Dec. 31, 1940. F. G. WEISBECKER 2,227,403

VERGE PLATES AND METHOD FOR MAKING SAME

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FIG. I.

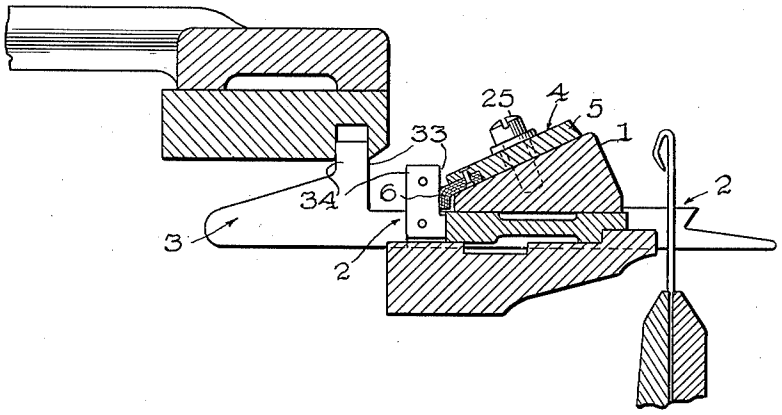


FIG. II.

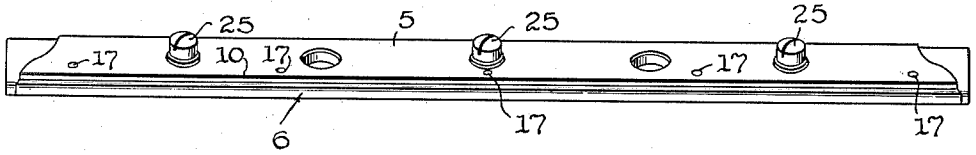


FIG. III.

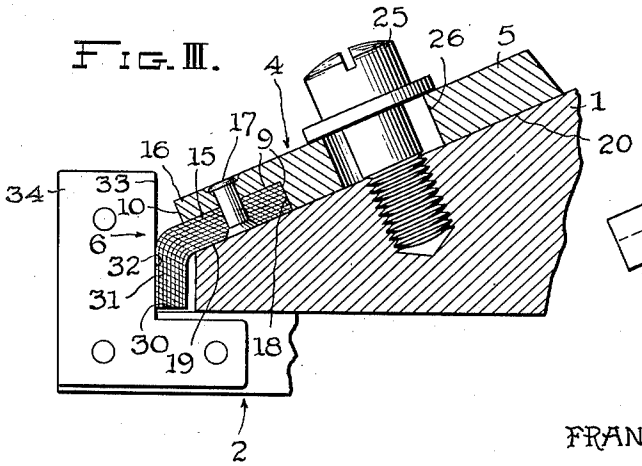
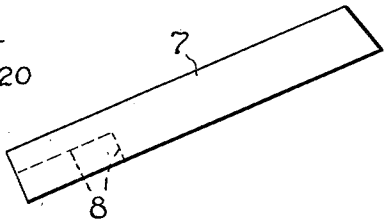


FIG. IV.



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VERGE PLATES AND METHOD FOR MAKING SAME

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FIG. V.

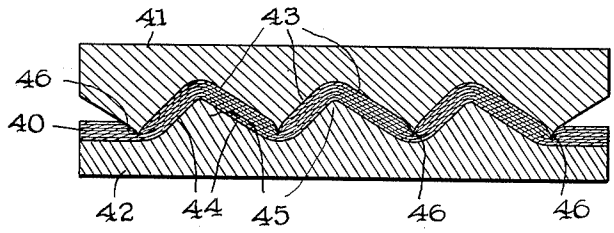


FIG. VI.

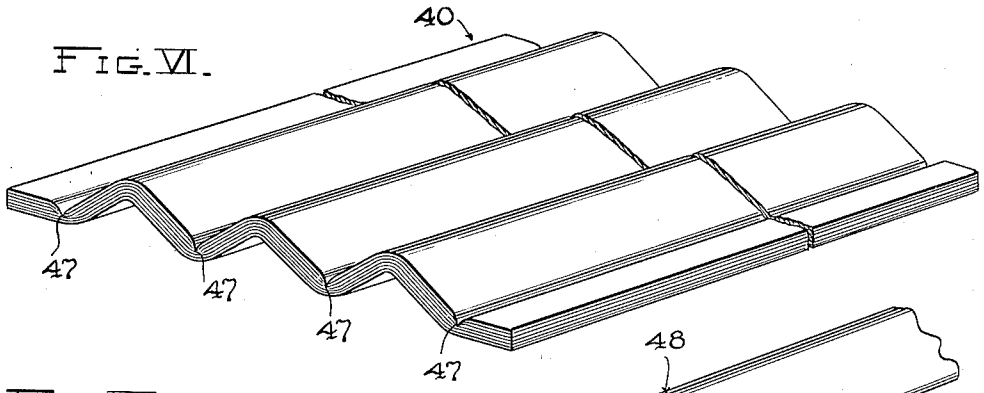


FIG. VIII.

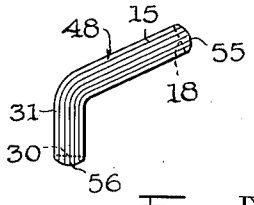


FIG. VII.

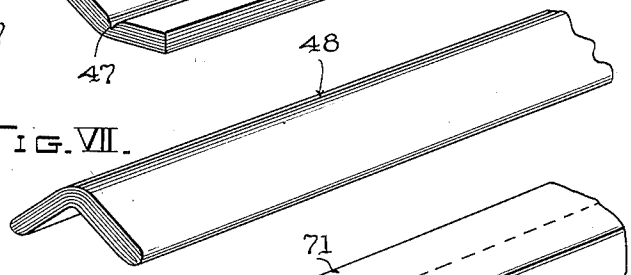


FIG. IX.

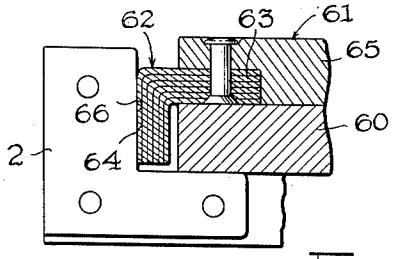


FIG. XI.

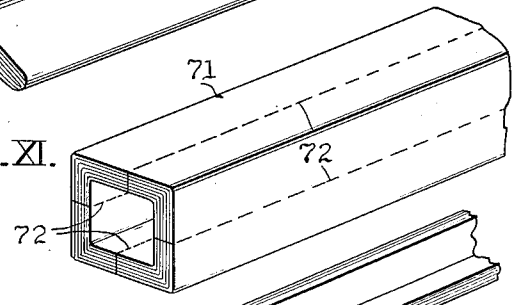


FIG. XII.

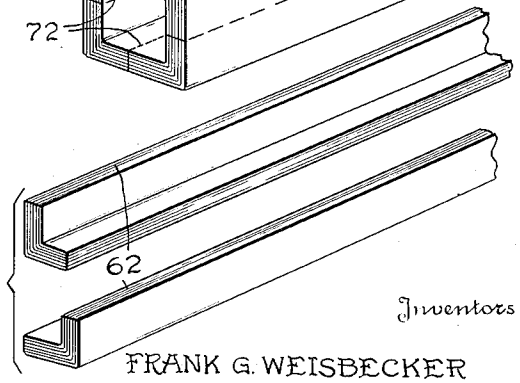
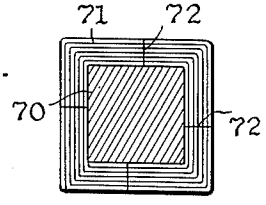


FIG. X.



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VERGE PLATES AND METHOD FOR MAKING SAME

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FIG. XIII.

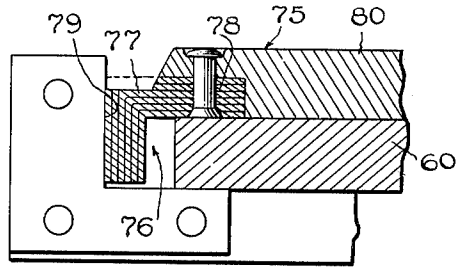
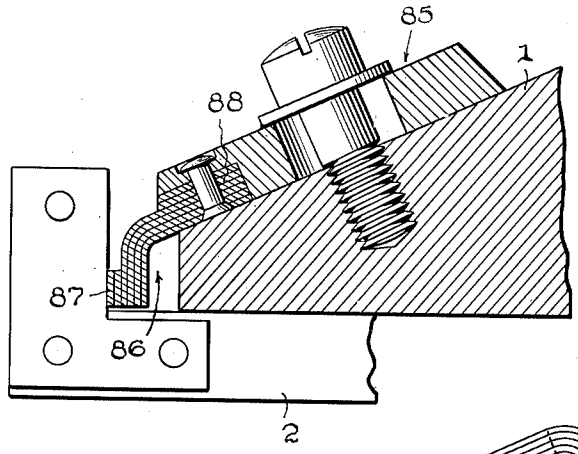


FIG. XIV.



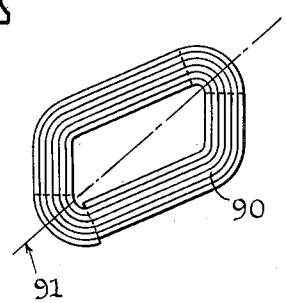


FIG. XV.

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2,227,403

UNITED STATES PATENT OFFICE

2,227,403

VERGE PLATES AND METHOD FOR MAKING SAME

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Application April 24, 1940, Serial No. 331,474

16 Claims. (Cl. 66—110)

This invention relates to improvements in knitting machines and more particularly to improvements in verge plates for straight knitting machines and methods for making such verge plates.

In a straight knitting machine of the type now generally used in the production of full-fashioned hosiery, there are a number of knitting sections for simultaneously producing a corresponding number of hosiery blanks. Each conventional knitting section includes one or more yarn carriers, a series of needles, a series of sinkers and dividers, sinker and divider operating means, and a verge plate. The yarn carriers lay yarn along the series of sinkers and dividers and adjacent the series of needles. The sinkers and dividers are then advanced according to the usual practice to sink the laid yarn between the needles. The forward movement of the sinkers and dividers is limited by the verge plate. For this purpose, the verge plate has a so-called sinker stop edge or face which is engaged by the sinkers and dividers to arrest them in alignment at the proper forward position.

The verge plate plays an important part in the production of perfectly knit hosiery fabric. The verge plate should uniformly arrest all the sinkers so that they will all be in alignment when they come to rest at their forward position. A misplaced sinker will cause the corresponding yarn loop which it has sunk between needles to be of different character from other yarn loops of the same course. The result is lack of uniformity in the sinker loops and the production of imperfect hosiery, known in the trade as "seconds."

Improper sinker action may be due to any one of a number of causes. The impact of the metallic sinkers on a metallic sinker arresting edge of a verge plate tends to cause the sinkers to rebound. When a sinker rebounds, its operation is abnormal and its loop of yarn is apt to be imperfectly formed.

It is also found that in prior art verge plates, the sinker stop edges wear irregularly. That is, each sinker in time wears a groove in the verge plate. These grooves are of varying size and depth. Consequently, the grooves preclude the verge plate from properly aligning the sinkers in their forward position, and the loops in certain wales are formed of a larger size than those of other wales. This variation in loop size forms sinker lines which detract from the appearance and value of the hosiery.

An object of this invention is to provide an improved verge plate which will tend to absorb the shock when a sinker is arrested by the verge plate, which will minimize sinker rebound and act substantially uniformly on all the sinkers as they come to rest, and which presents a sinker stop edge that will tend to wear more uniformly than prior constructions and will have relatively long life during which the sinkers will be properly arrested at their forward position.

Another object is to provide a novel method for making the verge plates of this invention so that they will have the described characteristics.

Other objects and advantages will be apparent from the following description, the appended claims, and the accompanying drawings, which illustrate preferred embodiments of this invention.

Referring to the accompanying drawings, Figure I is a sectional view of part of the loop forming mechanism of a full-fashioned knitting machine provided with an embodiment of the present invention.

Figure II is a rear elevational view of the verge plate and sinker head top of Figure I.

Figure III is a view on enlarged scale of a detail of Figure I.

Figures IV through VIII illustrate a method for making the verge plate of Figures I through III.

Figure IX is a sectional view showing a verge plate of this invention as applied to a flat top sinker head.

Figures X through XII illustrate a method for making the angle member of the verge plate shown in Figure IX.

Figures XIII and XIV are transverse sectional views of other verge plate constructions embodying this invention and in association with sinkers and a sinker head cap.

Figure XV is an end view of a tubular member, from which verge plate angle members may be formed.

Referring now to the drawings, Figure I shows a sinker head including a cap or top 1, a sinker 2 and a divider 3 of a knitting section in a conventional straight, full-fashioned knitting machine. In a conventional full-fashioned knitting machine, a series of sinkers 2 and a series of dividers 3 are associated with each sinker head top 1. For a further disclosure of loop forming mechanism in a full-fashioned, straight knitting machine, reference may be had to the book of Max C. Miller, entitled "Knitting full-fashioned hosiery" and published by McGraw-

Hill Book Company, Inc. of New York with a copyright notice dated 1937.

In the operation of a straight knitting machine, the sinkers 2 and dividers 3 are advanced and retracted in loop forming operations according to the usual practice. The sinkers 2 and dividers 3 have their forward movement limited by a verge plate 4 embodying the present invention.

As shown more particularly in Figures I through III, the verge plate 4 of this invention may comprise a bar-like or plate-like body member 5 and an angle-like bar or member 6. The body member 5 may be formed of stock 7 in strip form having the cross-sectional shape illustrated in Figure IV. This stock 7 is preferably metallic, but may be formed of other suitable material if desired. The longitudinal portion of stock 7 bounded by the dotted lines 8 in Figure IV is removed to provide the recess 9 of the body member 5 (see Figure III). This recess 9 extends longitudinally of the body member 5, inwardly from its rearward edge 10, and along its under side.

The angle member 6 has its leg 15 secured to the flange 16 of the bar-like member 5, which flange 16 results from the formation of the recess 9. The leg 15 may be secured to the flange 16 by any suitable means, but is preferably secured to the flange 16 by means of a number of relatively small rivets 17. These rivets preferably have their heads countersunk in the flange 16 and the leg 15, as shown more clearly in Figure III, so that the verge plate 4 will be provided with substantially flush surfaces. The leg 15 preferably completely fills the recess 9 so as to further minimize the possibility of the leg 15 shifting in the recess 9. The outer edge 18 of the leg 15 preferably engages throughout its length and width with the adjacent side of the recess 9. The thickness of the portion of leg 15 within the recess 9 is preferably of a size corresponding substantially to the depth of the recess 9, so that the inner face 19 of the leg 15 will be substantially flush with the underface 20 of the bar-like member 5. If desired, however, the thickness of the portion of the leg 15 which is disposed in recess 9 may be of a size somewhat greater or less than the depth of the recess 9, but best results are obtained when the portion of the leg 15 disposed in the recess 9 has a thickness of a size at least as great as the depth of recess 9.

The verge plate 4 is supported on the sinker head cap 1 as shown in Figures I and III. It will be seen that with the verge plate 4 in position on the sinker head cap 1, the latter, in effect, provides a third side for the recess 9. The upper surface of the sinker head cap 1, therefore, engages the inner face 19 of the angle member 6 and assists in maintaining the angle member 6 in the desired position for arresting the sinkers 2 and dividers 3. The verge plate 4 may be secured to the sinker head top 1 by means of threaded bolts or screws 25. These screws 25 extend through openings 26 formed in the bar-like member 5 and are threaded into the sinker head cap 1. The openings 26 may be somewhat larger in diameter than the diameter of the shanks of the screws 25, so that the verge plate 4 may be adjusted toward and away from the sinkers 2, when the bolts 25 are loosened.

The angle member 6 is preferably formed of a number of laminations of suitable sheet material and a hardened binder. It is also preferable that at least some of the laminations be continuous from the edge 18 of the angle member 6 to its edge 30, so that at least certain of the laminations in the leg 31 of the angle member 6 will be continuations of the laminations in the leg 15. In the Figure III construction, the legs 15 and 31 are provided with the same number of laminations, and each lamination in the leg 31 is a continuation of a corresponding lamination in the leg 15. These laminations preferably are arranged substantially parallel to each other and to the faces of the angle members 6.

The legs 15 and 31 of the angle member 6 are preferably so relatively disposed that they form an angle of somewhat more than 90° and the leg 31 is in a substantially vertical position when the verge plate 4 is secured in place on the sinker head cap 1 and the leg 15 rests on the sloping top surface of the cap 1 (see Figures I and III). The outer face 32 of the leg 31 will, therefore, be substantially parallel to the front edges 33 of the sinker and divider butts 34. The edge 30 of the angle member 6 is preferably disposed at a level adjacent the base of the sinker butts 34 so as to avoid breakage of the sinkers 2 when they are arrested.

According to one method for forming the angle bars 6, a corrugated-like member 40 (see Figure VI) is formed by means of a mold illustrated in Figure V. This mold comprises upper and lower members 41 and 42 having opposed molding surfaces 43 and 44 of suitable shape for producing the corrugated-like member 40 of Figures V and VI. It will be noted that the mold member 41 has in effect a series of parallel grooves to provide the molding surface 43, and that the mold member 42 has a corresponding series of ribs 45 to provide the molding surface 44. In the forming of the corrugated member 40, a desired number of suitably impregnated sheets of woven canvass, duck, linen or other desired material, are arranged in superimposed relation on top of the mold member 42. The mold member 41 is superimposed on the sheets of material, which are then heated. While heated, the sheet material is subjected to pressure by the mold members 41 and 42.

The sheet material forming the corrugated member 40 is impregnated previous to the molding operation with a binding material. Various adhesives or binders may be employed as the impregnating agent for the selected sheet material, but a phenolic condensation product, such as Bakelite, offers many advantages because of the strength of the resultant product, the fact that the faces of the elements formed are provided with a smooth finish by the described molding method, and the fact that the resultant structure is substantially heat, water, acid, and oil proof.

In the molding process, the material is heated according to the particular binder which is being used. If a phenolic condensation product is being used, the impregnated laminations while in the mold are subjected to heat and pressure in such manner that the heat will first soften and subsequently harden the phenolic condensation material so that the impregnated laminations will be strongly compacted and take the shape 40 shown in Figure VI.

The mold member 41 has longitudinally extending edges 46 which alternate with the grooves forming the molding surface 43. These edges 46 preferably project so as to more closely compact the laminated material than the cooperating

molding surfaces 43 and 44. The edges 46 will, therefore, in effect provide weakened lines 47 to facilitate separation of the corrugated-like member 40 into unit angle members 48 like that shown in Figure VII.

If desired, the edges 46 may be so formed or sharpened as to partially or completely sever the laminated material during the molding operation. If the edges 46 actually sever the laminated material, the molding operation provides a number of angle members, similar to the angle member 48 of Figure VII.

If the edges 46 are such as to not effect complete separation of the laminated material 40 in the molding operation, the resulting product will appear as illustrated in Figure VI. The corrugated-like member 40 is then separated along the lines 47 to provide a plurality of angle members 48 such as shown in Figures VII and VIII, these figures being respectively elevational and end views.

The angle members 48 may then have their portion 55 (shown in dotted line in Figure VIII) removed by any suitable operation such as cutting or grinding to provide an angle member 6 with the edge 18 as shown in Figure III. This angle member 6 is secured in the bar-like member 5 as shown in Figures I and III. The portion 56 shown by a dotted line in Figure VIII is preferably removed after the angle member 6 is secured to the bar 5, but may be removed before, if desired. Removal of the portion 56 provides the edge 30. The angle member 6, after being secured to the bar-like member 5, may have its face 32 machined, ground or otherwise treated. Usually the molding operation described above will provide each angle member 6 with a face 32 which is so straight and true that it may serve as a sinker stop edge. The face 32, however, may be machined or ground, if it has not been perfectly formed in the molding operation. It is important that the face 32, which is to engage the sinker butt edges 33, be perfectly smooth, even, and straight so as to arrest the sinkers 2 in alignment. The machine operation, if found desirable, is preferably such as to remove only a relatively thin portion of the side of the angle member 6 having the face 32. The machining operation is also preferably so carried out that the resultant face 32 is substantially parallel with the laminations of sheet material in the leg 31. The sinkers 2 will, therefore, travel, in their reciprocating movement along lines substantially normal to the planes of the sheet material or laminations in the leg 31.

Experience shows that, if the verge plate is made and constructed as above described, the angle member 6 resists the wearing action of the sinkers 2 and will have relatively long life during which its sinker engaging face 32 will retain its flat or smooth surface for uniformly arresting all of the sinkers 2 and dividers 3.

Where the sinker head cap 60 has a substantially horizontal top surface as shown in Figure IX, a verge plate 61 may be constructed as shown in that figure. In the Figure IX construction, the angle member 62 has its legs 63 and 64 arranged substantially at an angle of 90° relative to each other. The angle member 62, except for the angular relation of its leg members 63 and 64, has substantially the same construction as the angle member 6 of Figures I and III. The angle members 62 and 6 also have the same function and provide the same advantages. The verge plate 61 has a bar-like member 65 which may be constructed in the same manner as the bar-like member 5 in Figures I through III. The bar-like member 65 is preferably secured to its angle member 62 and the sinker head cap 60 in the same manner as explained with regard to the verge plate 4 of Figures I through III. The angle member 62, when in use as shown in Figure IX, has a substantially vertical sinker engaging face 66 corresponding to the sinker engaging face 32 described above.

In forming the angle member 62 of Figure IX, a length of impregnated sheet material, such as that used in the process illustrated in Figures V through VIII, may be wound or wrapped about a mandrel 70 (see Figure X) until a desired tubular form 71 of suitable wall thickness is formed. The mandrel 70 has a cross-sectional size and shape corresponding to the shape and size desired for the molded product. A mandrel 70 having a rectangular cross-section is desired for the formation of angle members having the legs thereof disposed at an angle of 90° relative to each other. The sheet material, of which the tube 71 is formed, may be impregnated with a binder such as that described above in the making of the form 40 in Figure VI.

After the tube 71 has been wrapped as shown in Figure X, the tube 71 and the mandrel 70 are placed in a suitable mold (not shown). This mold (not shown) has an interior shape and size corresponding to exterior shape and size for the finished tube 71 which is shown in Figure XI. The tubular form 71, while on the mandrel 70 and in its mold, is heated and subjected to pressure to provide the hardened tubular member of Figure XI having the desired wall thickness. The tubular member 71 may now be divided along the dotted lines 72 in its sides to form four angular or L-shaped members 62 such as those illustrated in Figure XII. Each of these angle members 62 is then secured to a bar-like member 65 in the same manner as described above with regard to the angle member 6 and its supporting bar 5. The shorter leg 64 of the angle member 62 has the laminations thereof substantially parallel to its sinker engaging face 66 and is substantially similar to the leg 31 of the construction of Figures I and III.

The above described methods for forming angle bars 6 and 62 are efficient and minimize waste of material. In both methods, there is but little of the molded material which does not go into the final form of the angle bars. The tubular member 71 of Figure XI, for example, may be cut into four similar angular members 62 with practically no waste of material.

Other verge plate constructions (75 and 85) embodying this invention are shown in Figures XIII and XIV. In the Figure XIII construction, a part of the angle member 76 is cut away or otherwise removed to provide a portion 77 of reduced thickness in the horizontal leg 78. This removed or cut-out portion is indicated in dotted lines and extends from the sinker stop face 79 and along the outer face of the leg 78 to the adjacent edge of the bar 80. This cut-out portion also preferably extends longitudinally of the angle member 76 for its entire length. Except for this cut-out part of the angle member 76, the verge plate 75 is substantially the same in construction as the verge plate of Figure IX.

In the verge plate construction 85 of Figure XIV, the angle member 86 is provided with por-

tions of reduced thickness in both of its legs 87 and 88. This reduced thickness may be secured by cutting away or removing adjacent longitudinal sections in the outer faces of both legs so that the cross-section of the angle bar 86 will appear as in Figure XIV. The outer portions of the legs 87 and 88 are thus formed of greater thickness than the inner leg portions in the final form of the verge plate 85. Except for these portions of reduced thickness in the verge plate 85, the latter is substantially the same in construction as the verge plate 4 of Figure III.

By reducing the thickness of portions of angle members 76 and 86 as described above, it is found that the tendency of the sinkers to rebound when they strike the sinker stop edges is still further reduced. The explanation for this improvement may be that the reduced thickness provides a more flexible construction for cushioning the shock when the sinkers are arrested. The thicker or heavier construction for the angle member portion which actually engages the sinker butts imparts ruggedness and strength to the structure.

In all of the described and illustrated forms of verge plate, its angular member presents a sinker engaging face of appreciable vertical extent. The sinker engaging face will, therefore, provide substantial surface area for sinker engagement and have relatively long life during which it will efficiently perform its intended function.

The angle members 4 and 86 of Figures III and XIV may be formed from a tubular member 90 having a cross-sectional shape as illustrated in Figure XV. This tubular member 90, in cross-section, has the shape of a parallelogram with its sides so relatively disposed that when it is divided on the diagonal line 91 into two equal parts or halves, it forms two similar angular members such as that illustrated in Figure VIII. The tubular member 90 may be formed on a suitably shaped mandrel with a suitably shaped outer mold and in substantially the same manner as described above for the making of the tubular member 71.

One of the features of this invention is that the angle members and their laminations curve in the direction of the bending movement or stress which occurs when the sinkers 2 are arrested. This feature provides a stronger construction and one which will not be apt to break during use.

It is also preferable that the depending leg of each angle member be spaced somewhat from the sinker head cap as shown in Figures I, III, IX, XIII and XIV. This spaced relation leaves the depending leg free to cushion the shock when it is struck by the sinkers. If the depending leg rests against the adjacent or rear side of the sinker head cap, the depending leg is not free to yield when struck by sinkers and/or to function to its fullest extent in absorbing the shock of striking sinkers.

The foregoing is illustrative, and it will be understood that this invention will include all embodiments and modifications coming within the scope of the appended claims.

I claim:

1. For use with the sinker head and movable sinkers of a straight knitting machine, a verge plate having a rearward portion with a face for limiting the travel of said sinkers, said rearward portion being formed substantially of laminated material and a hardened binder, and the laminations of said material adjacent to and provided with said face extending substantially parallel thereto.

2. For use with the sinker head and movable sinkers of a straight knitting machine, a verge plate comprising a bar-like body member, and an angle member having one leg thereof secured to said body member, said angle member having the other leg thereof so disposed that its outer face presents the sinker engaging face for the verge plate, said angle member being formed substantially of laminated material and a hardened binder.

3. For use with the sinker head and movable sinkers of a straight knitting machine, a verge plate having a rearward portion with a face for stopping said sinkers to limit the travel thereof, said verge plate comprising a body member having a recess therein, and an angle member having two legs, one leg being secured in said recess, and the other leg being arranged to present the outer face thereof as the sinker stopping face of the verge plate, said angle member being formed substantially of laminated material and a hardened binder, and the laminations of said material in one of said legs being continuations of laminations in the other of said legs.

4. For use with the sinker head and movable sinkers of a straight knitting machine, a verge plate comprising a bar-like body member having a longitudinal recess extending inwardly from one longitudinal edge thereof and from one face thereof, and an angle member having one leg thereof disposed in said recess and secured to said body member with the inner face of said leg substantially flush with said face of said body member, said angle member having the other leg thereof so disposed that its outer face presents the sinker engaging face for the verge plate, said angle member being formed of laminated material and a hardened binder.

5. In combination with a knitting machine sinker head and knitting machine sinkers having upstanding butts, a verge plate construction comprising; a bar-like member adjustably secured to and mounted on the top of said sinker head, said member having a longitudinal recess extending along the underface thereof and inwardly from the longitudinal edge thereof facing said sinkers; and an angle member having a leg thereof mounted in said recess, secured to said member and resting on said sinker head; said angle member having its other leg depending from said first-mentioned leg and between said sinker head and the butts of said sinkers, the lower edge of said depending leg being arranged at a level adjacent the level of the base of said sinker butts, the outer face of said depending leg being engageable with said sinker butts to limit travel of said sinkers, said angle member being formed substantially of laminated sheet material and a hardened binder, and at least a substantial part of the laminations in said depending leg being substantially parallel to said sinker engaging face and being continuations of laminations in said first-mentioned leg.

6. A method for making verge plates for straight knitting machines, which method comprises forming a bar-like body member, molding and shaping sheet material and a binder into a laminated angle member, and securing one leg of said angle member to said bar-like body member with the other leg of said angle member arranged

to present a face thereof as the sinker stop face or edge of the verge plate.

7. A method for making verge plates for straight knitting machines, which method comprises: forming a bar-like member with a longitudinal recess in a longitudinal edge thereof; molding and shaping sheet material and a binder into a hardened, laminated, angular, bar-like member with the laminations running substantially parallel to the faces of the angular member and with a plurality of the laminations at one side of the apex of said angular member continuations of laminations at the other side of said apex; and securing one leg of said angular member in the recess of said first-mentioned bar-like member.

8. A method for making verge plates for straight knitting machines, which method comprises: forming a bar-like member with a longitudinal recess in a longitudinal edge thereof; molding and shaping sheet material and a binder into a laminated, angular, bar-like member with the laminations running substantially parallel to the faces of said angular member and with a plurality of the laminations at one side of the apex of the angular member continuations of laminations at the other side of said apex, securing one leg of said angular member in the recess of said first-mentioned bar-like member, and finishing the outer face of the other leg to provide a straight smooth face for serving as a sinker stop face or edge.

9. A method for making verge plates for straight knitting machines, which method comprises forming a bar-like member with a longitudinal recess in a longitudinal edge thereof, molding sheet material and a binder into a laminated tubular member of substantially rectangular cross-section, forming an angular member by separating said tubular member along substantially parallel lines in adjacent sides thereof, and securing one leg of said angular member in the recess of said bar-like member with the other leg arranged to have the outer face thereof serve as a sinker stop face or edge.

10. For use with the sinker head and movable sinkers of a straight knitting machine, a verge plate comprising a bar-like body member, and an angle member having one leg thereof secured to said body member, said angle member having the other leg thereof so disposed that its outer face presents the sinker engaging face for the verge plate, said angle member being formed of laminated material and a hardened binder and having a longitudinally extending portion of reduced thickness intermediate said sinker engaging face and said body member.

11. In combination with a knitting machine sinker head and knitting machine sinkers having upstanding butts, a verge plate construction comprising: a bar-like member adjustably secured to and mounted on the top of said sinker head, said member having a longitudinal recess extending along the underface thereof and inwardly from the longitudinal edge thereof facing said sinkers; and an angle member having a leg mounted in said recess, secured to said bar-like member and resting on said sinker head; said angle member having its other leg depending from said first-mentioned leg and between said sinker head and the butts of said sinkers, the lower edge of said depending leg being arranged at a level adjacent the level of the base of said sinker butts, the outer face of said depending leg being engageable with said sinker butts to limit travel of said sinkers, said angle member being formed of laminated sheet material and a hardened binder, and at least a substantial part of the laminations in said depending leg being substantially parallel to said sinker engaging face and being continuations of laminations in said first-mentioned leg, said angle member having a longitudinally extending portion of reduced thickness intermediate said sinker engaging face and said bar-like member.

12. In combination with a knitting machine sinker head and knitting machine sinkers having upstanding butts, a verge plate construction comprising: a bar-like member adjustably secured to and mounted on the top of said sinker head, said member having a longitudinal recess extending along the underface thereof and inwardly from the longitudinal edge thereof facing said sinkers; and an angle member having a leg mounted in said recess, secured to said bar-like member and resting on said sinker head; said angle member having its other leg depending from said first-mentioned leg and between said sinker head and the butts of said sinkers, the lower longitudinal edge of said depending leg being arranged at a level adjacent the level of the base of said sinker butts, the outer face of said depending leg being engageable with said sinker butts to limit travel of said sinkers and the inner face of said depending leg being arranged in spaced relation with respect to said sinker head, said angle member being formed substantially of laminated sheet material and a hardened binder, and at least a substantial part of the laminations in said depending leg being substantially parallel to said sinker engaging face and being continuations of laminations in said first-mentioned leg.

13. In combination with a knitting machine sinker head and knitting machine sinkers having upstanding butts, a verge plate construction comprising: a bar-like member adjustably secured to and mounted on the top of said sinker head, said member having a longitudinal recess extending along the underface thereof and inwardly from the longitudinal edge thereof facing said sinkers; and an angle member having a leg mounted in said recess, secured to said bar-like member and resting on said sinker head; said angle member having its other leg depending from said first-mentioned leg and between said sinker head and the butts of said sinkers, the lower edge of said depending leg being arranged at a level adjacent the level of the base of said sinker butts, the outer face of said depending leg being engageable with said sinker butts to limit travel of said sinkers, and the inner face of said depending leg being arranged in spaced relation with respect to said sinker head, said angle member being formed substantially of laminated sheet material and a hardened binder, and at least a substantial part of the laminations in said depending leg being substantially parallel to said sinker engaging face and being continuations of laminations in said first-mentioned leg, said angle member having a longitudinally extending portion of reduced thickness intermediate said sinker engaging face and said bar-like member.

14. A method for making verge plates for straight knitting machines, which method comprises forming a bar-like body member, molding and shaping sheet material and a binder into a laminated angle member, securing one leg of said angle member to said bar-like body member with the other leg of said angle member arranged to present at least part of the outer face thereof as the sinker stop face of the verge plate, and re-

moving a longitudinal portion of the angle member between said body member and said sinker stop face to provide said angle member with a longitudinal portion of reduced thickness.

15. A verge plate for straight knitting machines, said verge plate comprising a bar-like body member, a molded laminated member of angle shape and formed of sheet material and a binder, and means securing one leg of said angle shape member to said bar-like body member with the other leg of said angle shape member arranged to present a face thereof as the sinker stop face or edge of the verge plate.

16. A verge plate for straight knitting machines, said verge plate comprising a bar-like member having a longitudinal recess in a longitudinal edge thereof, a molded laminated bar-like member of angular shape and formed of sheet material and a binder, the laminations of said angular member running substantially parallel to the faces of said angular member, a plurality of the laminations at one side of the apex of said angular member being continuations of laminations at the other side of said apex, and means securing one leg of said angular member in said recess of said first mentioned bar-like member, the outer face of the other leg being finished to provide a straight smooth face for serving as a sinker stop face or edge.

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