# 3 UPPERS

This chapter gives you more insight in our manufacturing process of uppers. Uppers can be ordered separately, allowing you to complete the construction of the bottom and mount the shoe, or as part of our complete shoe service. For Uppers alone, we can receive orders via email together with an existing pattern, a picture or select a model from our catalogue, together with the ground pattern or a scan of the designed last. For a complete shoe you can also specify different reinforcements or padding options which specifically meet the needs of your client

Our production use specific proportion ratios in the design of your upper which are explained in this chapter. If you would like to change these ratios, please specify your requests in your order

#### **PRODUCTION OF UPPERS**



- B | UPPER DEPARTMENT
- **C** | ORTHOPEDIC OPTIONS

### 3.1 | HOW TO MEASURE

#### 3.1.1 | MEASURE UPPER HEIGHT

The height of the upper for high shoes is always measured from the external backside of the shoe.



#### **MEASURE UPPER HEIGHT FOR LOW SHOES**

The upper height for low shoes is standard. At size 42 is 65 mm + 1 mm per size going up, -1 mm per size going down. This is measured from the back of the last withour inlay, space-sole and inner-sole. \*

- 40 63 mm
- 41 64 mm
- 42 65 mm \*
- 43 66 mm
- 44 67 mm

A mark on the last is leading for upper height. Without a marking on the last, the measurements on the orderform will be applied. The upper height includes the following thickness of the layers;

Space sole:	3 mm / 5 mm
Inner sole:	3 mm
Lining:	1 mm
Heel reinforcement:	1 mm
Upper leather:	1 mm
	<u>+</u>

TOTAL THICKNESS:

#### 9 or 11 mm (including space sole)

Example; An upper height of 200 mm is requested:

- 1) No Space sole: we mark the line on the last on 194 mm
- 2) Space sole of 5 mm: we mark the line on the last on 189 mm



#### 3.1.2 | MEASURE INSTEP

DRAWING	DEFINITION	DERBY	OXFORD
1, 2	Vamp Length	1/3 of last length	5 mm extra to the front
3	Instep Height Men	2/3 of Vamp Length	2/3 of Vamp Length
	Instep Height Women	- 5 mm	- 5 mm
	Instep Height Sport	+ 5 mm	+ 5 mm
4	Instep Width	1/4 (see drawing)	

All ring closures have back plates for more strength.

We place three eyelets from the instep point and use hooks for the remainder.

#### **1 VAMP LENGTH DERBY**

#### **2 VAMP LENGTH OXFORD**



#### 3 INSTEP HEIGHT (DERBY AND OXFORD)

#### 4 INSTEP WIDTH (DERBY)



#### 3.1.3 | MEASURE HIGH BOOTS

- 1. Place the client's foot on a comfortable heel height without any insole or orthosis
- 2. Always measure the size of the leg under the body weight because the leg differs in size due to tension in the calf muscle
- 3. Measure the leg circumference at the height of 10 cm, 15 cm, 20 cm and so on, The height of the leg is measured from the 0 point, see drawing below. The 0 point starts at the heel height
- 4. 2 types of boots:
  - Tight-fitting Boots: add a minimum of 5 mm extra tolerance on all measurement points
  - Ankle Boots: add minimum of 10 mm extra tolerance on all measurement points



## 3.2 | STITCHING SPECIFICATIONS

	THICKNESS OF THREAD*	NR. OF STITCHES IN 1 CM
Men	40/3	4
	10/3	2
Women	60/3	4,5
	20/3	2,5

\*The standard colour of our stitching thread matches with the colour of the upper leather

- 1. The standard size of perforation is:
  - Men 5x5 mm Ø2 mm
  - Women 4x4 mm Ø1 mm
- 2. The standard size for the braided shoes design is:
  - Men and Women 5 mm width

#### 3.2.1 | COLLAR PADDING

- 1. The standard thickness which we use for the collar padding is:
  - Men 5 mm
  - Women 3 mm
- 2. For both low and high shoes, with blind stitch and a folded upper leather collar, we apply a half moon design to strengthen the blind stitching on the back side of the upper.





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#### 3.2.2 | TONGUE SPECIFICATIONS

	TONGUE WIDTH
Men	80 mm
Women	70 mm
Sport shoe	100 mm

Tongue Label:

- Laser print for leather lining material
- Sticker for fabric lining material



### 3.3 | CLOSURE SPECIFICATIONS

#### 3.3.1 | DERBY AND OXFORD MODEL

DRAWING	DEFINITION	DERBY	OXFORD
1	Distance Between Quarters	Like model*	Like model*
2	Distance Between Eyelets		
	Men	23 mm	23 mm
	Women	18 mm	18 mm

#### 1 DISTANCE BETWEEN QUARTERS DERBY

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#### **DISTANCE BETWEEN QUARTERS OXFORD**



\* The distance between the quarters varifies per model. If a specific distance is prefered, define this on the order.

#### 2 DISTANCE BETWEEN EYELETS MEN

#### **DISTANCE BETWEEN EYELETS WOMEN**



For high shoes we always use blocking velcro on the tongue. This velcro is always being placed on the medial side. Except for velcro closure nr. SP112 (see next page), in this case we place the blocking velcro on the lateral side.



#### 3.3.2 | VELCRO

SPECIFICATION VELCRO	MEN SIZE	WOMEN SIZE
Length	19 / 20 * cm	19 / 20 * cm
Overlap	2,5 cm	2,5 cm
Width	2,5 cm	2 cm



\*the lowest velcro has a length of 19 cm, others are 20 cm (from bottom to top)

We have the following two standard types of velcro:

#### SP110 ROLLER BUCKLE IN LEATHER HOLDERS

#### SP112 BUCKLE THROUGH LEATHER

SP112



SP110

#### 3.3.3 | ZIPPER

- Shoes with a lateral zipper on the picture also have a medial zipper. Since a shoe is displayed from the lateral side, a single medial zipper is indicated with a zipper icon.
- All displayed models with zippers have a functional zipper.

At high boots with a zipperclosure we do not use cork to create extra space around the instep, unless clearly indicated on the order form. See picture below for a reference.

Reference:



### 3.4 | HIGH UPPER ON LOW LASTS

If a high shaft has to be made from the low last, we use a separate instep cap and separate heel cap for a maximum upper height of 160 cm. For an upper height from 160 mm to 250 mm, we use a combination of an instep cap and heel cap as shown in figure 2. If the shaft should be 250 mm or higher, we will make a leg last extension.

#### **1. INSTEP CAP AND FIXED HEEL CAP**

#### 2. COMBINATION OF INSTEP AND HEEL CAP



### 3.5 | PADDING

In our special material bundle you will find our padding material with code 5016 to 5032. By default CYS uses code 5027 for padding. The standard thickness is: 3 mm for women and 5 mm for men. Please state in your order if you would like a thickness of 3 mm or 5 mm. Padding is only by request, except collar padding which is based on LOOXZ model. The CYS padding SP155 is 18 mm thick. It is a combination of materials 5028 and 5029. If requested, SP155 is applied to heel, tongue and collar. In the overview below you can see the different padding options.



### 3.6 | COUNTER & SIDE LINING

The standard height of the counter is 5 mm below the medial / lateral ankle. At the backside of the shoes, we keep the counter as high as possible.

COUNTER	MATERIAL	THICKNESS
Women	Rhenoflex 5048	1.2 mm
Men	Rhenoflex 5048	1.7 mm

For toe reinforcement we use Tep 5046 1.1 mm. However toe reinforcement can also be made from steel, aluminium, polypropylene or carbon.

We only use side lining when the upper has a foam lining or / and Berry (baby calf) upper leather

#### COUNTER

#### **SIDE LINING**



### 3.7 BLU REINFORCEMENT <u>B</u>ETWEEN <u>LINING & UPPER LEATHER</u>

The BLU is being ordered to support and stabilize the foot and ankle. The BLU types that we offer can be made with ankle padding or general padding all around. By default, this padding is made in: 3 mm (women) or 5 mm (men) of 5027 material.

In the overview on page 36 - 37 you will find our BLU options together with the specifications of the materials which we use for each layer. You may provide us with the drawing of lines of the BLU on the last or seperate drawing on paper for any specific client case. If requested BLUE is higher than 30 cm, a lining shoe will be made and charged.

#### **BLU REINFORCEMENT BETWEEN LINING & UPPER LEATHER**





### 3.8 FINISHING UPPERS

Upper-only orders are not finished and therefore differ from the photos shown