WE CLAIM:

1. An insole for insertion into footwear comprising:

a fabric layer having a peripheral edge defining a toe portion, a heel portion, and an arch portion, the fabric layer having a bottom surface and an exposed upper surface that can contact the foot or sock of a wearer; and

a base layer comprised of a self-adhering material directly bonded to the bottom surface of the fabric layer and covering substantially the entire bottom surface of the fabric layer, the base layer having a bottom surface that can be placed in contact with a footbed of the footwear.

2. The insole of claim 1, wherein the base layer comprises liquid silicone rubber.

3. The insole of claim 1, wherein the base layer has a bottom surface formed with a plurality of sipes.

4. The insole of claim 1, wherein the base layer has a thickness of about 0.3 mm to about 6 mm.

5. The insole of claim 1, wherein the base layer has a tack value of about 0.2 N to about 2.2 N.

6. The insole of claim 1, wherein the base layer has a tack value of about 1.0 N to about 2.0 N.

7. The insole of claim 1, wherein the fabric layer comprises cotton or wool.

8. The insole of claim 1, wherein the fabric layer comprises polyethylene terephthalate.

9. The insole of claim 1, wherein the insole shrinks less than 3% after multiple wash-and-dry cycles.

10. The insole of claim 1, wherein the insole has a shear strength of about 2 to about 24 under ASTM D1894.

11. The insole of claim 3, wherein the sipes have a depth of about 0.3 mm to the full thickness of the base layer.

12. The insole of claim 3, wherein at least a portion of the sipes extend along respective lines that are parallel to each other.

13. A method for making footwear insoles comprising:

applying a continuous layer of a self-adhering coating material along the length of a surface of a fabric layer to form a laminate;

curing the coating material applied to the fabric layer, causing the coating material to bond directly to the fabric layer; and

after curing the coating material, cutting a plurality of insoles from the laminate.

14. The method of claim 13, wherein each insole formed from the laminate comprises a fabric layer having a bottom surface and a base layer formed from the coating material that substantially covers the entire bottom surface of the fabric layer.

15. The method of claim 13, wherein prior to applying the coating material to the fabric layer, the method comprises printing text or images on the fabric layer.

16. The method of claim 13, further comprising forming sipes in the cured coating material.

17. The method of claim 13, wherein coating material comprises liquid silicone rubber.

18. The method of claim 13, further comprising supplying the fabric layer from a roll of fabric material to a location where the continuous layer of the self-adhering coating material is applied and the laminate is formed, and continuously feeding the laminate through a curing oven to cure the coating material.

19. The method of claim 18, further comprising winding the laminate onto a spool downstream of the curing oven.

20. The method of claim 18, wherein the coating material is applied to the fabric layer by a dispensing nozzle positioned above the fabric layer as the fabric layer is continuously fed underneath the nozzle.

21. The method of claim 20, wherein the nozzle has an outlet opening sized to apply a layer of coating material that covers substantially the entire upper surface of the fabric layer.

22. The method of claim 19, wherein cutting the plurality of insoles from the laminate comprises unwinding the laminate from the spool and feeding the laminate through a cutting apparatus that cuts the plurality of insoles from the laminate.

23. The method of claim 18, further comprising mixing a tackifying agent with the coating material before it is applied to the fabric layer.

CLAIMS

1. An insole for insertion into footwear comprising:

a fabric layer having a peripheral edge defining a toe portion, a heel portion, and an arch portion, the fabric layer having a bottom surface and an exposed upper surface that can contact the foot or sock of a wearer; and

a base layer comprised of a self-adhering liquid silicone rubber material directly bonded to at least 80% of the bottom surface of the fabric layer, the base layer having a bottom surface that can be placed in contact with a footbed of the footwear.

2. The insole of claim 1, wherein the base layer has a bottom surface formed with a plurality of sipes.

3. The insole of claim 1, wherein the base layer has a thickness of about 0.3 mm to about 6 mm.

4. The insole of claim 1, wherein the base layer has a tack value of about 0.2 N to about 2.2 N.

5. The insole of claim 1, wherein the base layer has a tack value of about 1.0 N to about 2.0 N.

6. The insole of claim 1, wherein the fabric layer comprises cotton or wool.

7. The insole of claim 1, wherein the fabric layer comprises polyethylene terephthalate.

8. The insole of claim 1, wherein the insole shrinks less than 3% after multiple wash-and-dry cycles.

9. The insole of claim 1, wherein the insole has a shear strength of about 2 to about 24 under ASTM D1894.

10. The insole of claim 2, wherein the sipes have a depth of about 0.3 mm to the full thickness of the base layer.

11. The insole of claim 2, wherein at least a portion of the sipes extend along respective lines that are parallel to each other.

12. A method for making footwear insoles comprising:

applying a continuous layer of a self-adhering coating material along the length of a surface of a fabric layer to form a laminate, the coating material comprising liquid silicone rubber;

curing the coating material applied to the fabric layer, causing the coating material to bond directly to the fabric layer; and

after curing the coating material, cutting a plurality of insoles from the laminate.

13. The method of claim 12, wherein each insole formed from the laminate comprises a fabric layer having a bottom surface and a base layer formed from the coating material that substantially covers the entire bottom surface of the fabric layer.

14. The method of claim 12, wherein prior to applying the coating material to the fabric layer, the method comprises printing text or images on the fabric layer.

15. The method of claim 12, further comprising forming sipes in the cured coating material.

16. The method of claim 12, further comprising supplying the fabric layer from a roll of fabric material to a location where the continuous layer of the self-adhering coating material is applied and the laminate is formed, and continuously feeding the laminate through a curing oven to cure the coating material.

17. The method of claim 16, further comprising winding the laminate onto a spool downstream of the curing oven.

18. The method of claim 16, wherein the coating material is applied to the fabric layer by a dispensing nozzle positioned above the fabric layer as the fabric layer is continuously fed underneath the nozzle.

19. The method of claim 18, wherein the nozzle has an outlet opening sized to apply a layer of coating material that covers substantially the entire upper surface of the fabric layer.

20. The method of claim 17, wherein cutting the plurality of insoles from the laminate comprises unwinding the laminate from the spool and feeding the laminate through a cutting apparatus that cuts the plurality of insoles from the laminate.

21. The method of claim 16, further comprising mixing a tackifying agent with the coating material before it is applied to the fabric layer.