

DIGITIZING THIS BOOK

This is a digitized copy of Crooker's Bottom Finishing Design Book from 1885.

My wonderful wife, Debra, gave me this book as a gift. I found this book to be intriguing, providing a day-in-the-life view of the shoe industry. Printing books in 1885 was labor intensive, yet here was a book printed with its primary purpose to show different bottom finishing designs.

The quality of the original digitization was poor, even using a scanner or camera. I cleaned up the digitized pages, redrew or touched up images and re-typed the text. The original typeface was not available, but I did find a font that was reasonably close. I have attempted to mimic the layout of pages, spacing and size of the text and even included the blank pages. This is the only page not in the original book.

I would like to thank The Honourable Cordwainer's Company (thehcc.org). This group is dedicated to preserving the art and knowledge of shoemaking. Their forum is an invaluable resource and this special version was created as a thanks to all the contributors.

A special thanks also goes to my lovely wife for giving me this book.

Terry Burress



thehcc.org

CROOKER'S

DESIGN BOOK

FOR

Bottom Finishing

One Hundred and Fifty Different Designs.

Wm. W. Crooker Mfg. Co.,

Brushed and Burnished Colors,

63 & 65 OXFORD ST.,

Lynn, Mass.,

U. S. A.

A COPYRIGHTED 1885

—✦—**OTHELLO**—✦—
Heel, Edge and Shank
BURNISHING INK.



No. 1, HEELS AND EDGES No. 2, SHANKS

*After a fair trial you will use no other.
Send for Sample.*

WM. W. CROOKER MFG. CO.
Lynn, Mass., U. S. A.





CROOKER'S

DESIGN BOOK

FOR

BOTTOM FINISHING.



150 DIFFERENT DESIGNS

DESIGNED AND COPYRIGHTED BY WM. W. CROOKER

"To make perfect is to excel."

LYNN:
PRESS OF G. H. & W. A. NICHOLS.
1885.





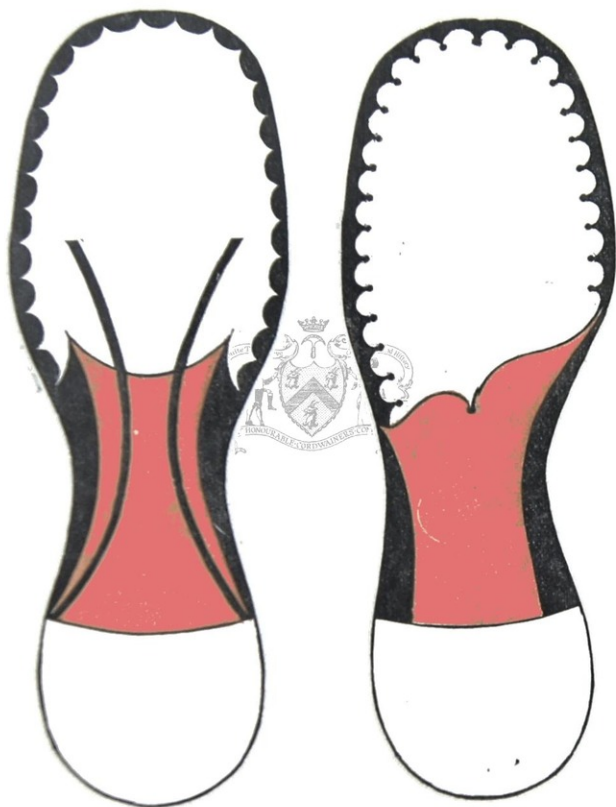
INTRODUCTION.

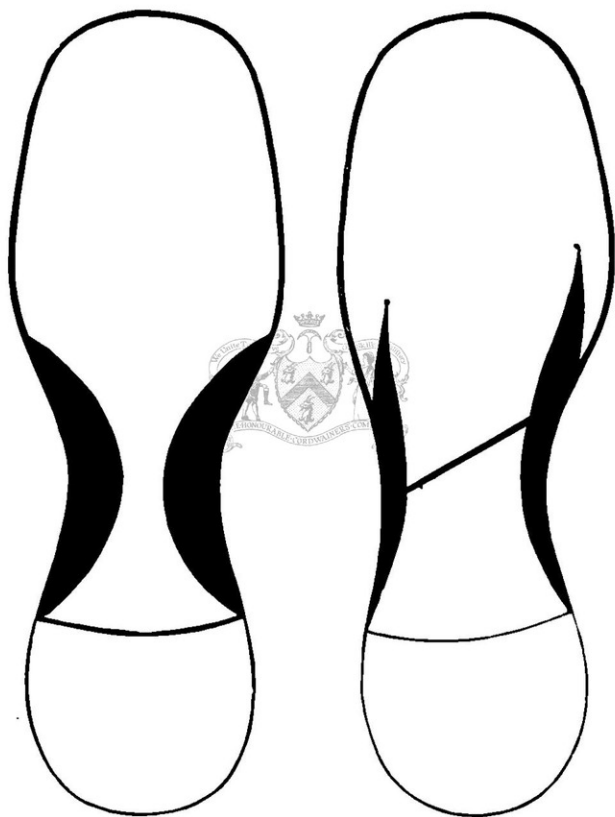
THIS book is issued to take the place of a want long felt by manufacturers—that of finishing the bottoms in a practical manner. Whenever samples are to be finished it is always very desirable to finish the bottom so that it may add both beauty and grace to the shoe. A beautifully designed upper, no matter how nicely fitted, may be caused to look poorly if the bottom lacks the same beauty of finish that is given to the rest of the shoe. In placing this work before you, it is given as an aid in being properly instructed how a boot or shoe should best be finished in a satisfactory and workmanlike manner.

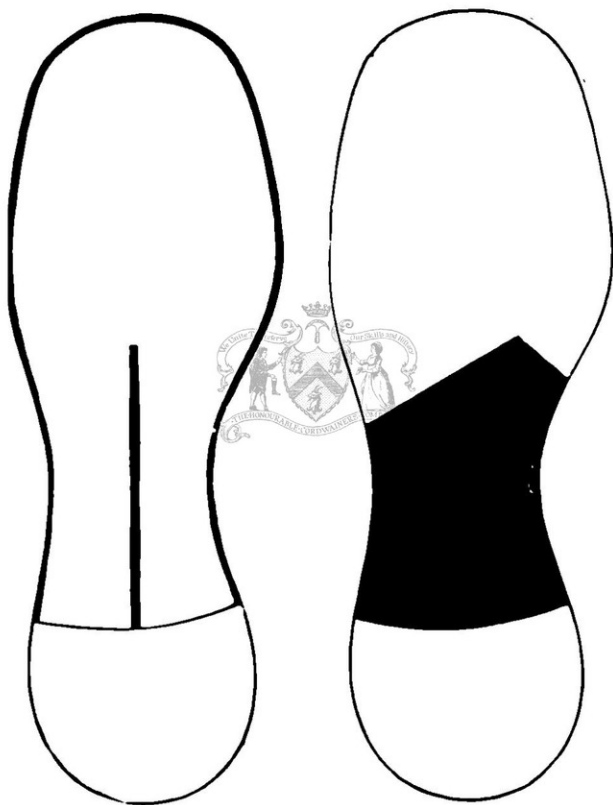
Hoping the foregoing pages may fully meet with your approval, I am,

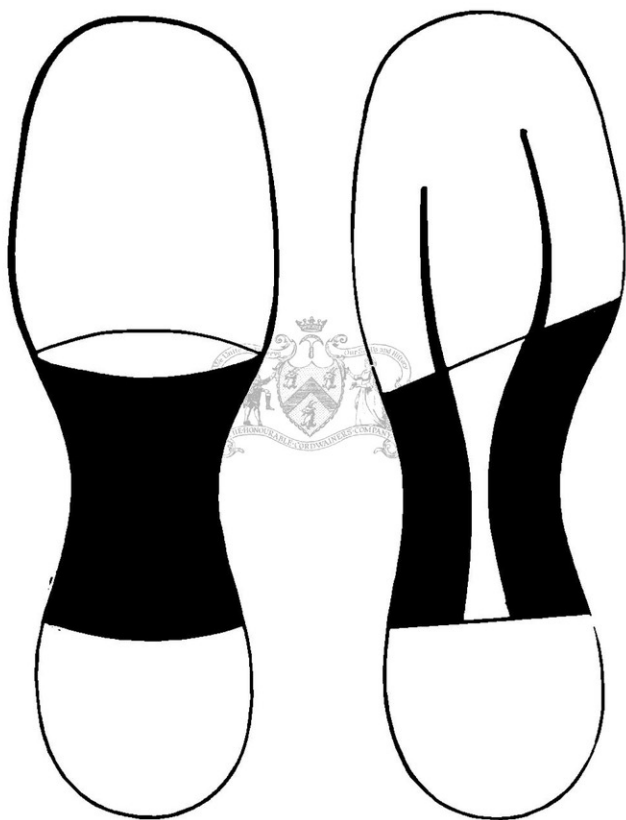
Yours very respectfully.

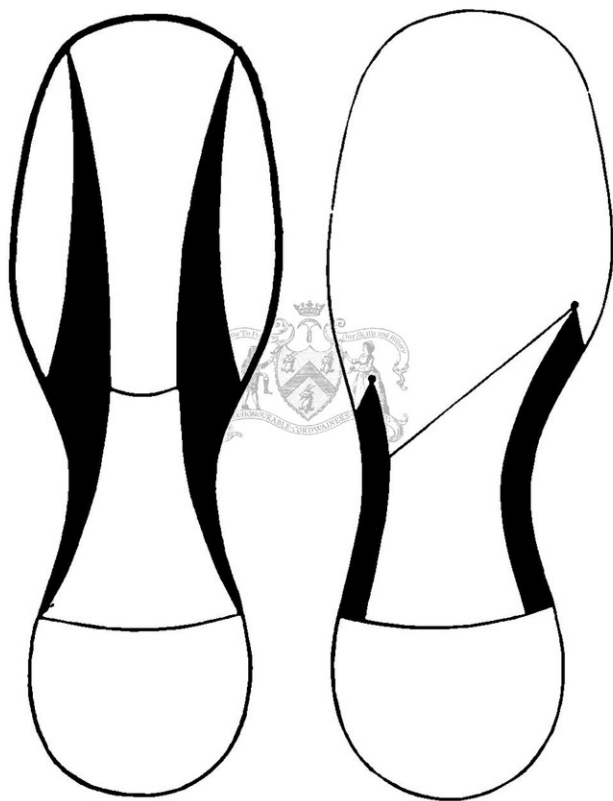
WM. W. CROOKER.

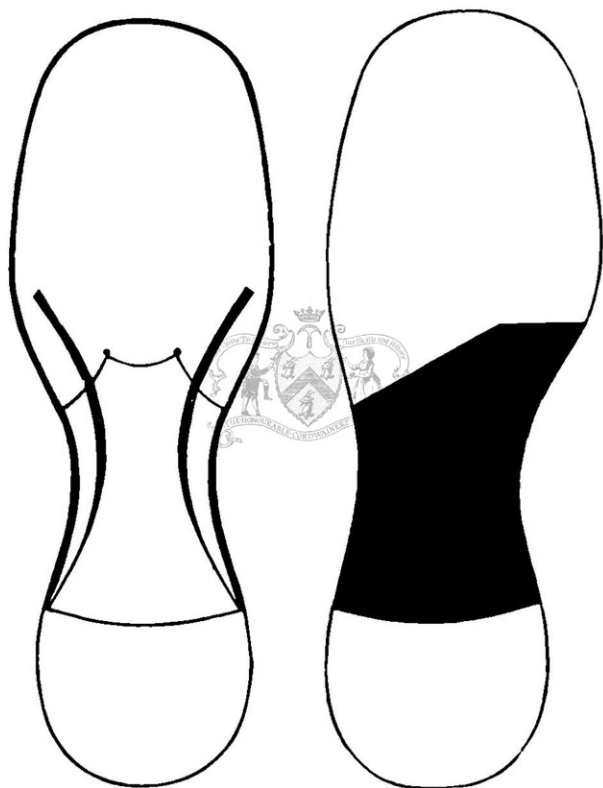


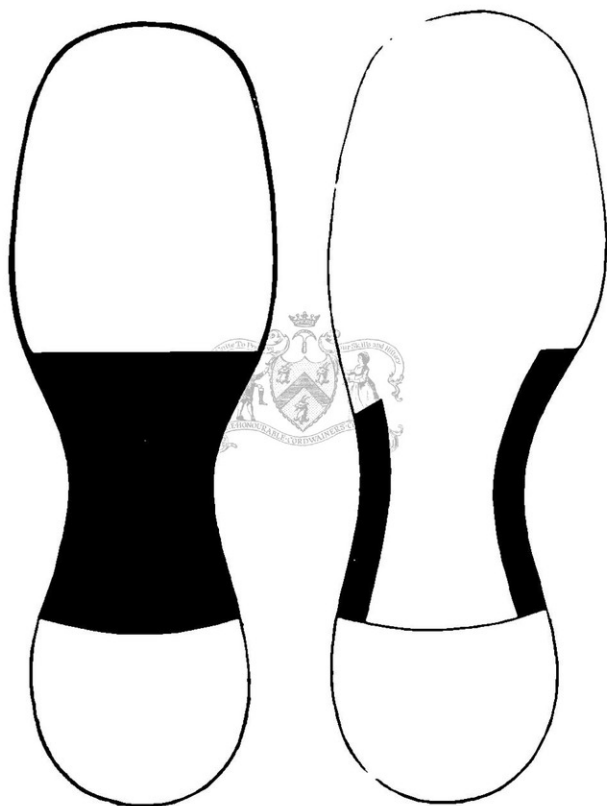


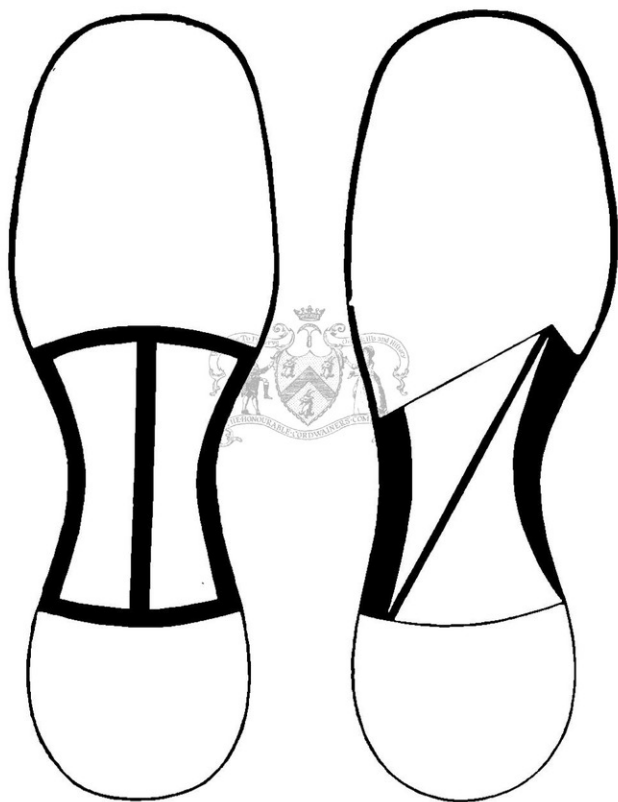


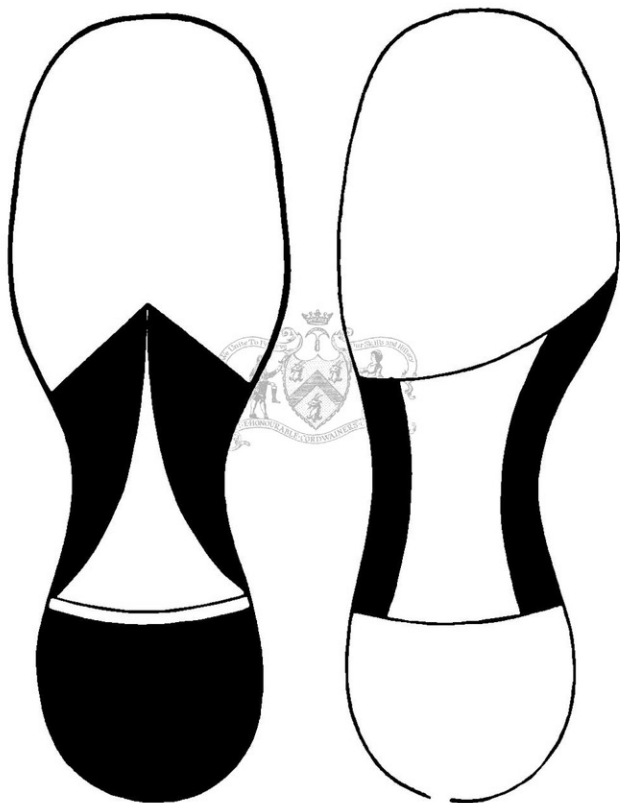


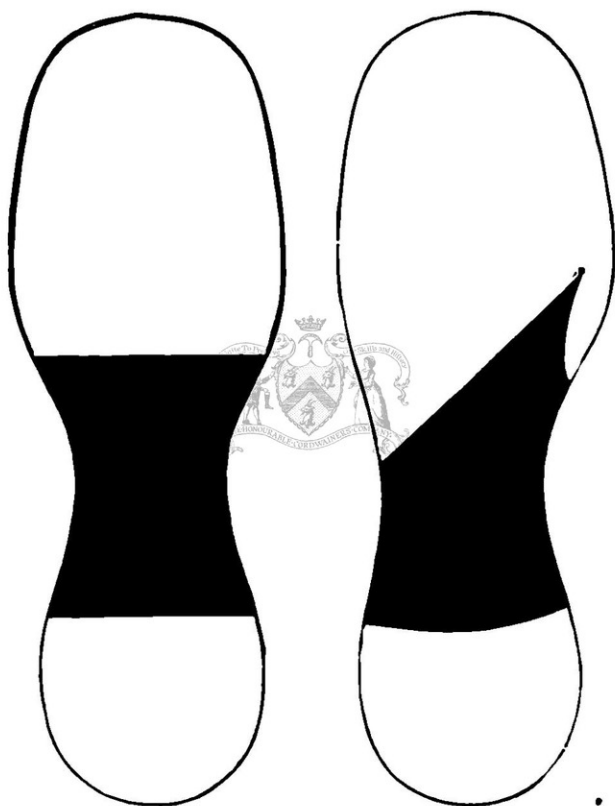


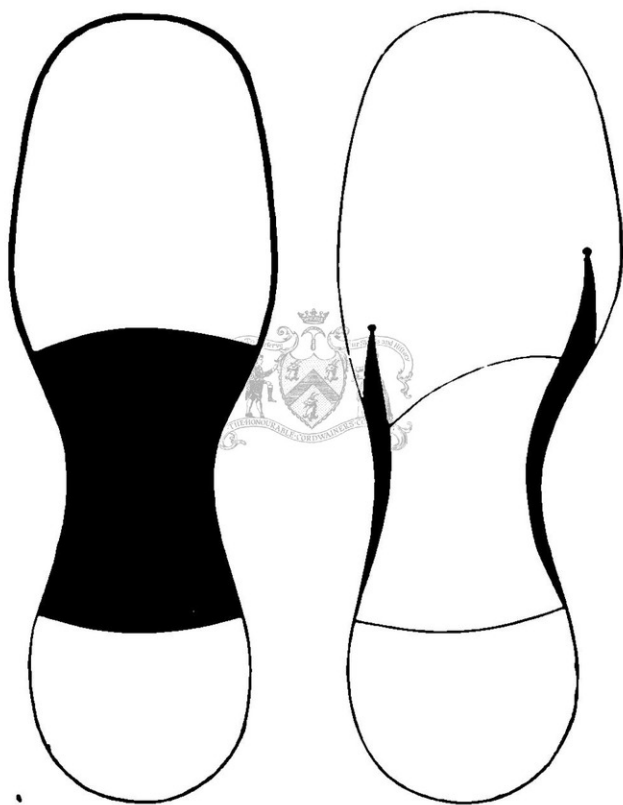


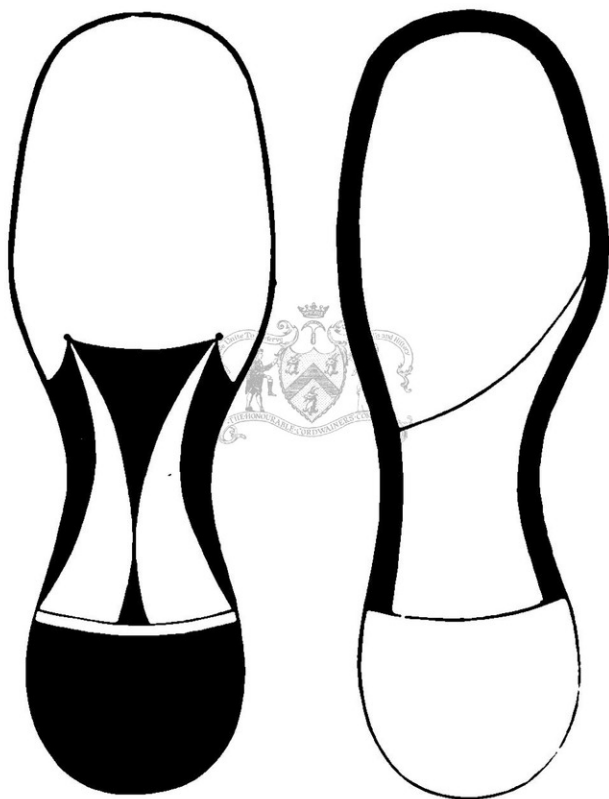


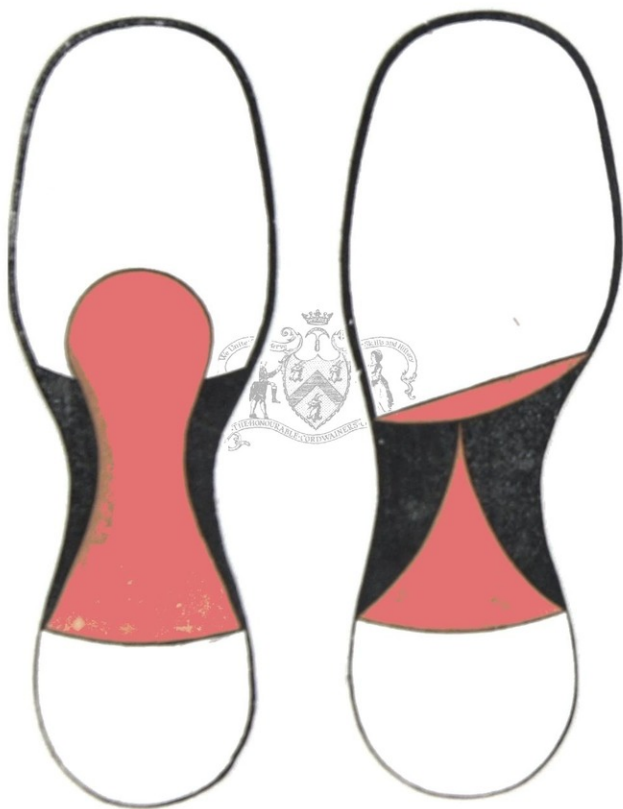


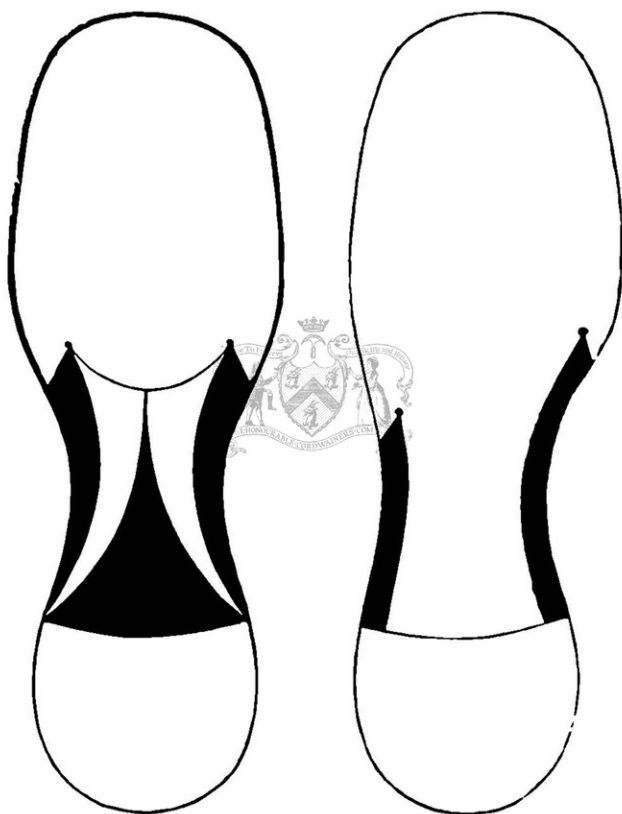


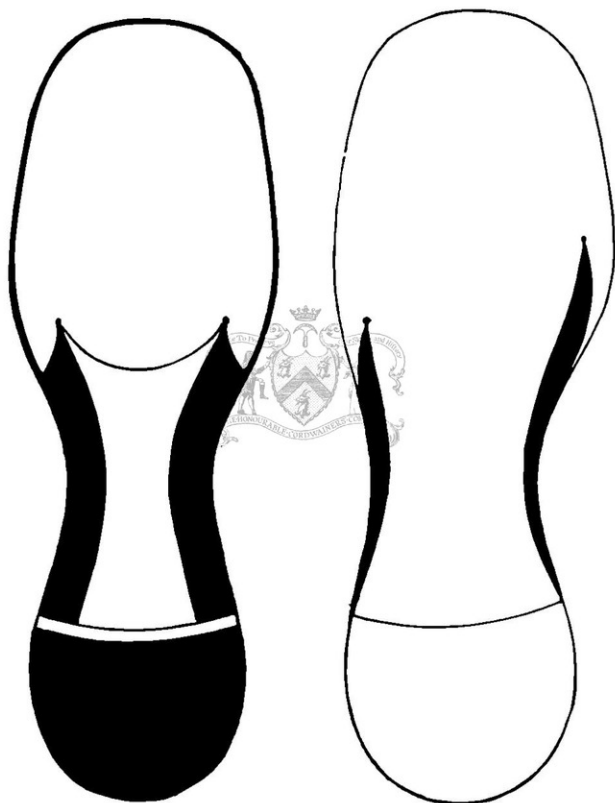


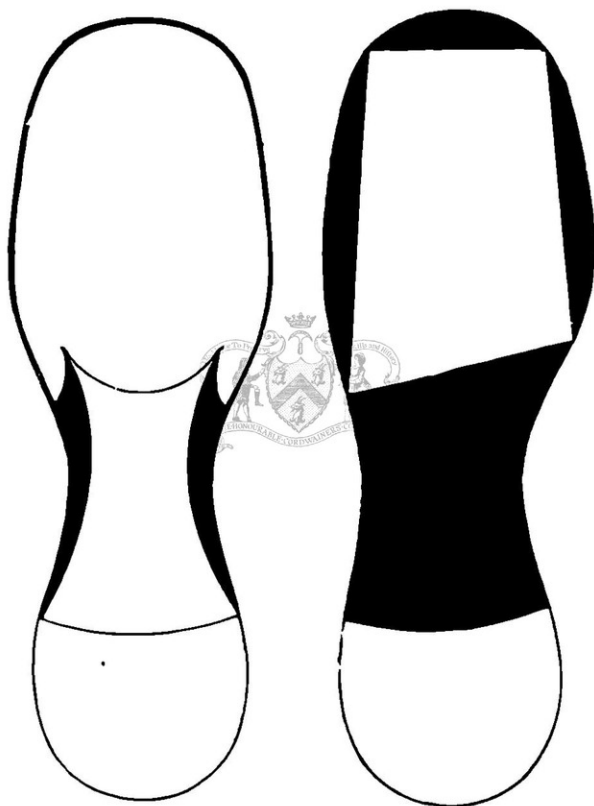


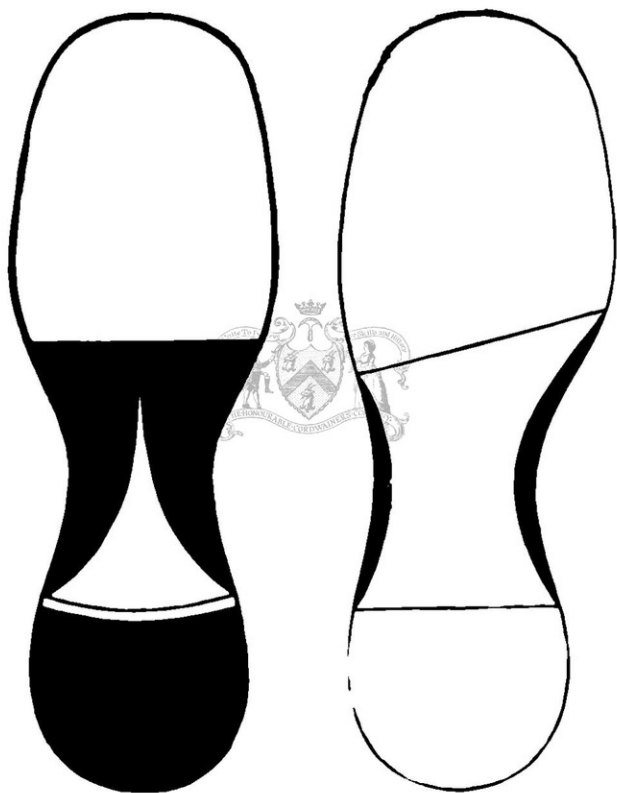


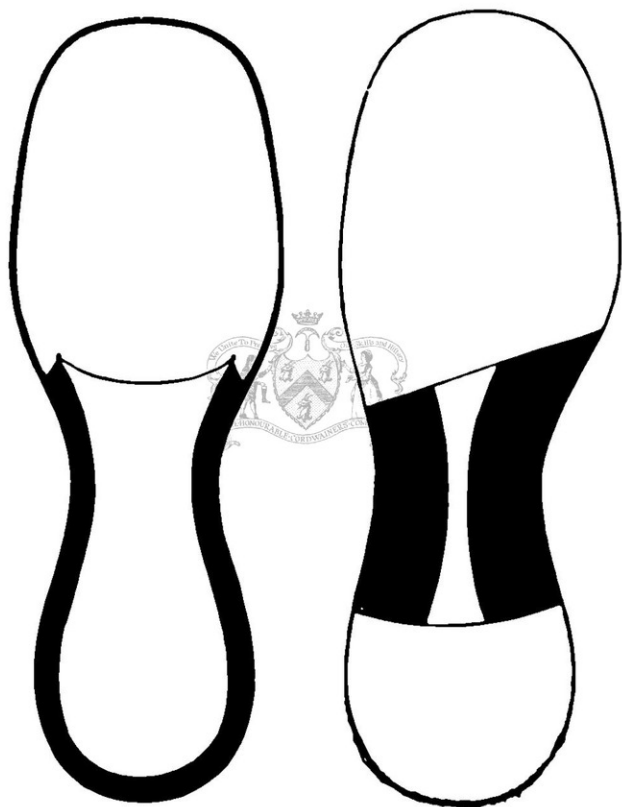


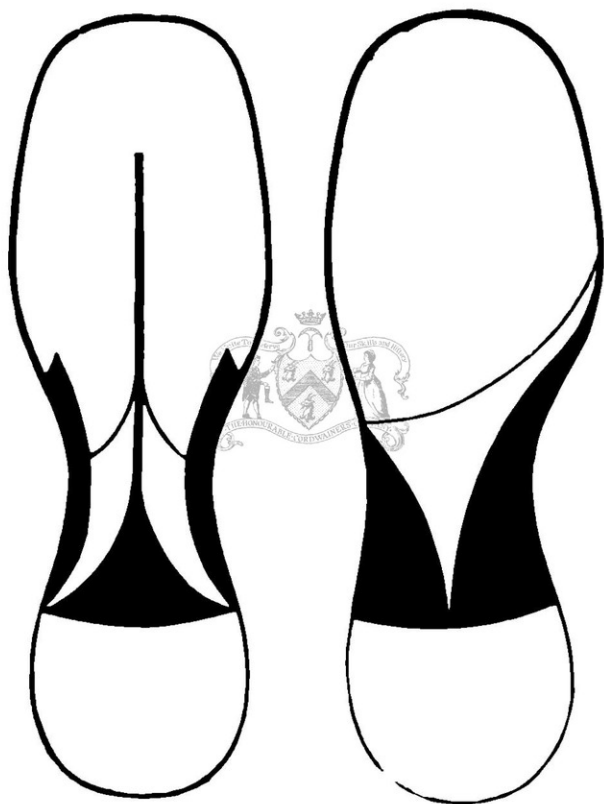


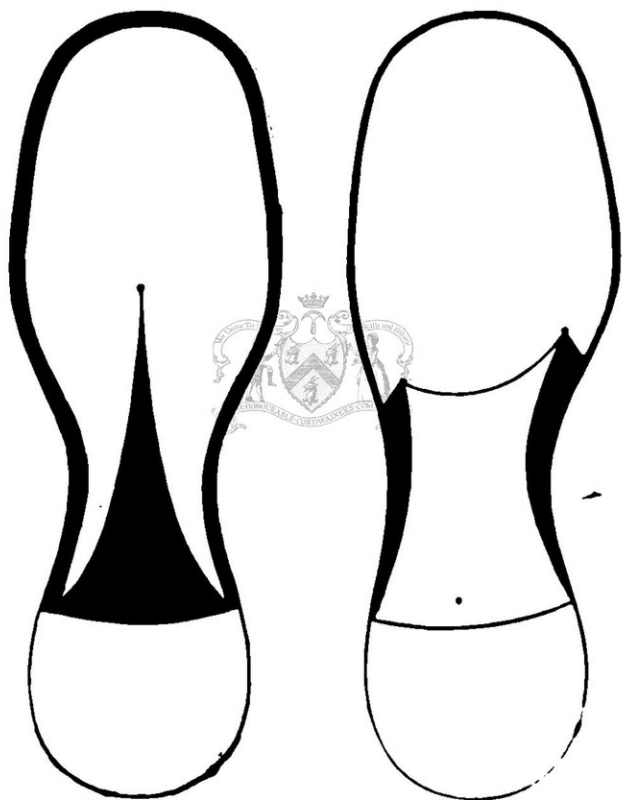




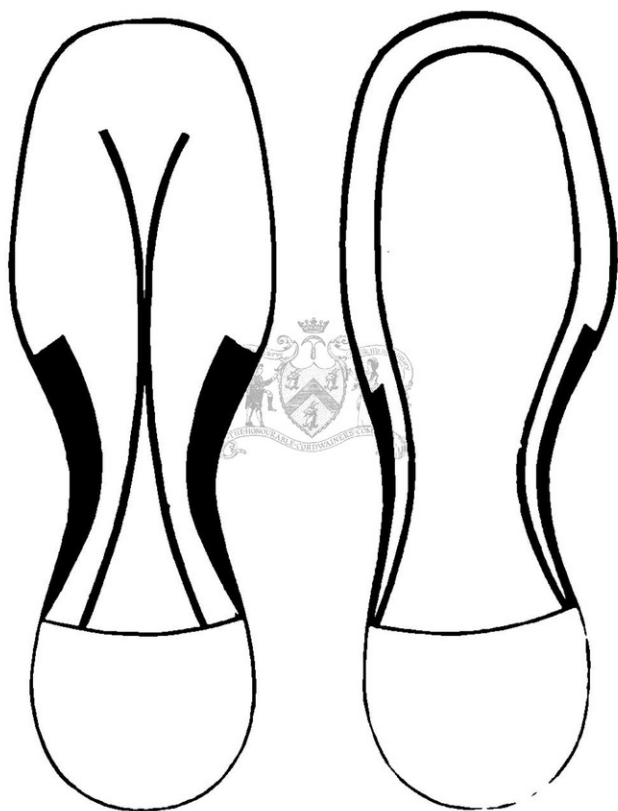


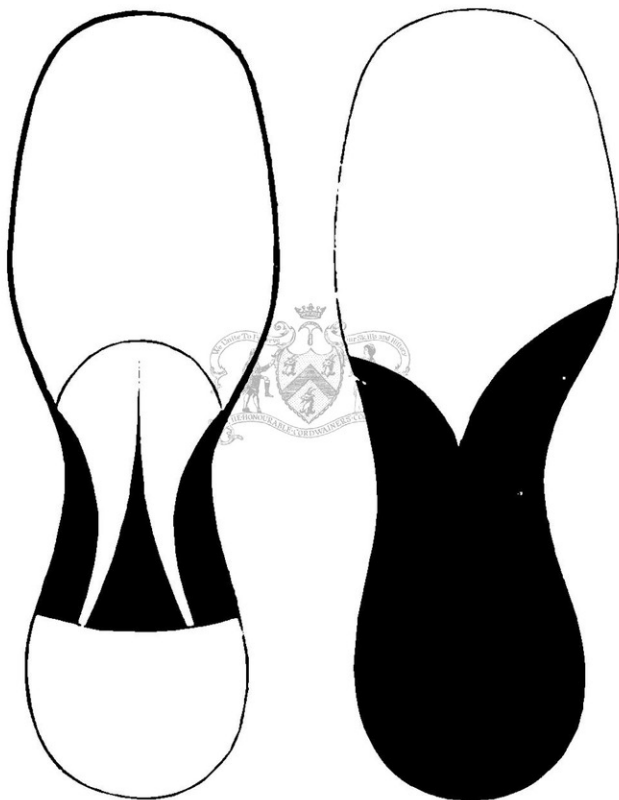


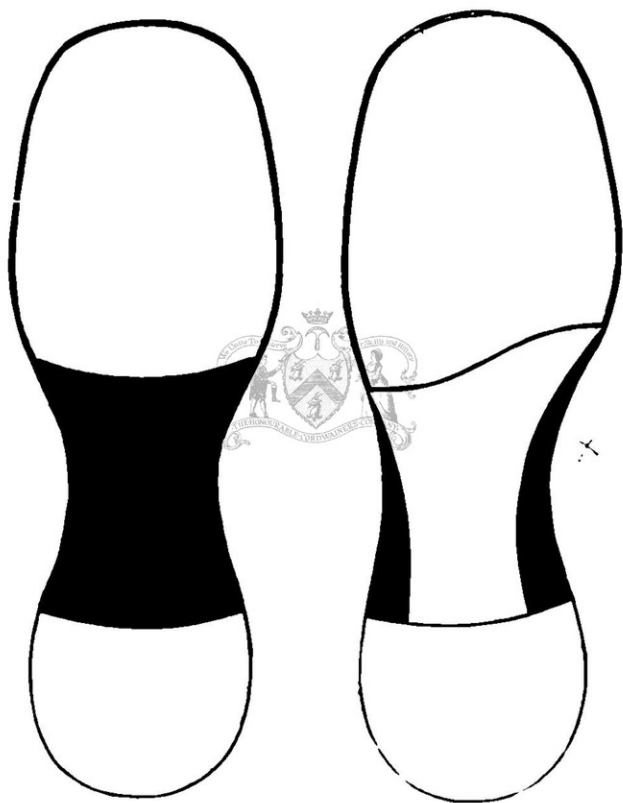


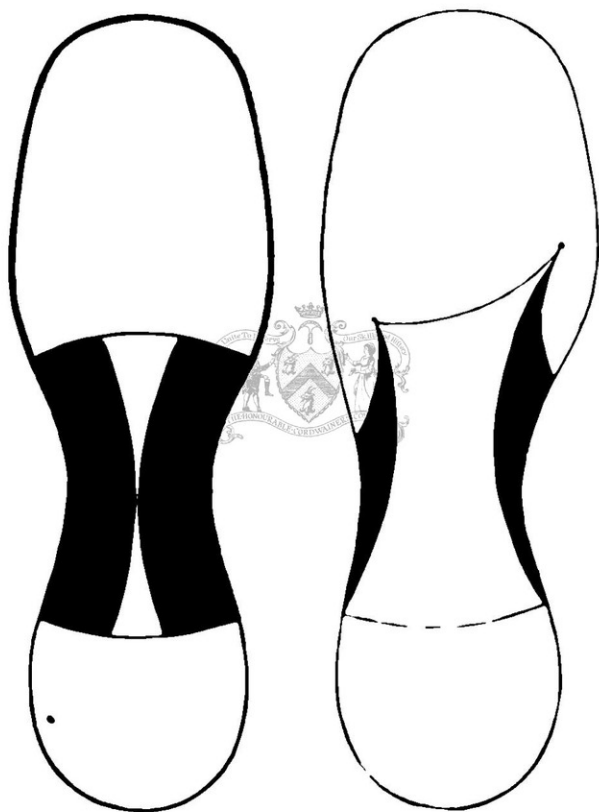


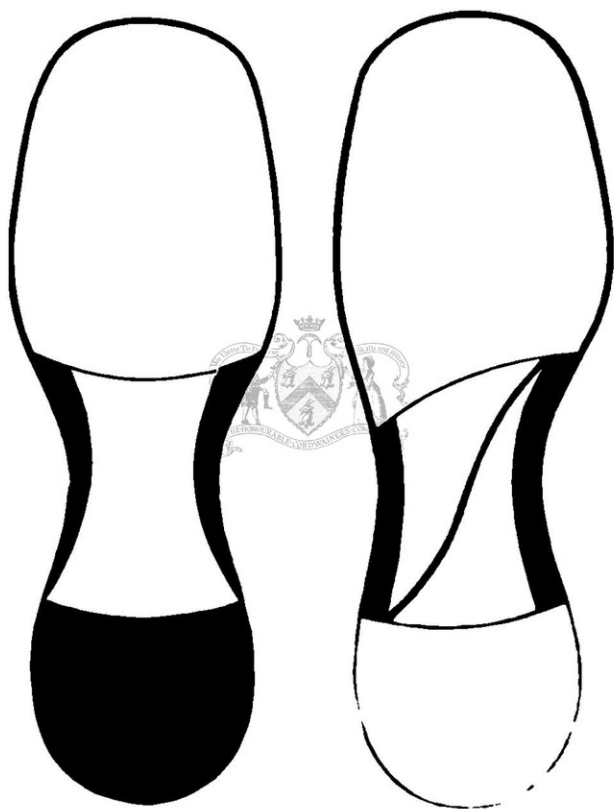


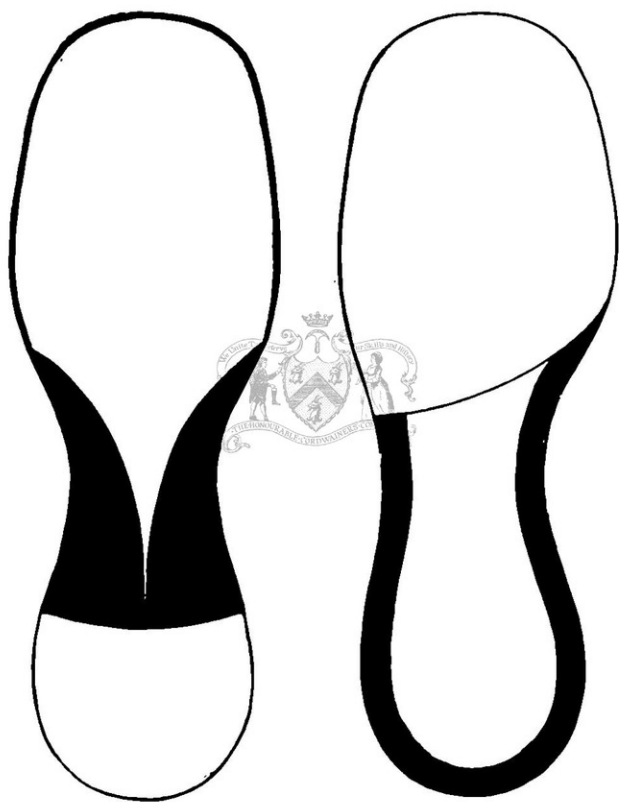


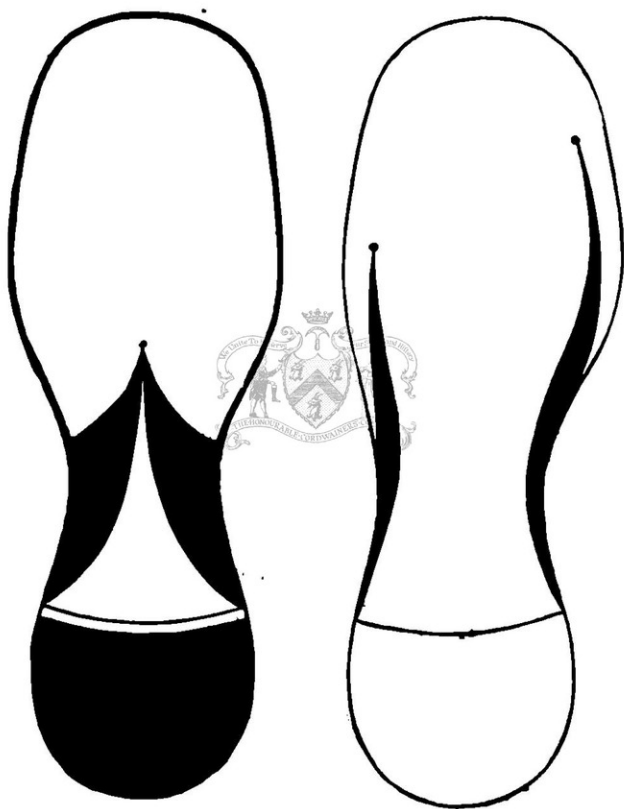




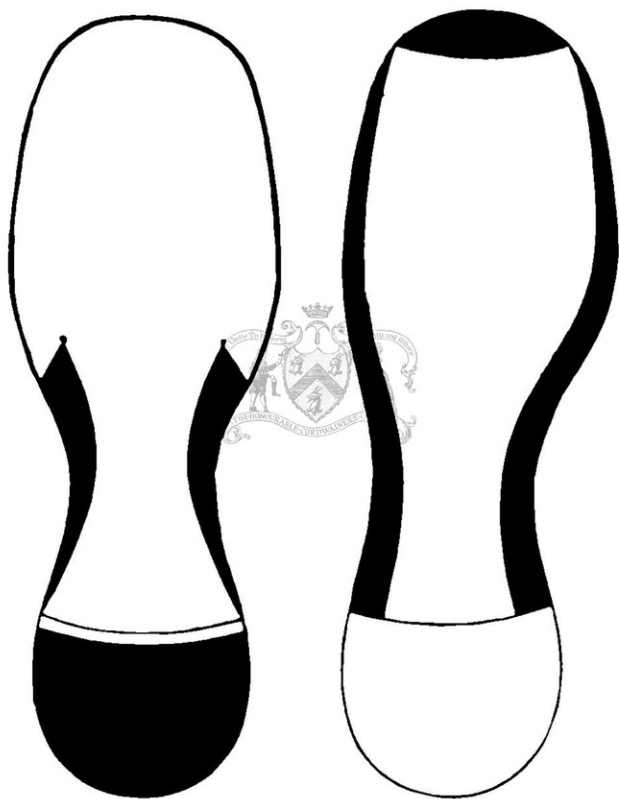


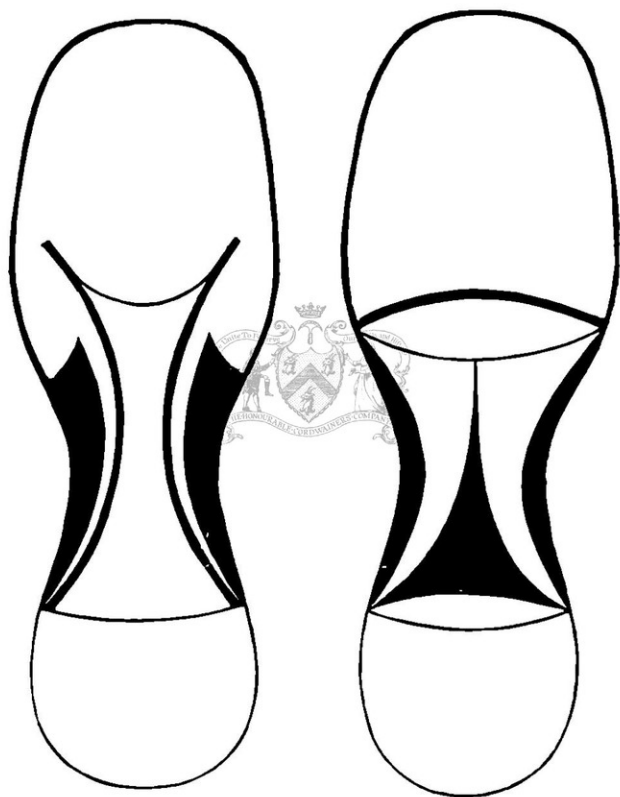


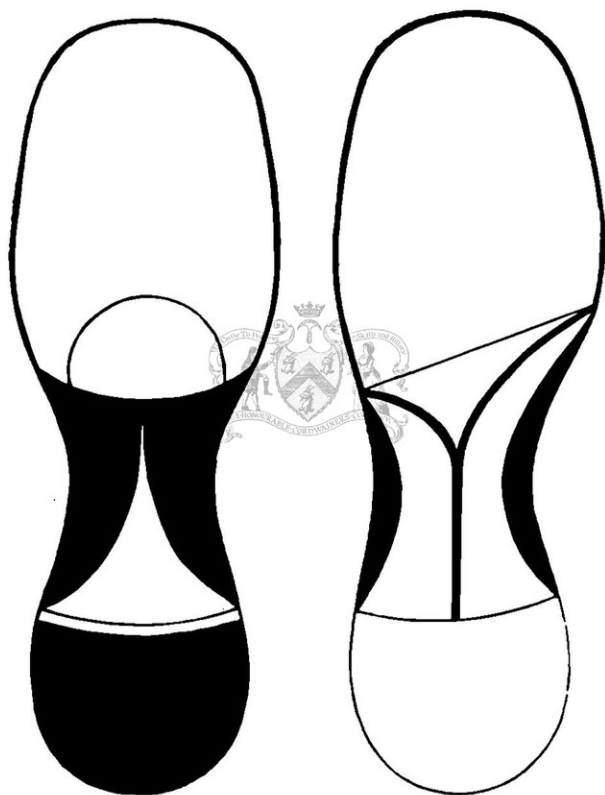


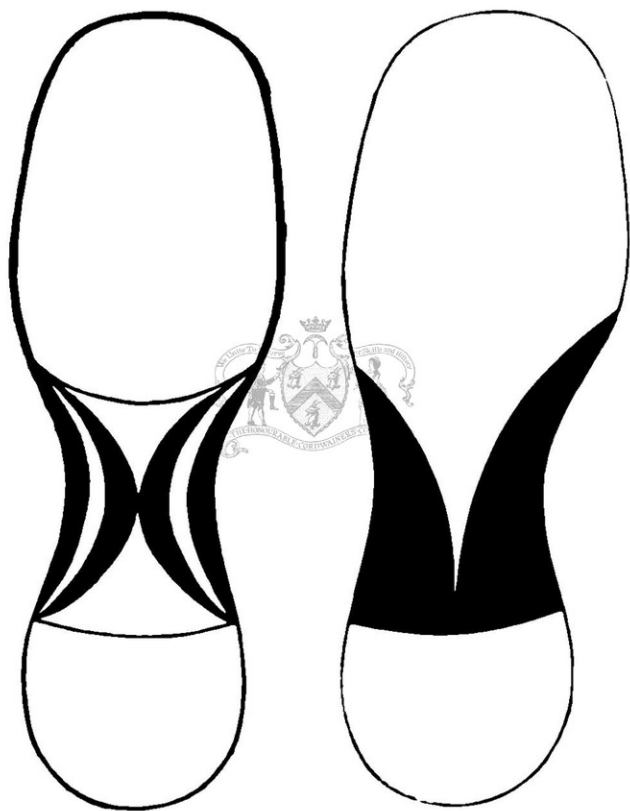


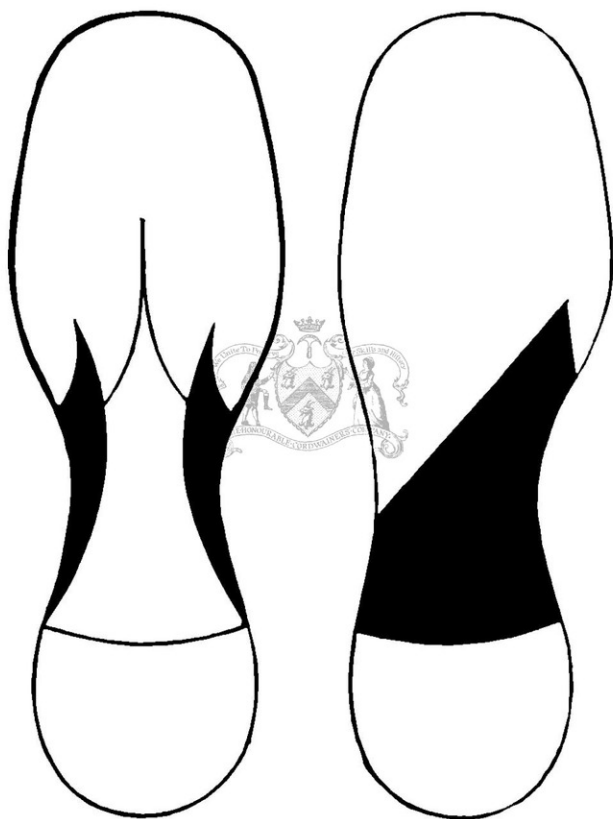


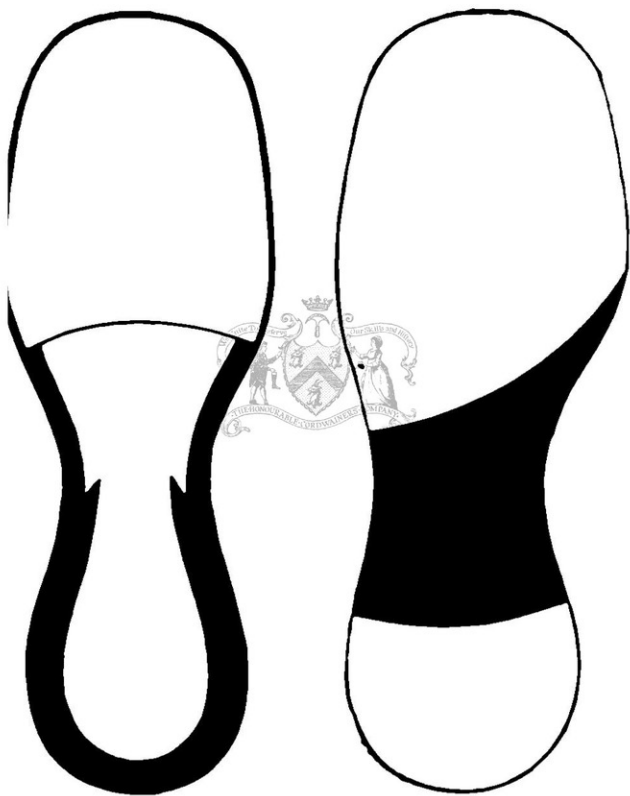


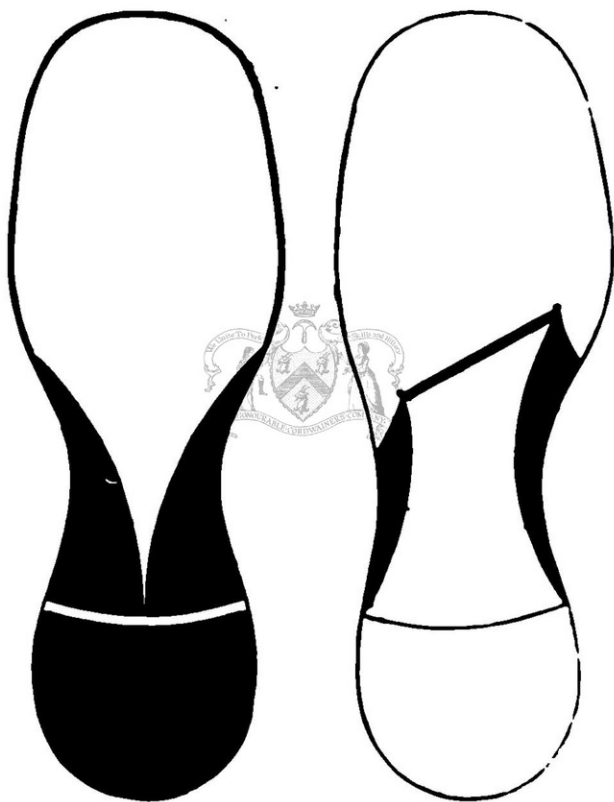


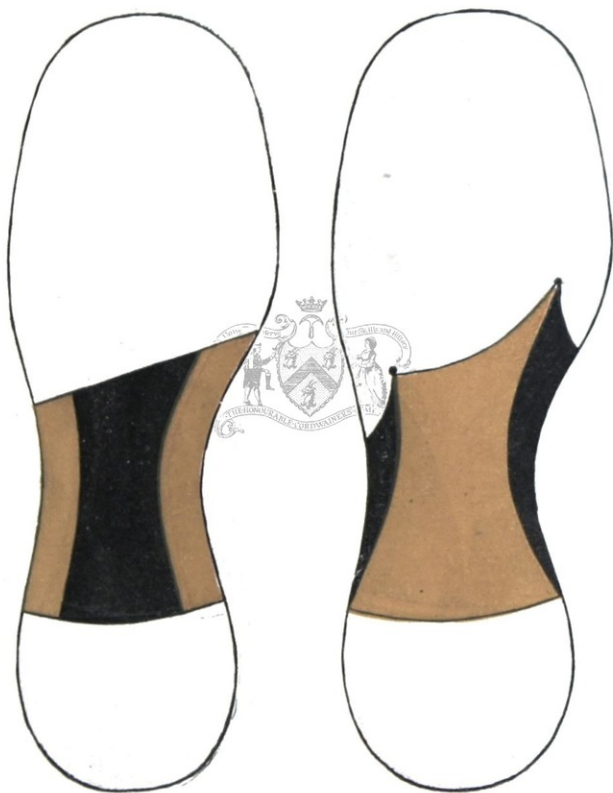


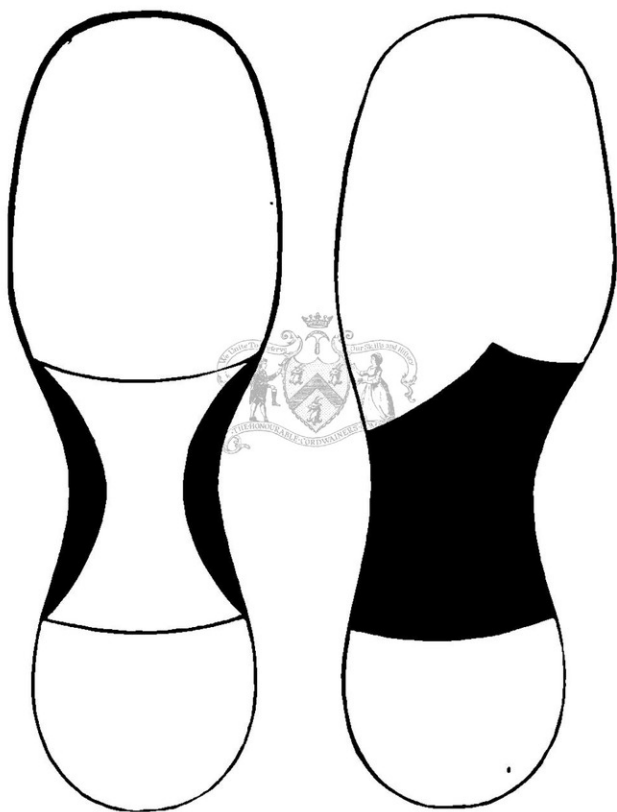


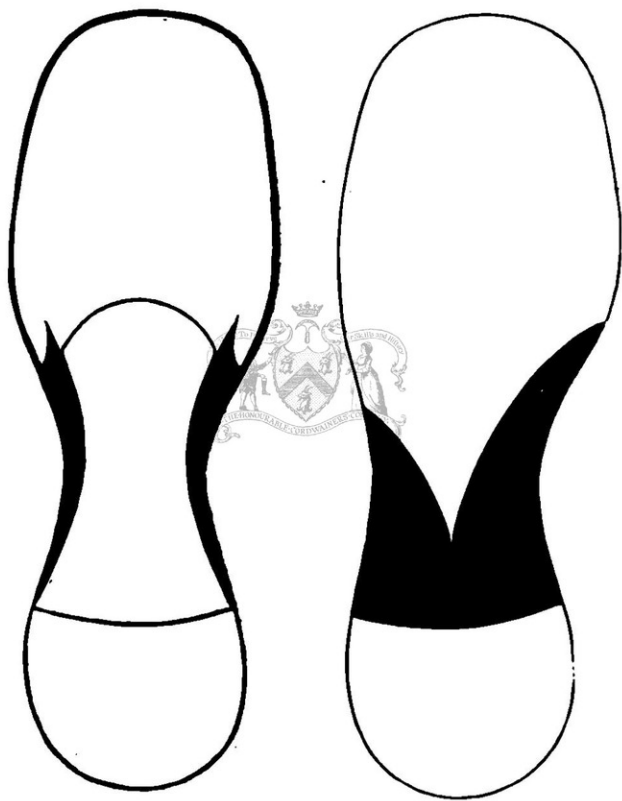


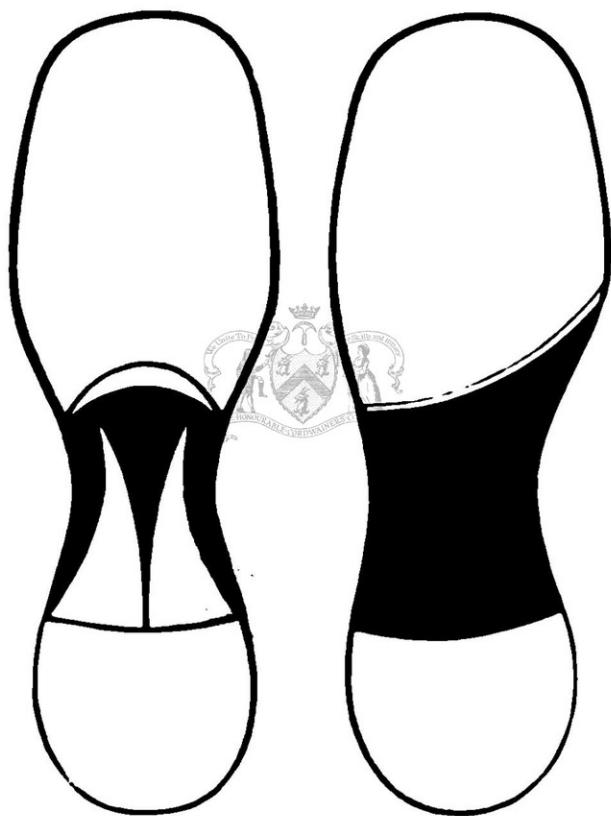


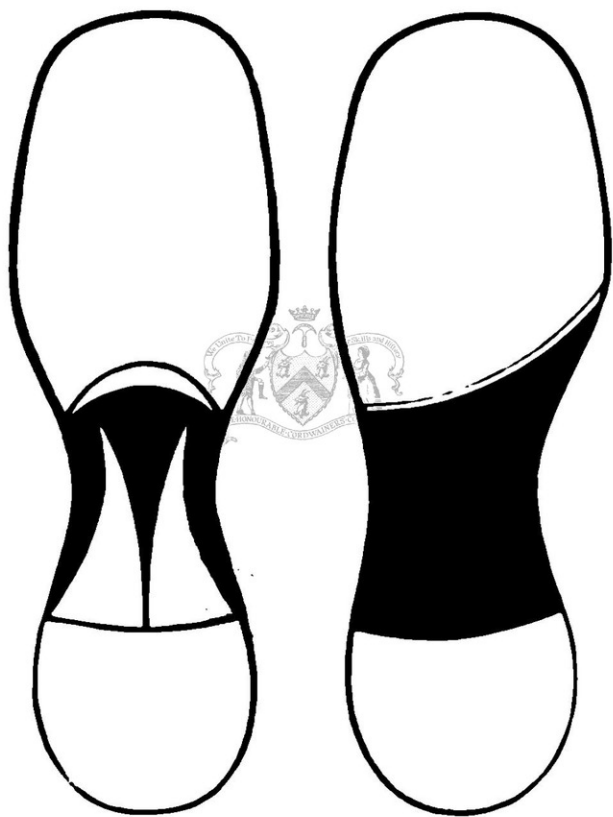


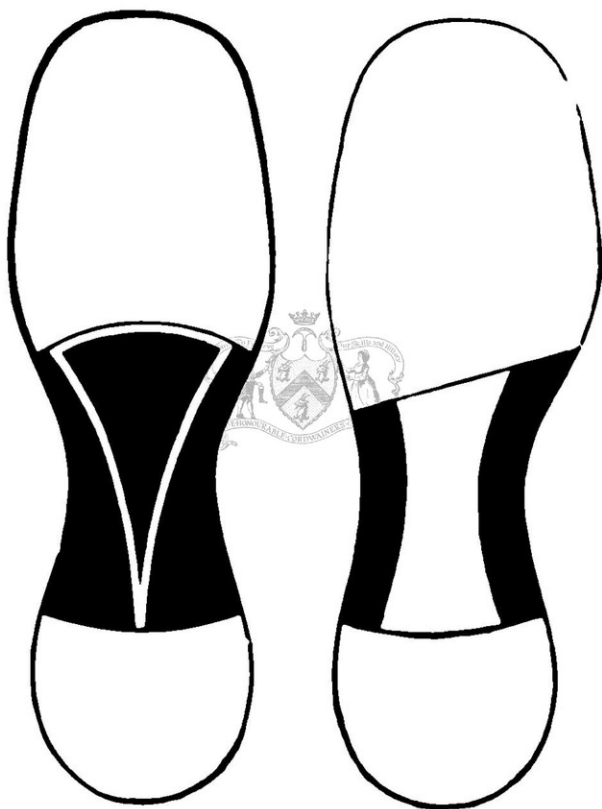


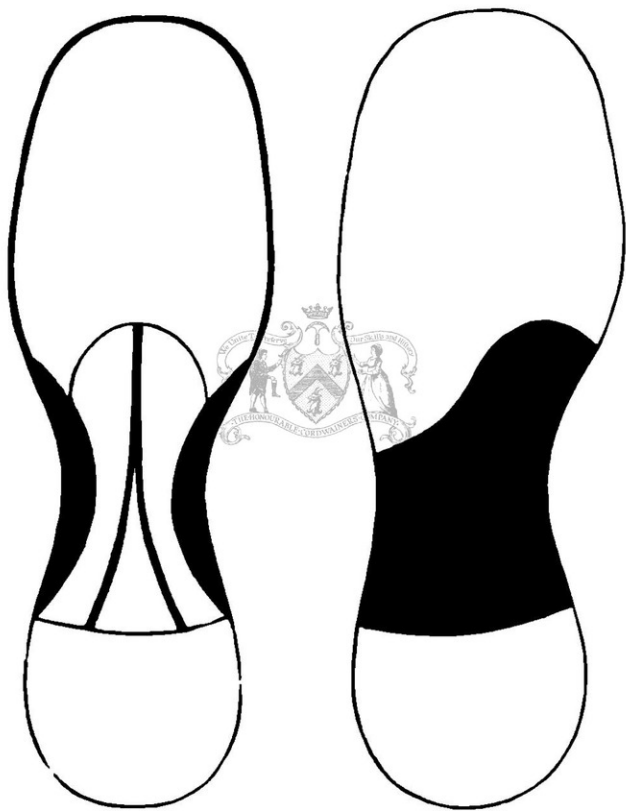


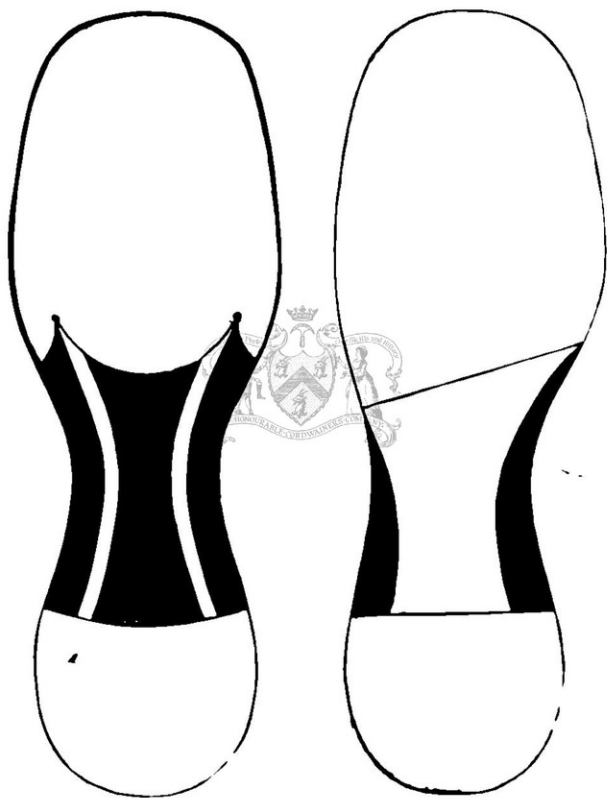


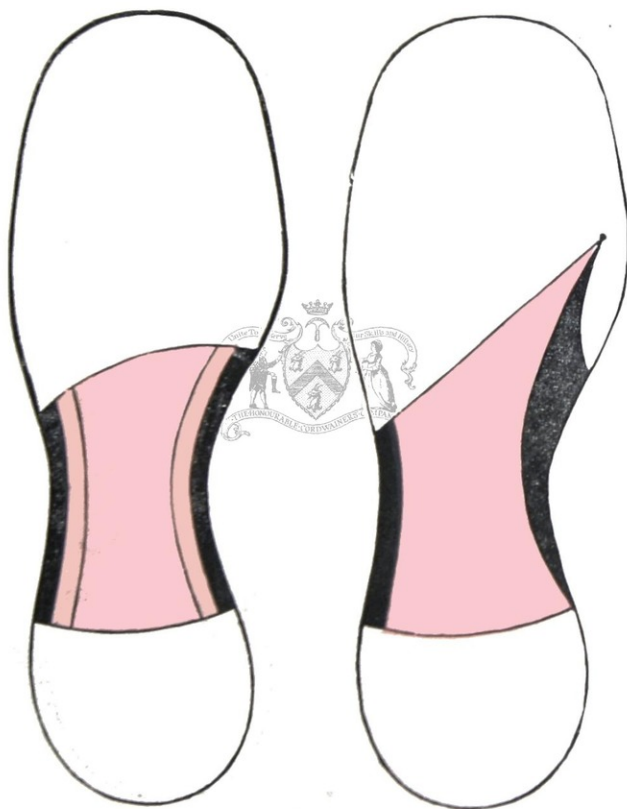


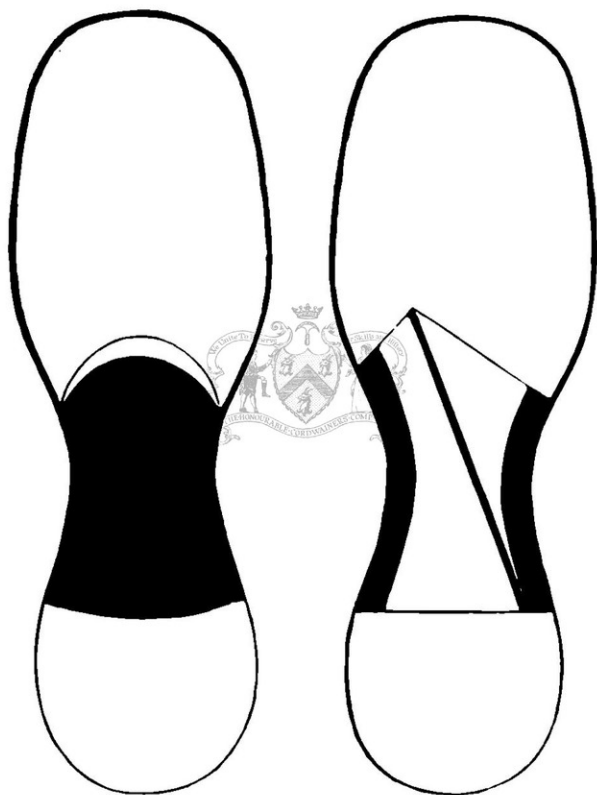


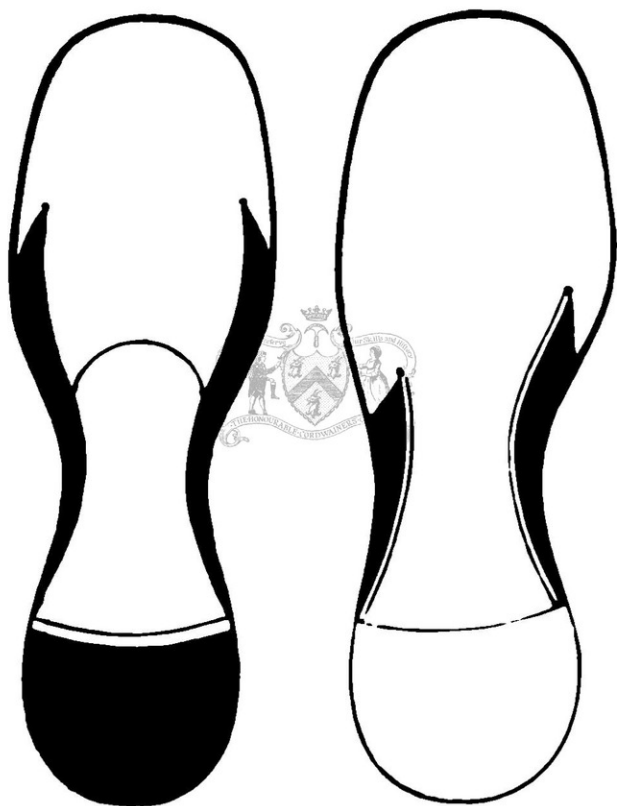


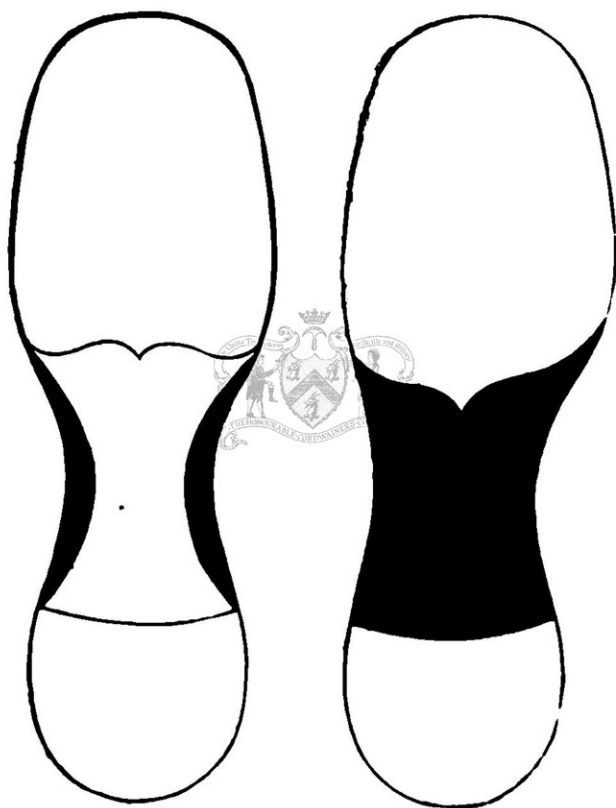


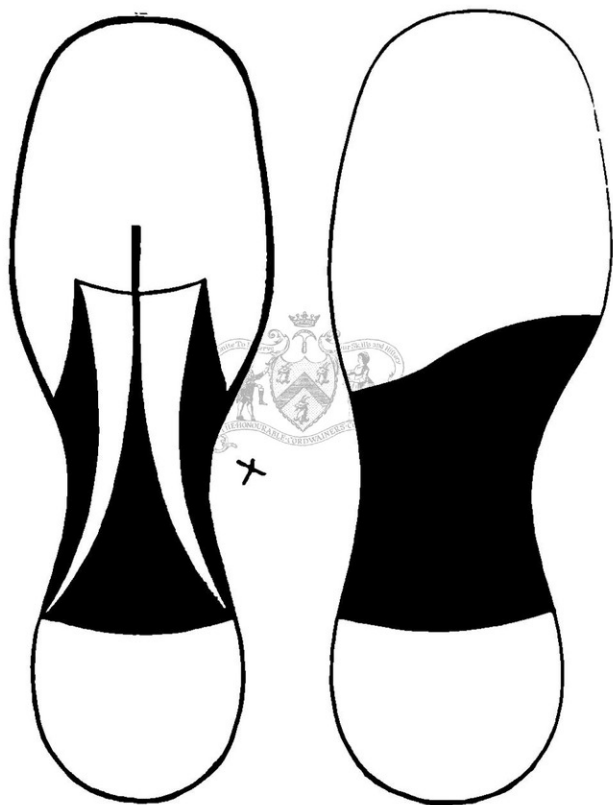


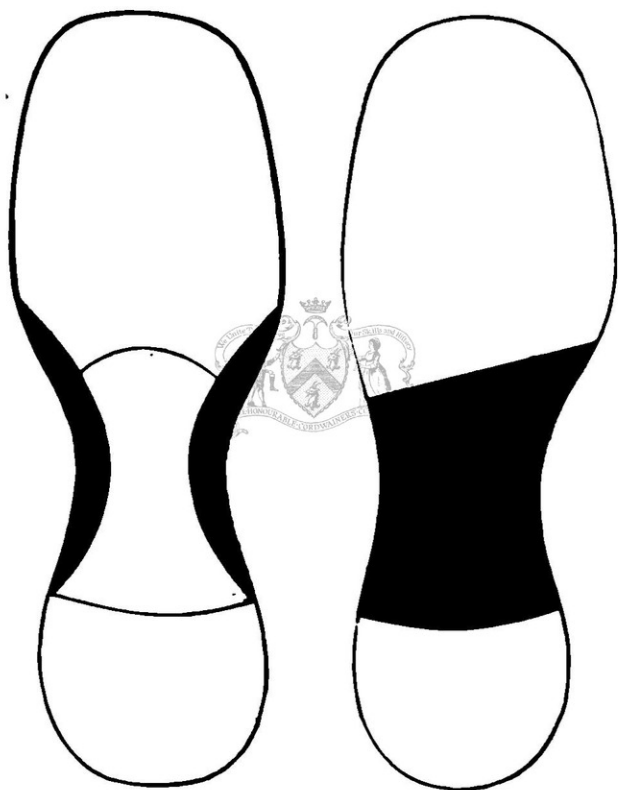


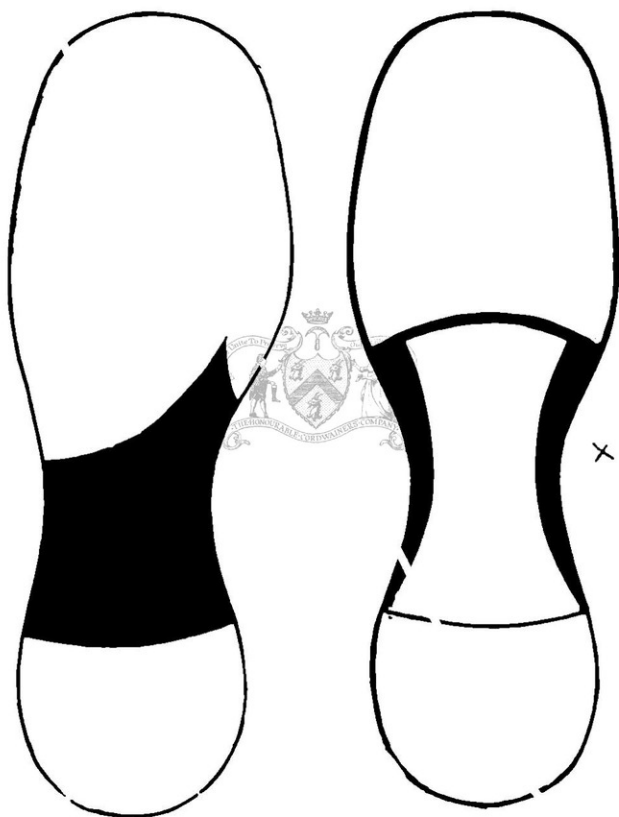


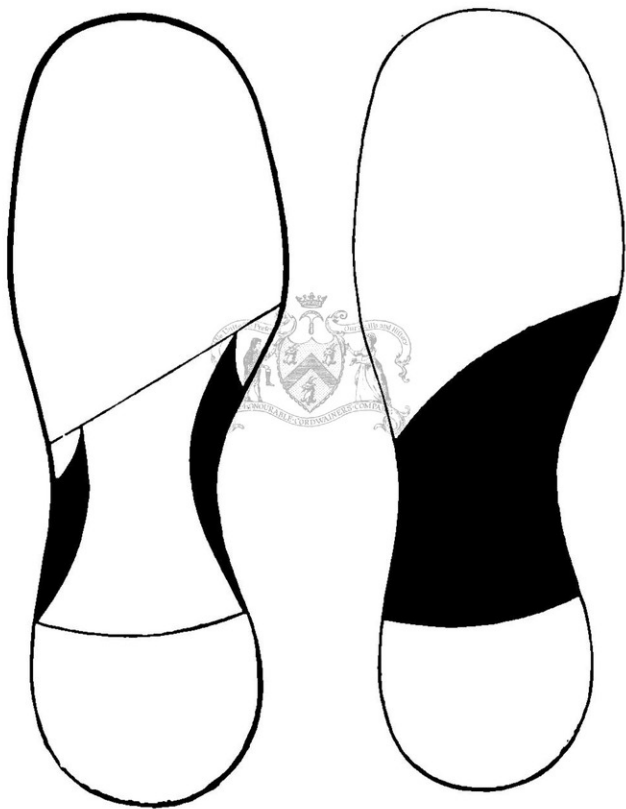




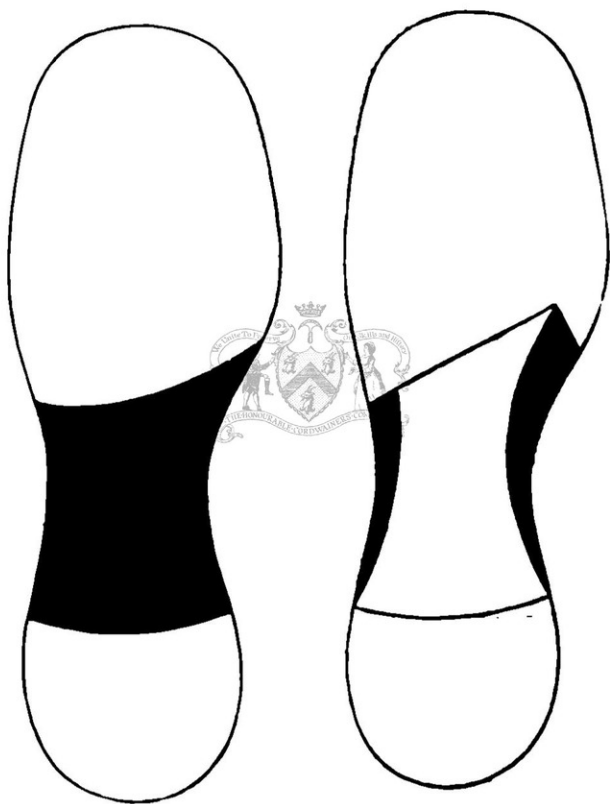


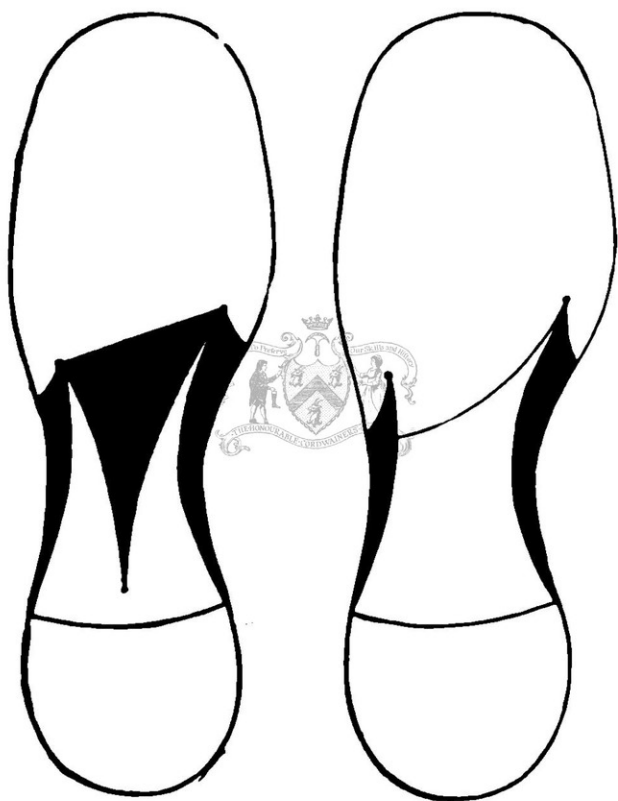


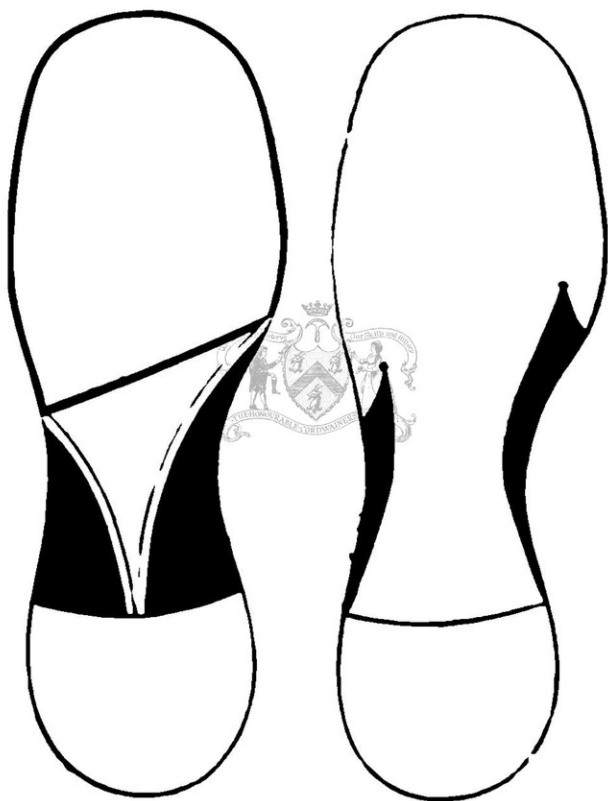


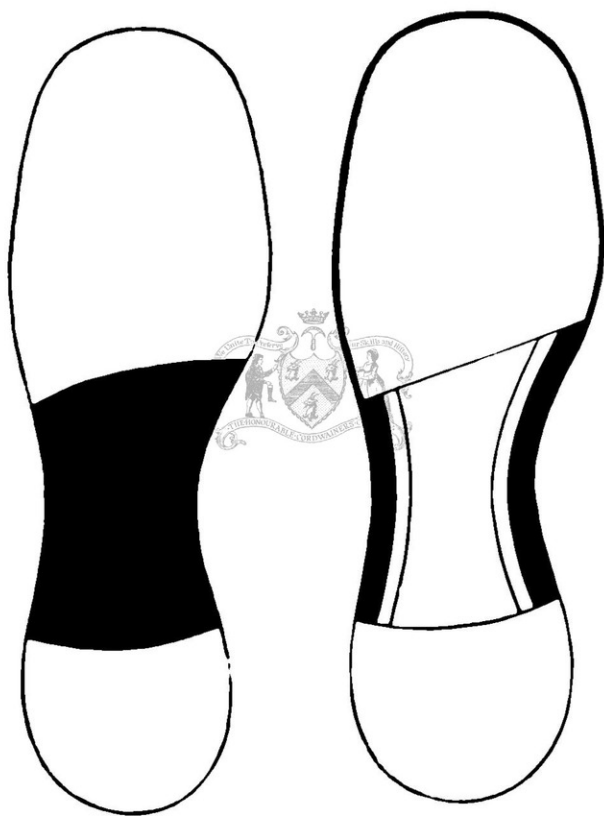


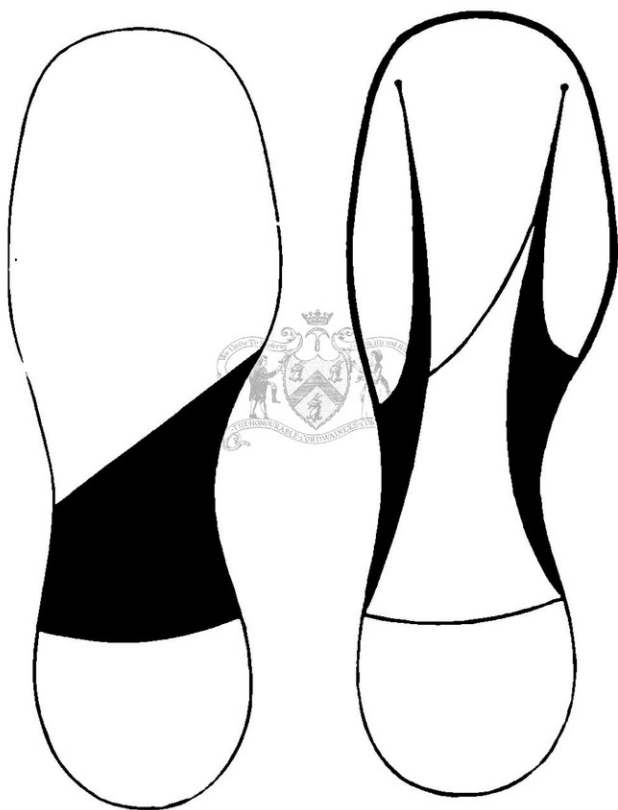


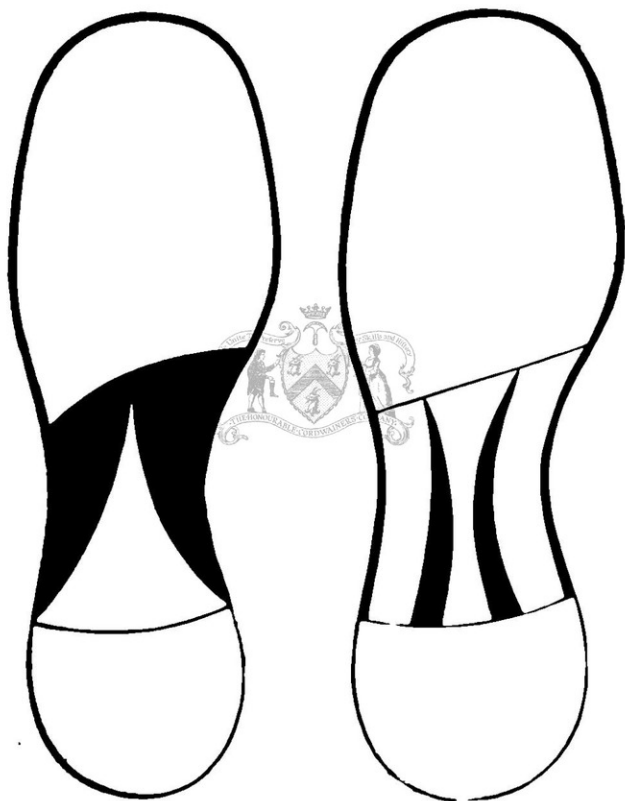


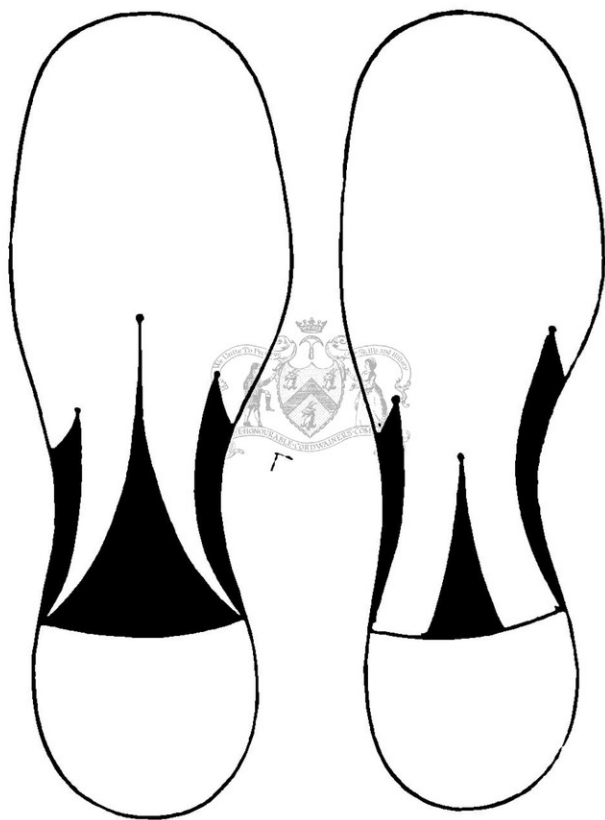




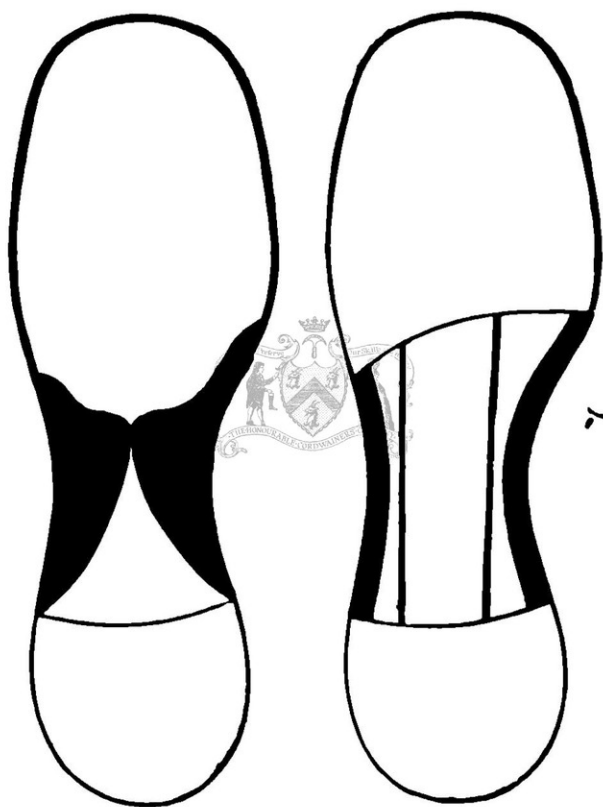


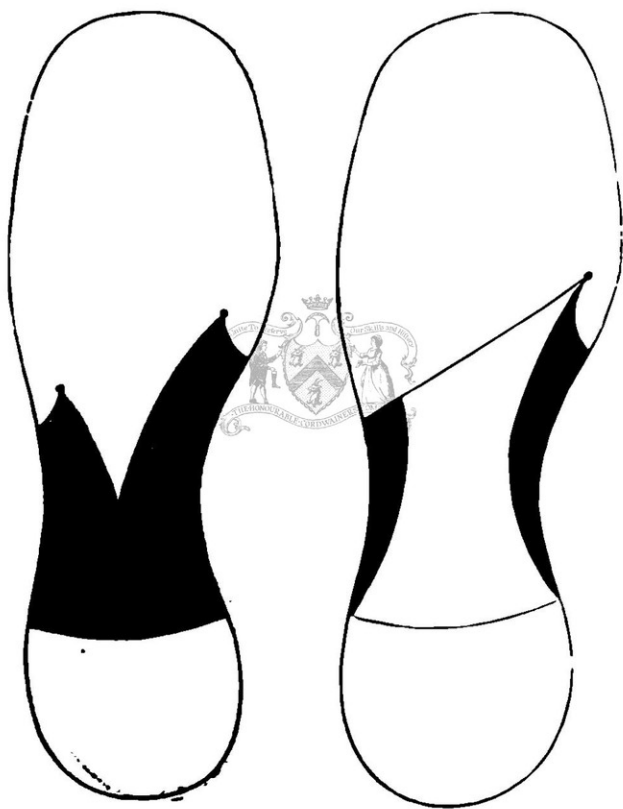


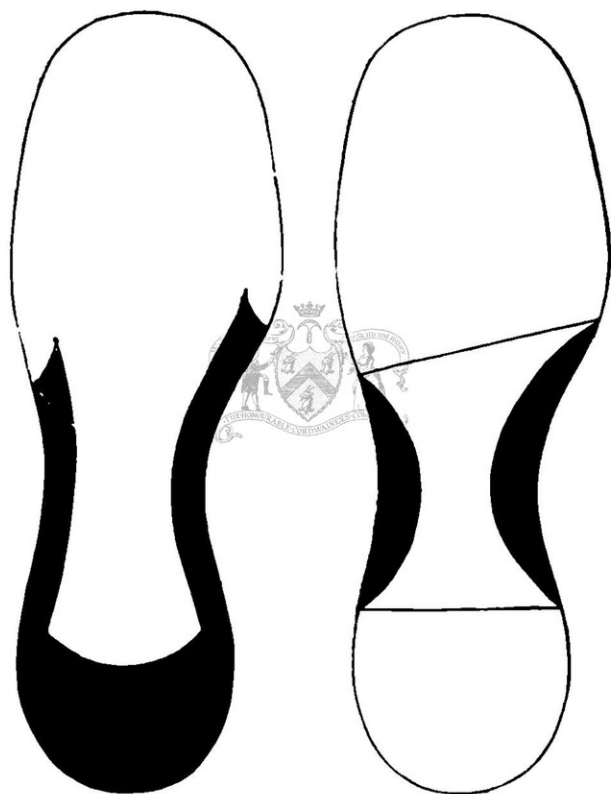


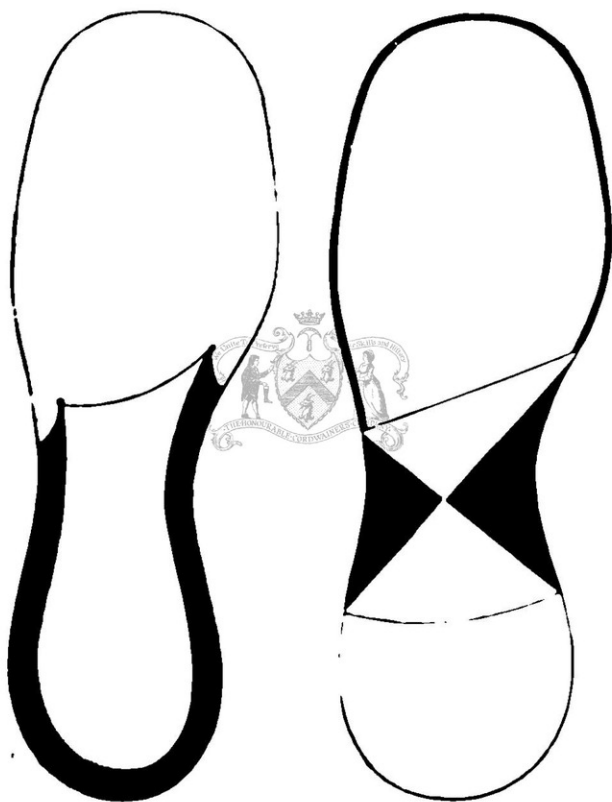


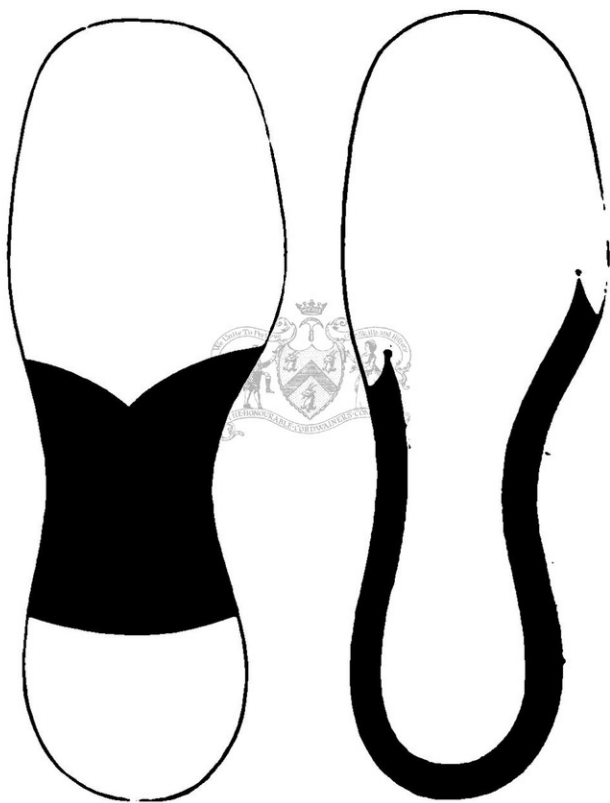


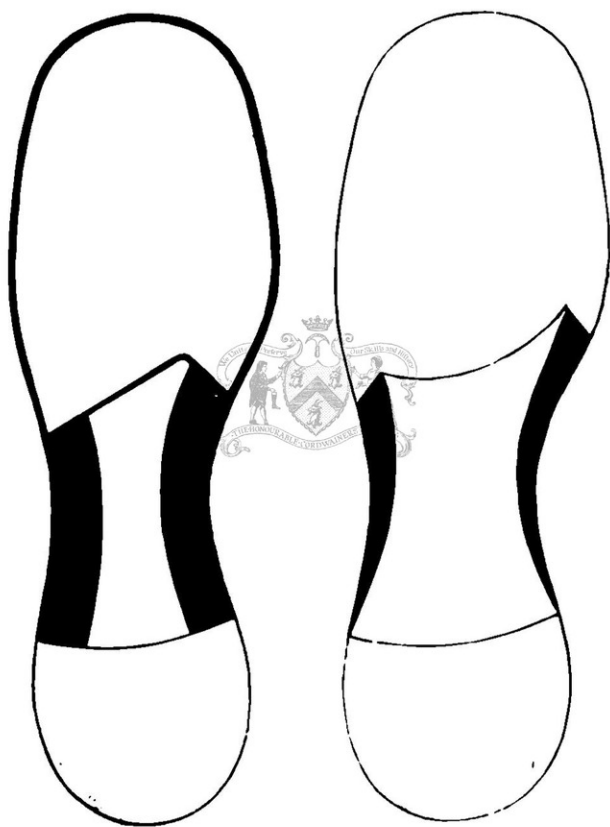


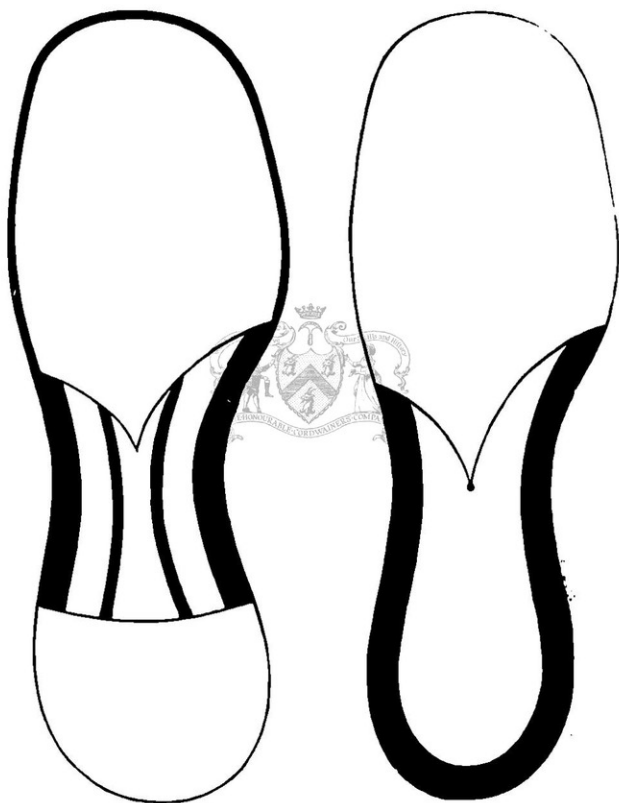


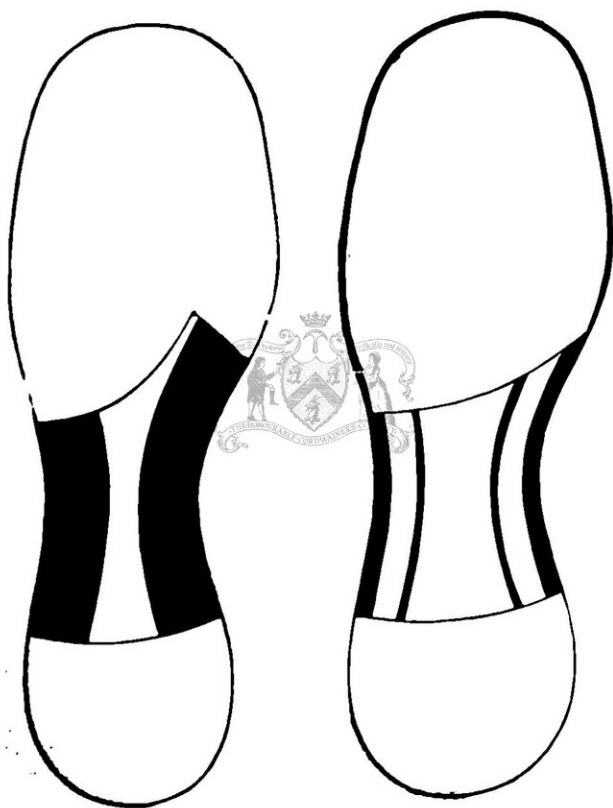


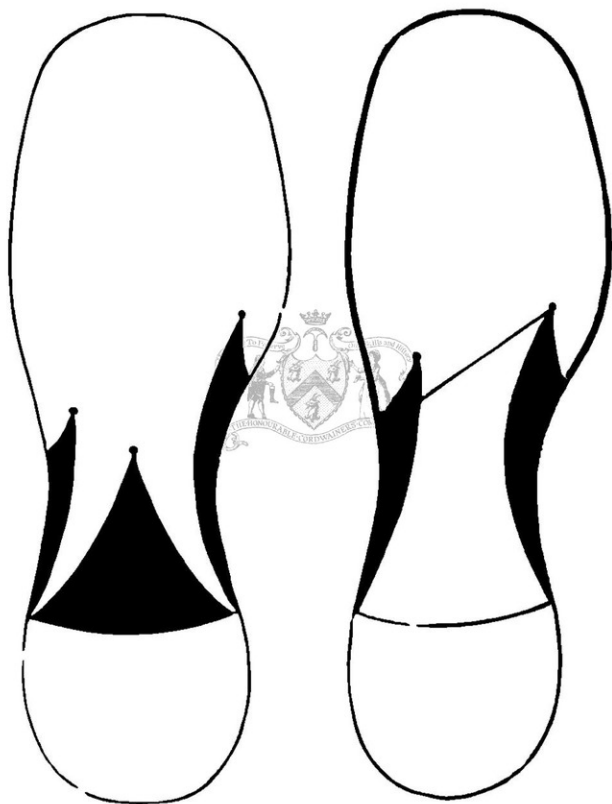


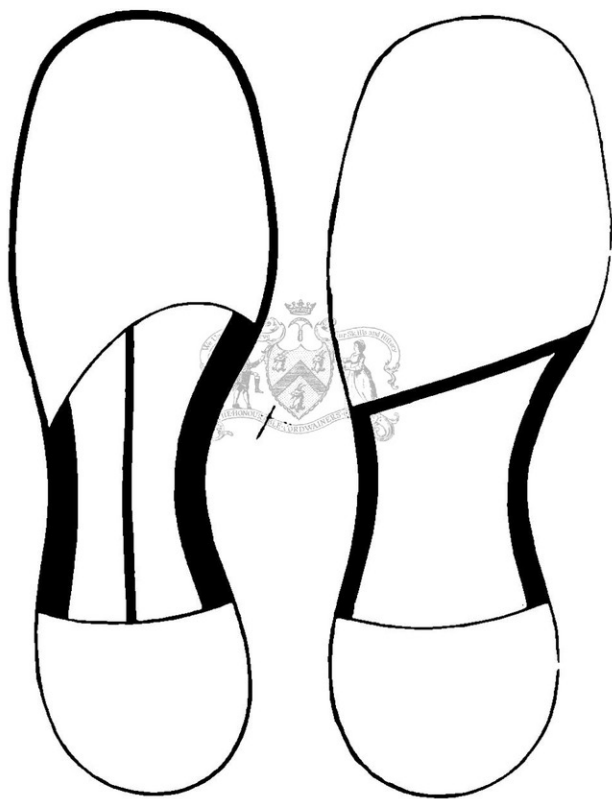


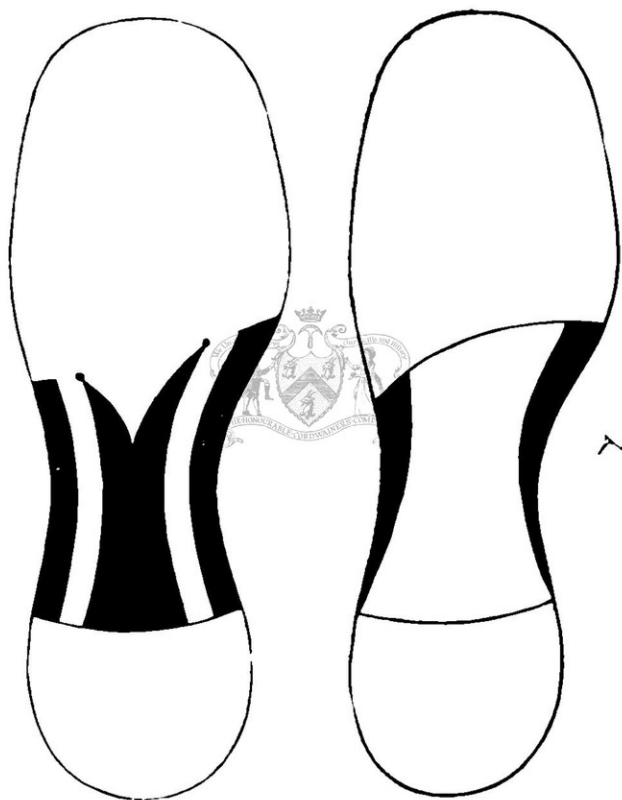


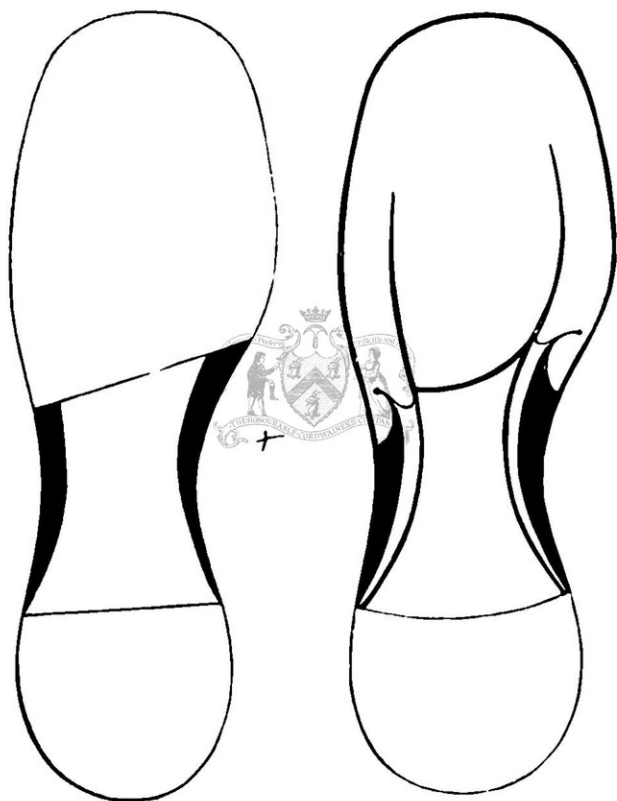


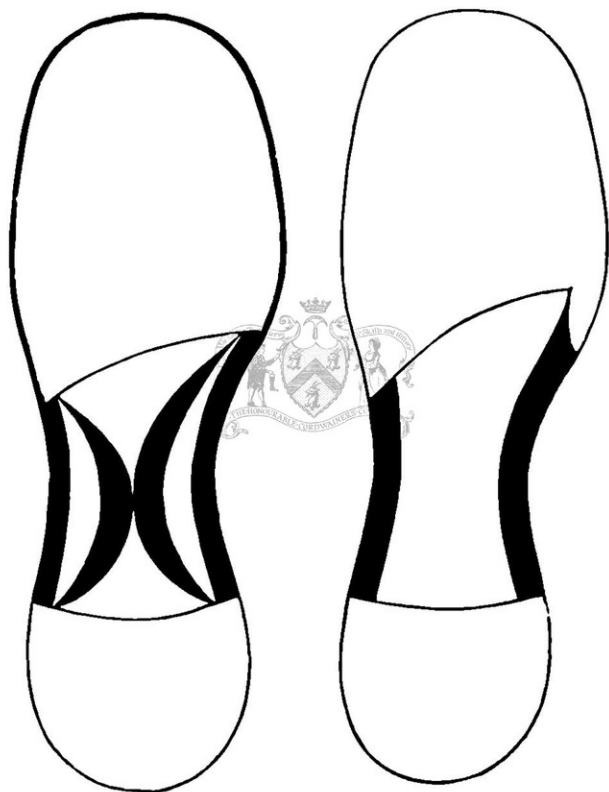


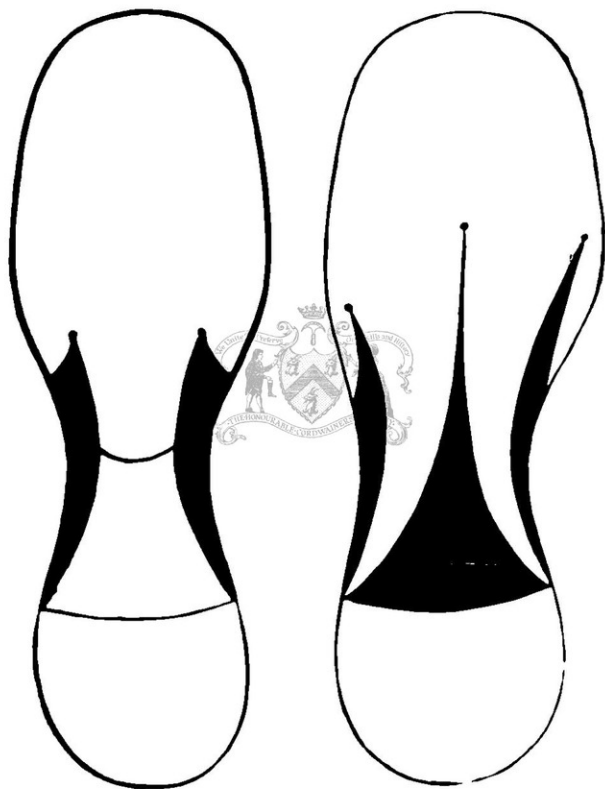














IMPORTANT NOTICE.



To commence with let me say that to be perfect is to excel, and so in workmanship "excellence is only given as a reward for labor." To illustrate, I have seen one of the finest workmen, one who could make from the rough a finely fitted and perfect fitting boot, but in the finish he was not able to even make a respectable showing. Of course, the boot would wear just as long as if finished perfectly, but one would not care to wear even a broadcloth coat without its being sponged and pressed, while it would wear just as long. So with finishing a boot or shoe, each and ever part should be well done, so that when finished the effect is a pleasing one to the eye. The following, taken from my Guide Book, is the proper way finishing bottoms.



* BOTTOM FINISHING OR CHANNELING. *



More care should be taken in this department than in any other; for the simple reason that unless the work is done in a workmanlike and creditable manner, the other parts previously done are made to look inferior, no matter how much care may have been taken with them. I find it to be most desirable, when it can be done, to have the finishing room separate from the rest, except that the Tapley Heel Burnishing Machines are to occupy the same room. This department is as much different from the rest of the bottoming room as that is different from the upper cutting department. I refer to string work. as rules for finishing by hand will be given hereafter. There is not a part of shoe manufacturing that requires such perfect cleanliness as this, and for this reason the bottom-finishing should be kept apart from the rest of the work.

There has recently been made some improvement in burnishing irons for shank panels, made from cast iron hardened. A good supply of the different widths of brushes for applying stains is necessary. There is now being placed in the market a new Shank Burnishing Machine, for black shanks, top pieces and side stripes or panels, which is meeting with some favor.

The proper management of this department lays a great deal in the skill of the finisher: neatness and cleanliness should at all times be enforced.

Have the workman who cleans or sandpapers the bottom by hand as far from the others as possible; have him use a sand-card covered with sandpaper No. 1. After he has taken off the rough part, smooth over with a piece of fine emery cloth (No. 120). The Naumkeag Buffing Machine is used very extensively in the larger factories for cleaning bottoms after being buffed on the Buzzell or like machines, and is a valuable acquisition to the trade, doing the work much better than by hand.

Have the uppers well brushed before giving them to the cutter, or to the workman who puts on the hard bottoms or shank colors, the latter part of which I shall write separate directions about; for I wish here to state that I think one workman to cut all the bottom designs as much the best way, as it gives to the shoes one style and a uniformity which is impossible to obtain by having different cutters, or each man to do his work through a case of shoes. Then again, if there is work enough, say from six to ten cases per day, have one workman do nothing but burnish while another keeps the channels blacked and in temper for him. Never allow the use of steel burnishers; use cast iron as they do much better work.

I will divide a team of workmen who ought to easily accomplish from six to nine cases per day, sixty pairs to the case, taking the shoes after the buffer has finished his part: —One man to clean or sandpaper the bottoms; one channel cutter; one man or a first-class boy to apply the stains; one man to burnish and one boy to black for the burnisher, stamp the monogram and clean the uppers. with what help he can get from the cutter, as six, eight or ten cases per day is not enough to keep an average cutter busy. Should only two workmen be required, one may clean the bottoms, apply the stain, do the stamping and black:

the other to do the cutting and burnishing. Should twenty cases per day be required, double the number of men that is required for ten cases, with the exception of the cutter, who, if he is a rapid workman, can easily cut, in any style, twenty cases per day. These rules are for first-class work in string style.

Use the fountain forepart swab for putting on foreparts, as it keeps the blacking from soiling the edge and spoiling its looks. If convenient, better work can be obtained by having the shoes go through the work on lasts, as it prevents the upper from being cracked or defaced. The prices of shoe-racks capable of holding 60 pairs are from \$1.85 to \$2.30 apiece.



CARE OF BRUSHES.



This is a very important part and should be properly attended to. First of all, the proper speed of a brush should be not not less than 800 and not over 1000 revolutions per minute. To do work properly two brushes are required, one to lay the stain down, and one to brush it up to make the suitable polish. In washing out brushes, do not, under any consideration, use oxalic acid; or, in fact any acid or strong alkali. Take clean water and soap and make soap suds; then take a carriage sponge of good size and wet it well; then, while the brush is in motion, hold the sponge saturated with soap suds up to the brush and wash it out. After giving the brush a good washing, take a coarse piece of sandpaper and hold it against the wheel brush while in motion to take off a little of the outside roughness and it is ready for use.

Applying Stains Without Power.

After having sandpapered your shoe and brushed off whatever dust is on the sole and upper apply the stain with a sponge or brush and smooth over with a fine hand brush (a hat brush is very good for the purpose); then have a piece of flannel rolled up, and smooth from heel to toe once or twice; let it dry and then polish with a clean piece of flannel. A little experience will soon enable you to make a very fair button by hand, but of course not so hard or smooth as when finished by power. I make stains on purpose for hand finishing, and when ordering please state whether for hand or power. Machines to run by foot power can be readily made at very little cost.



Culling and Designing Bottoms.



The finisher should be sure to bear in mind that his cutting knives should be in proper shape before he starts. Almost every bottom finisher has his own way of keeping his knives in shape. Some desire a wide bevel on one side of the knife, others a short one, and some none at all, which to my mind is the proper way, for this reason; grinding a knife on a bevel forces open on one side when cutting the leather so as to make a guard to prevent the blacking from going over the cut. That is all right as far as it goes, but you have to use more strength in cutting. It turns open the leather in a wide groove which is very hard to burnish down again. This is avoided by using a knife ground on both sides alike or nearly, slightly rounding on one side and the lip of the cut will be sufficiently lifted to prevent the spreading of the ink over the cut.

FINISHING BY HAND.

To finish by hand properly the finisher should be most particular about having his buffer ground with a short bevel so that his steel used for turning over the edge will enable him to get a light and fine cut instead of a coarse and wide one, as would be the case if he ground his buffer with a long, wide bevel. Ground in such a manner, makes the buffer cut a deep shaving and show ridges, commonly called, and causes the buffer to be termed rank, but when a buffer is properly prepared it takes just enough of the grain off in a clean smooth cut to leave the bottom in the right trim to be well sanded or sandpapered. To do this well take a sand card as it is commonly called, have it well padded and covered with No. 1 1-2 sandpaper, sand down clean and smooth as possible, then take a fine piece of emery cloth, No. 120, and finish. Be sure to brush all the dust out so you may be able to discern if all the ridges left by the buffing knife are taken out. A bottom to have stain applied to it must be finished with sandpaper much finer than if no hard finish stain was to be applied, as the stain is very liable to lift into sight any imperfection in the sandpapering. To illustrate, buff a pair of shoes as fine as possible on the buffing machine, use as fine sandpaper as possible, apply the stain to one and you will see small straight lines caused by the paper in taking off the grain; now take the other and clean on the Naumkeag machine, stain it in the same manner and you cannot see the marks at all. It is the same in hand

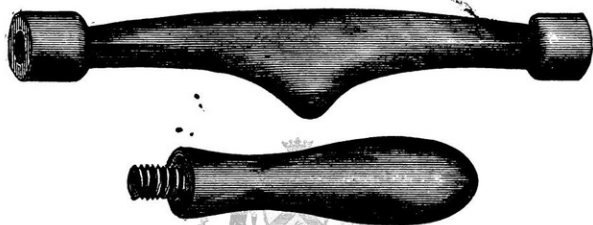
finishing unless the shoe is properly sandpapered the buffer marks will show and cause the bottom to look defaced after the shoe is finished. A deep, heavy cut should always be avoided. To design well be sure to cut your bottom finish so that after it is blacked and burnished it will make the whole outline of the bottom have a narrower appearance than it really is; this is done by cutting your panel stripes Galloons -- in fact all designs outside of black shanks as narrow as possible. Some finishers think that cutting a wide panel will make the inside look narrower, which is not the case, as I will illustrate in the cutting of a simple black shank; take a right and left shoe, cut as near straight across as possible on one and on the other make a sloping cut, the latter will be found to make the whole outside of the bottom appear narrow while the other looks wide and out of shape. Do not use large figures in sizes on the bottom as it makes the shoe have a heavy unfinished appearance, as also does large dot wheeling; many little seemingly small things when put into practice, adds greatly to the beauty of the shoe. In burnishing do not use too hot a burnishing iron or black with too heavy an ink, as too hot an iron has a tendency to burn the ink and peel it off, while too heavy an ink will only rest on the outside of the bottom on the surface and is very liable to drop off when in the process of cleaning the upper.







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