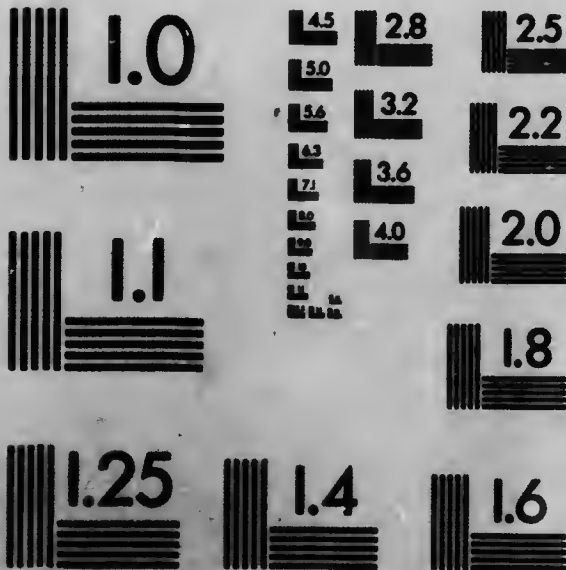
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THE MAKING OF A GOODYEAR WELT SHOE



**UNITED SHOE MACHINERY CO OF CANADA
MONTREAL**

P. M. G.





No.

1. A last.
2. An upper.
3. An insole.
4. Shoe lasted and ready to have welt sewed on.
5. Welt partially sewed on.
6. Welt entirely sewed on and shoe ready to have outsole laid.

No.

7. An outsole.
8. Shoe with outsole laid and rounded. Channel lip turned up ready to be stitched.
9. Shoe with sole stitched on.
10. Shoe with heel in place.
11. Heel trimmed and shoe ready for finishing.

The Making of a Goodyear Welt Shoe

THE passing of the old-fashioned shoemaker presents a most interesting phase of our commercial development, for it is well within the limits of a decade that he of the lap stone, the awl, and waxed ends has disappeared, and in his place has come the modern shoe factory, clean, well lighted, and highly organized.

In the new régime the maker of shoes no longer works from "sun to sun," but, in a surprisingly few hours, he and a few of his fellow-workmen, aided by that greatest of all boons to mankind, machinery, are able to produce in a day shoes to a number which he, working single-handed under the old method, could not hope to equal in a year of labor, and which possess comfort, durability, and all the essential features which make a shoe desirable to a degree which he, even if

exceptionally skilled, could not duplicate working in the old way. The excellent footwear of today could not be produced, except at a great increase in cost, without the use of machinery, for the genius of the inventor has set aside the old-fashioned, slow, and laborious methods of manufacture, and made it possible for those even in the most moderate circumstances to secure all the comfort and satisfaction in shoes which were but a few short years ago denied to all but the very wealthy.

The group of machines here exhibited is considered among the most remarkable in use at the present time, consisting as it does of the famous Goodyear Welt System, which has probably done more to revolutionize shoe-making methods than any other set of machinery, and, with it, the different machines which are necessary accessories to the making of a perfect shoe. Duplicates of these machines may be found in all leading shoe factories the world over.

As a shoe is made either a comfort or a torment in the manufacturing process, the details effecting its construction cannot fail to interest, for even a


superficial observation will assist in avoiding the annoyances and discomforts which attend wearing shoes which are improperly made.

In the beginning, the parts forming the upper portion of the shoe are cut to conform with certain patterns, the linings fitted, and the whole sewn together, forming the shoe upper; this is then lightly drawn over a wooden form, called a last, which determines the shape of the shoe. The insole, which is the exact form and size of the bottom of the last, has already been put in place, being lightly tacked to the last bottom.

This insole, which is made of light, tough leather, is channeled on a little machine, which cuts a slit in the sole extending from the edge about half an inch toward its centre, also a little slit about one-half inch from the edge of the insole so that it extends toward the slit that has been cut from the edge. The portion of leather between these two cuts is now turned up so that they form a lip to which the welt is afterward sewed. In this shape, the insole is tacked to the last, as heretofore described, and the shoe upper is drawn over the last and lightly tacked to the



human way in which it performs its part of the work. Notice how evenly and tightly it draws the leather around the last. At each pull a small tack, driven automatically, holds the edge of the upper exactly in place, so that in the finished shoe every part of the upper has been stretched in all directions equally. The shoe is now ready to receive the welt, which is a narrow strip of carefully prepared



SHOE MAKING
BEFORE
GOODYEAR WELTS
WERE INVENTED



famous Goodyear Welt Sewing Machine, which has been a leading factor in the great revolution that has taken place in shoe manufacturing. Note its work: every stitch of equal length and measured automatically, the strong linen thread, thoroughly waxed, drawn evenly and tightly, for the machine never tires. It draws the thread as strongly in the evening as in





SHOE MAKING
★ BEFORE ★
GOODYEAR WELTS
WERE INVENTED



**TORONTO EXHIBITION
SHOE FACTORY**

Showing How

**EATONIA
SHOES**

are made by the

**GOODYEAR WELT
PROCESS**

FOR

THE T. EATON CO. LIMITED

Eatonia Shoes Manufactured
by the

**VICTORIA SHOE CO., LTD.
TORONTO**

Machines and Supplies furnished
by the

**UNITED SHOE MACHINERY
OF CANADA**

MONTREAL

