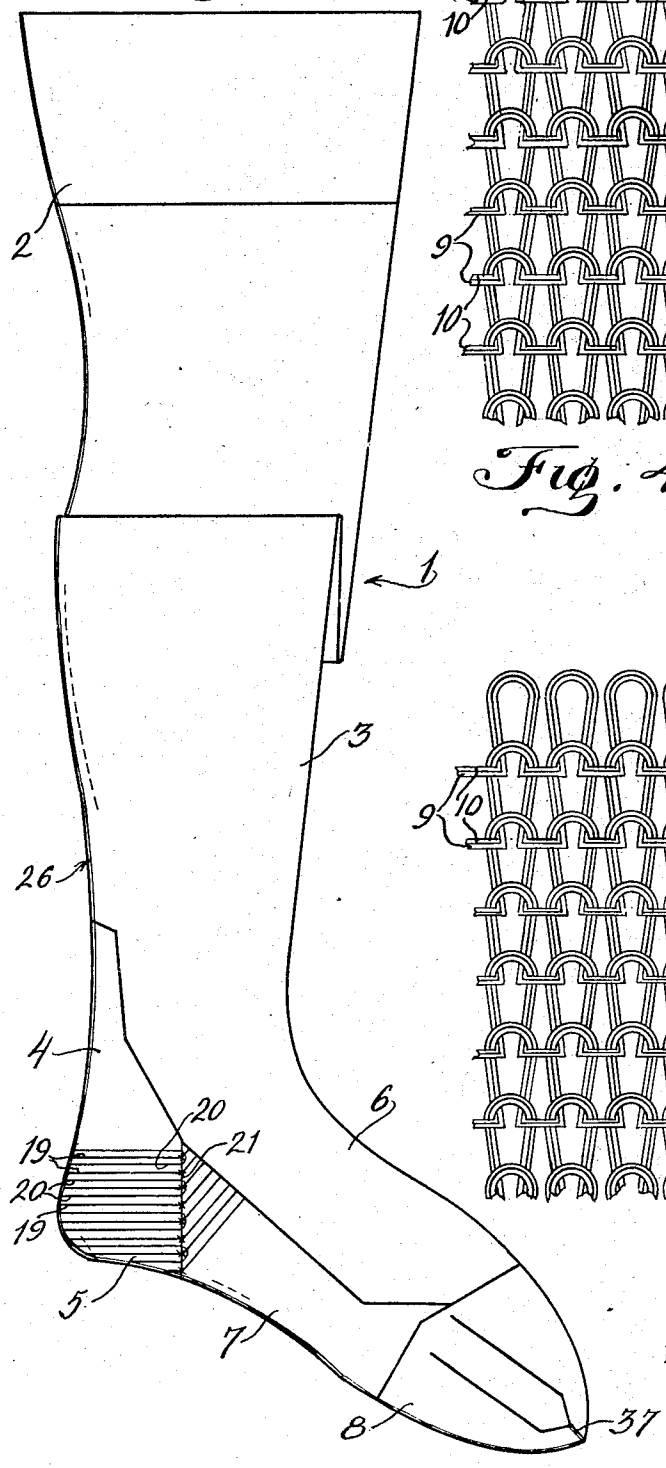
May 18, 1943. J. L. BEERS 2,319,768

METHOD OF KNITTING

Filed Oct. 21, 1936 5 Sheets-Sheet 1

Fig. 1.



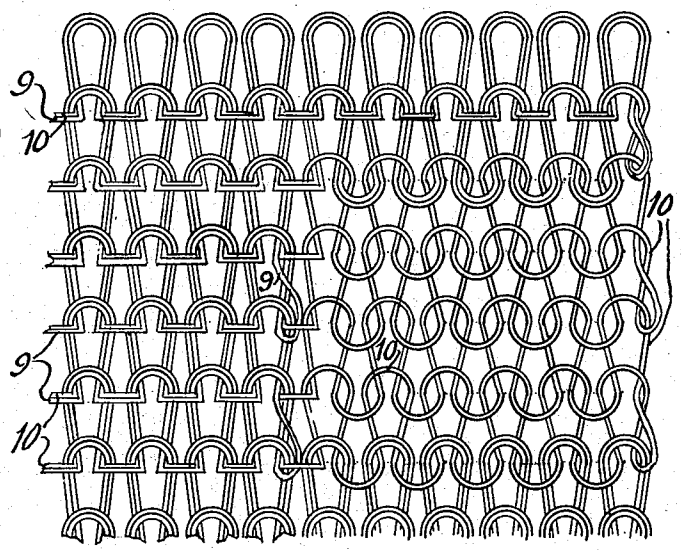
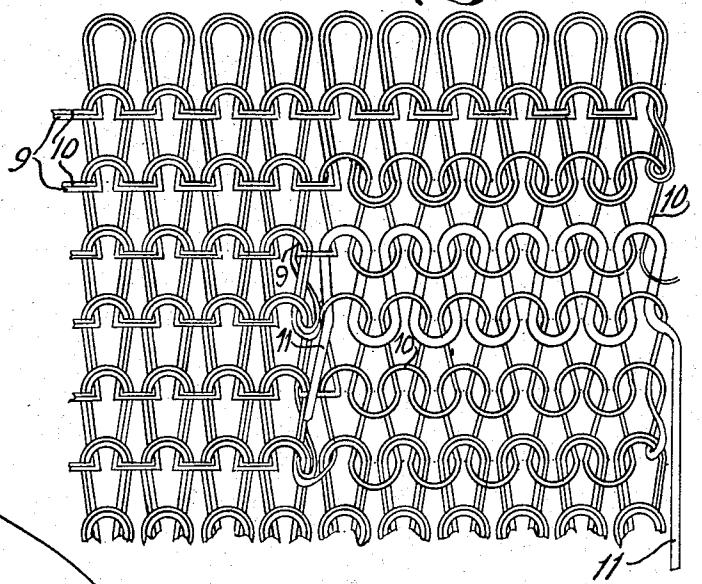


Fig. 4.

Fig. 5.



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METHOD OF KNITTING

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Fig. 2.

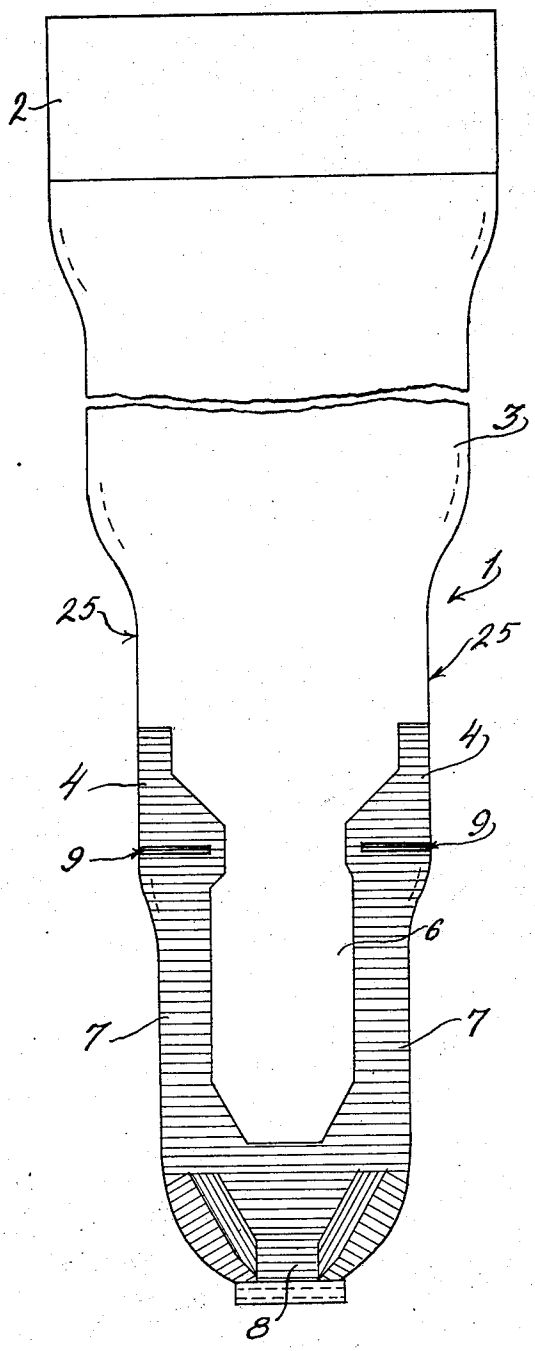
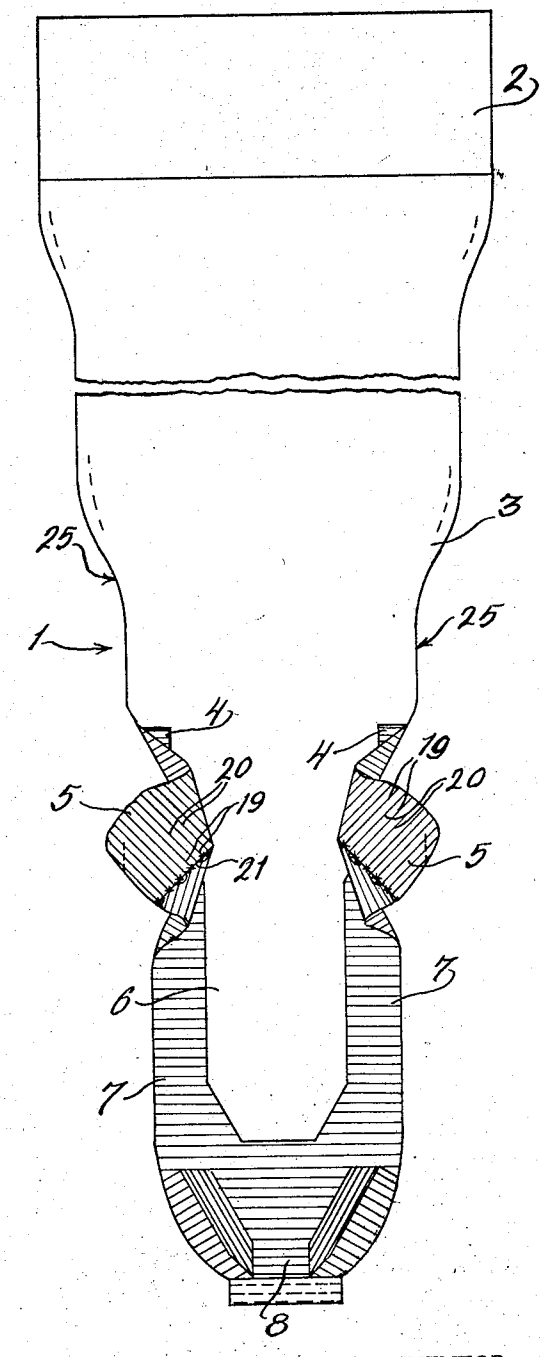


Fig. 3.



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METHOD OF KNITTING

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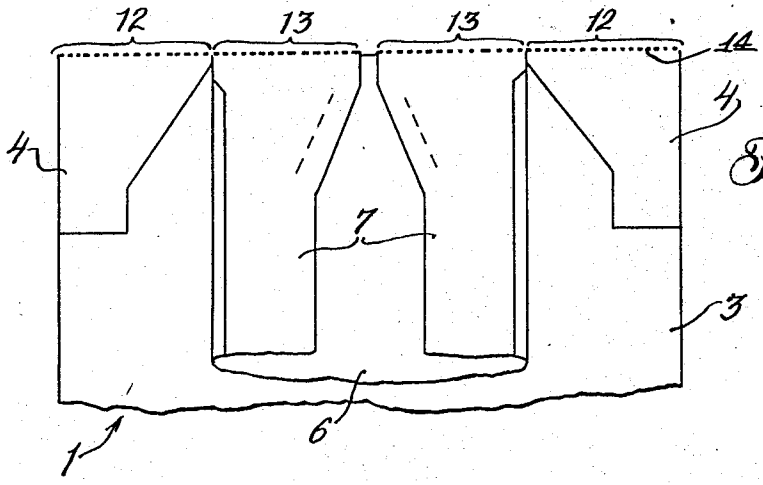


Fig. 6.

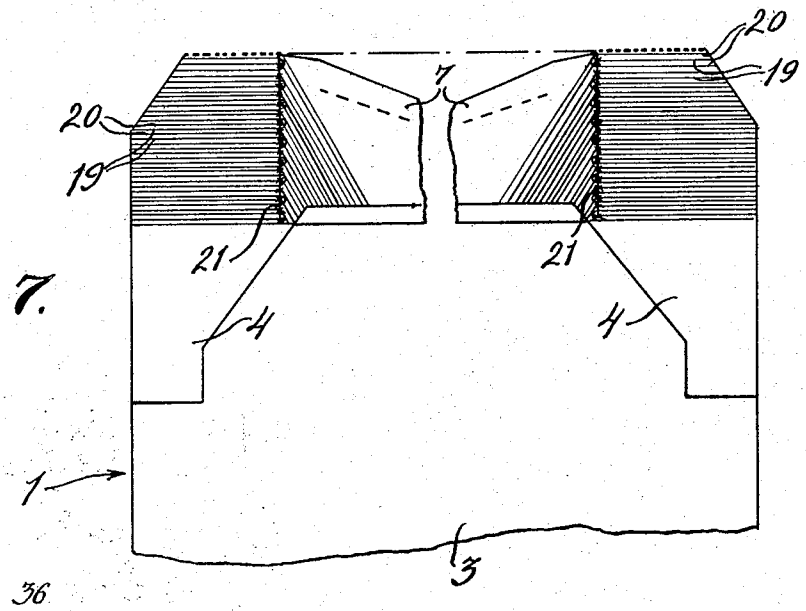


Fig. 7.

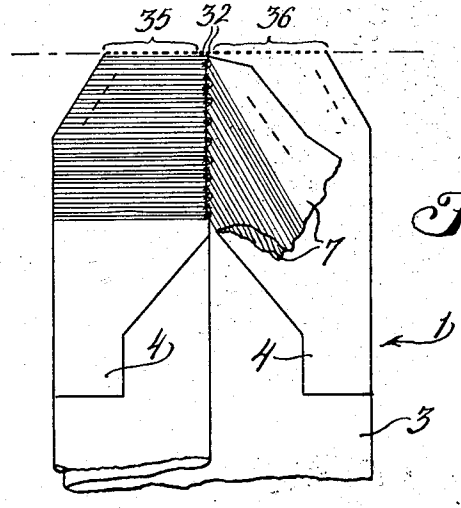


Fig. 8.

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METHOD OF KNITTING

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Fig. 9.

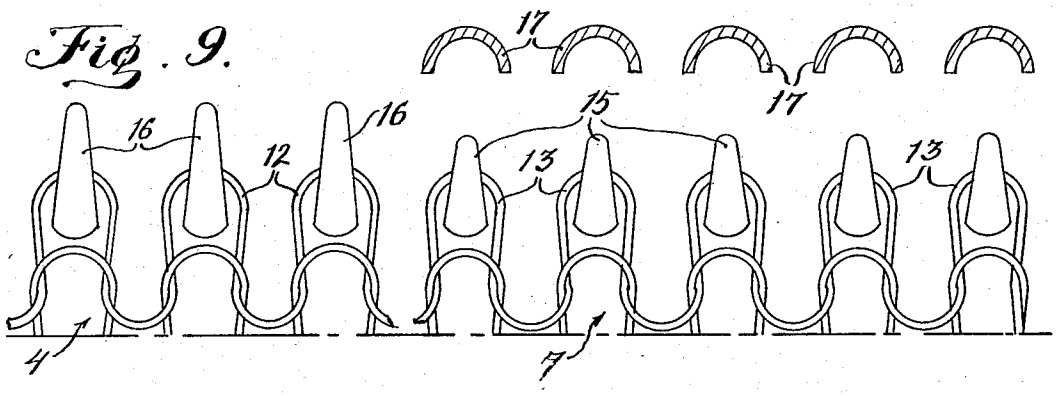
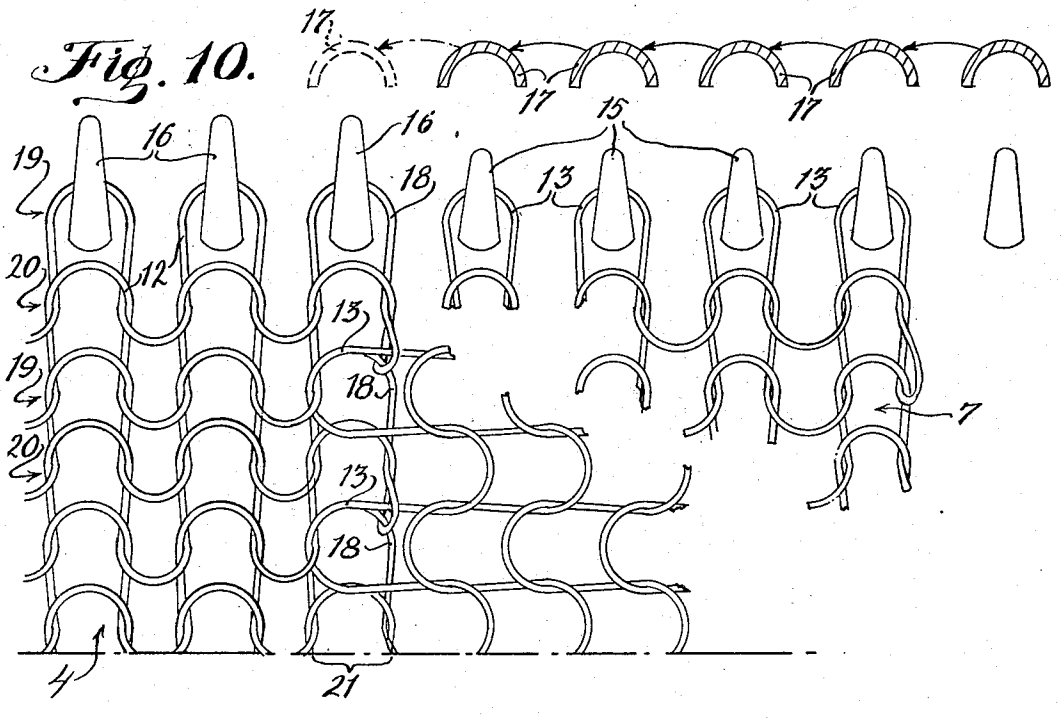


Fig. 10.



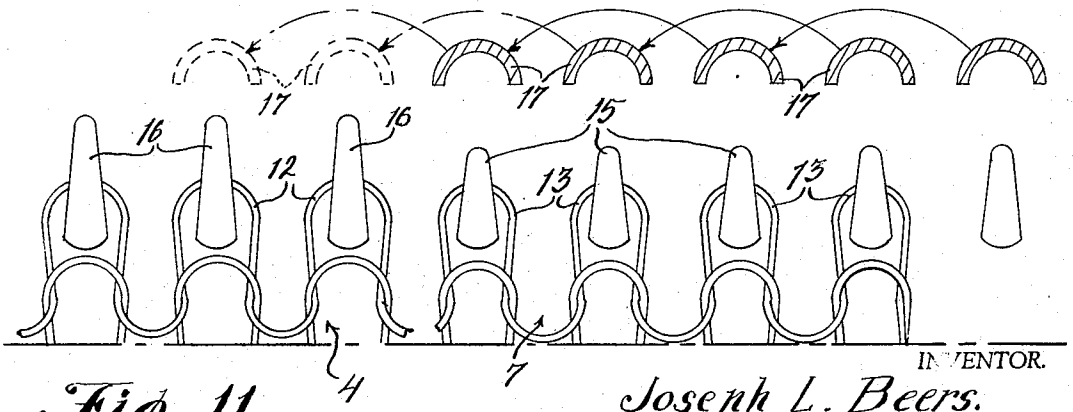


Fig. 11.

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METHOD OF KNITTING

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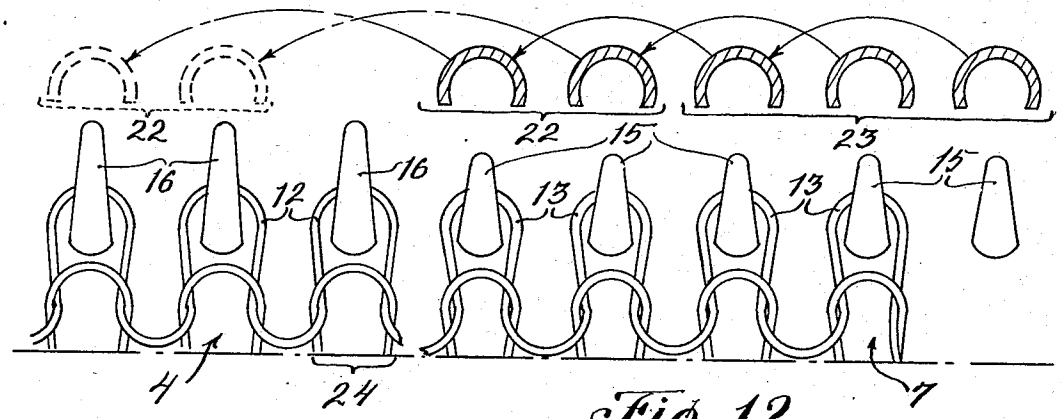


Fig. 12.

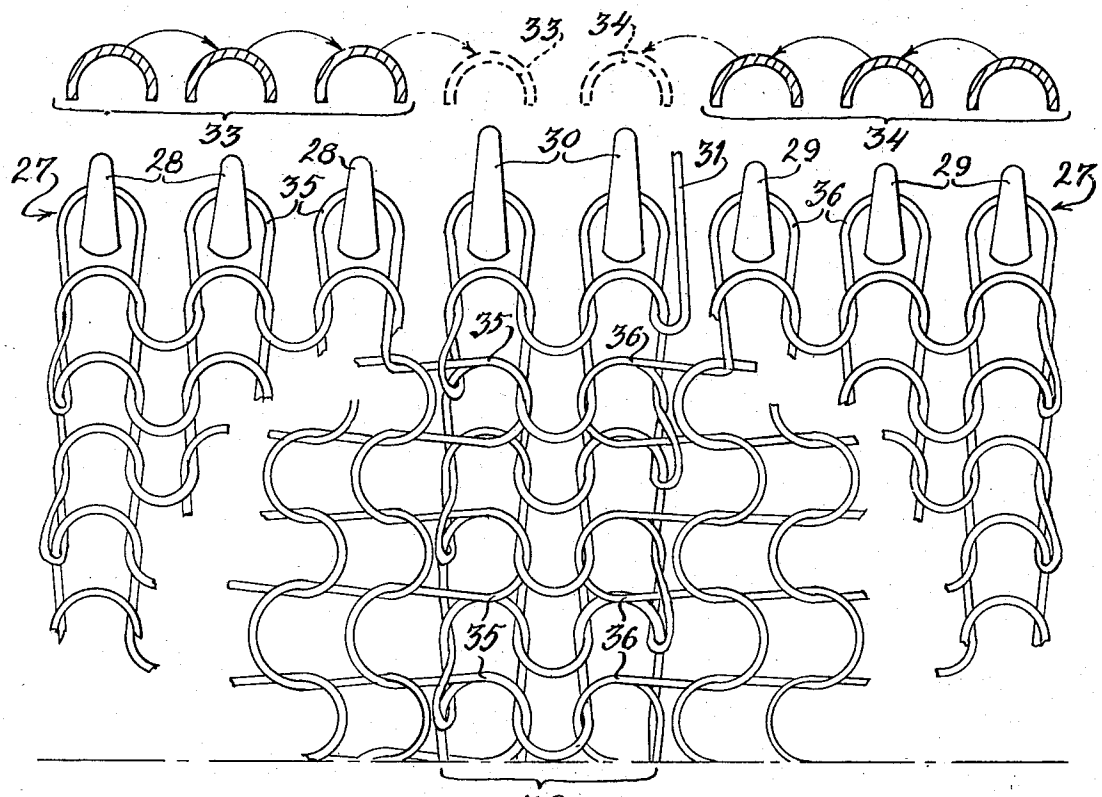


Fig. 13.

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Patented May 18, 1943 2,319,768

UNITED STATES PATENT OFFICE

2,319,768

METHOD OF KNITTING

Joseph L. Beers, Bloomfield, N. J., assignor to Julius Kayser & Co., Brooklyn, N. Y.

Application October 21, 1936, Serial No. 106,828

54 Claims. (Cl. 66—82)

The present invention relates to hosiery, more particularly to full fashioned stockings of the single unit type, and contemplates an improved method of manufacturing the fabric blank for such stockings.

As known in the art, the manufacture of the ordinary type of full fashioned stocking blanks requires the use of two distinct and separate machines—one called the "legger" and the other known as the "footer." The legger is adapted to knit the leg portion of the stocking blank, including the heel tabs, while the footer is devised to knit the foot (consisting of the instep, sole, and toe) of the blank as a continuation of the leg and heel tabs after said leg and heel tabs have been transferred onto the needles of the footer.

The manufacture of full fashioned stockings of the single unit type differs from the manufacture of the ordinary type in that the leg and foot of the blank of a single unit type of stocking are knitted continuously on one and the same machine.

Full fashioned stockings of the single unit type are preferable to the ordinary type because, due to the fact that the leg and foot portions are knitted contiguously, there are produced a proper matching between the leg fabric and the foot fabric, and uniform texture throughout the blank. However, the manufacture of single unit type of stockings has heretofore been limited and practically prohibited because the various methods devised for their manufacture are quite involved and necessitate the utilization of complicated machines which, obviously, places the cost of production on an exceedingly high scale.

Therefore, it is the primary purpose of this invention to provide a method of manufacturing single unit type of full fashioned stockings, the use of which makes it possible to produce such stockings at a cost substantially at par with the manufacture of the ordinary two-unit type of full fashioned stockings.

The invention aims to provide a method of knitting full fashioned stockings of the single unit type capable of being carried out easily on a machine having a greatly simplified construction, the invention being especially characterized in that the method, particularly the step relating to the formation of the heel tabs, may be carried out on an ordinary footer with slight changes readily made therein.

An important object of the invention resides in the provision of a method whereby are eliminated certain looping operations which have heretofore been necessary to join certain parts of the stocking. According to the present invention, these parts are joined during the knitting operation.

It is also an important object of the invention to provide a stocking blank of the type specified, wherein the usual relatively wide, bulging, and unsightly looping seams at the heel and foot sections are obviated, and narrow flat seams of smooth and even appearance are formed therein.

The method of the present invention is further characterized by the fact that the foot fabric is automatically turned to a position at right angles to the general direction of the leg fabric as the heel fabric is being knitted, and that said foot fabric is automatically transferred for interlooping connection with said heel fabric as the knitting thereof progresses, whereby the leg, foot, high-splice, and heel portions become integral and continuous parts.

Other important objects and advantages of the invention will be in part obvious and in part pointed out hereinafter.

In order that the invention and its mode of operation may be readily understood by persons skilled in the art, I have in the accompanying drawings, and in the detailed description based thereupon, set out possible embodiments of the same. In these drawings:

Figure 1 is a side elevation of a finished stocking constructed in accordance with the invention.

Figure 2 shows the stocking blank including the leg and foot portions knitted in accordance with the invention.

Figure 3 shows the blank of Figure 2 with the heel tabs knitted therein.

Figure 4 is an enlarged detail of the blank diagrammatically illustrating the formation of the severing courses.

Figure 5 is a view similar to Figure 4 diagrammatically illustrating a modification of the invention wherein a pull-out thread is used instead of the severing courses.

Figure 6 diagrammatically shows a portion of the blank severed and folded for topping onto the needles of an ordinary footer converted to form the heel tabs.

Figure 7 diagrammatically shows the portion of the blank of Figure 6 at the completion of the heel tabs.

Figure 8 diagrammatically shows the method of uniting the edges of the heel tabs.

Figure 9 diagrammatically shows the engagement of loops with sets of knitting and non-knitting needles.

Figures 10, 11, and 12 diagrammatically illus-

trate various methods of transferring loops of the foot portion for interlooping engagement with the heel tabs as the knitting thereof progresses.

Figure 13 diagrammatically shows the method of uniting the heel tabs.

Having more particular reference to the drawings, wherein like characters of reference will designate corresponding parts throughout, I have shown in Figure 1 a completed stocking 1 including the welt 2, the leg 3, the high-splice heel 4, the heel proper 5, the instep 6, the sole 7, and the toe 8.

In carrying out my improved method, the leg 3 with the high-splice heel 4, sole 7, and toe 8 are knitted contiguously on one machine. The high-splice heel 4, together with the sole 7 and toe 8 may be reinforced by introducing additional yarns in the usual manner, as shown at 9 in Figures 4 and 5 of the drawings.

At the point between the high-splice heel 4 of the leg 3 and the sole 7 of the foot, where the blank is to be severed for the insertion of the heel tabs, there are knitted series of partial loose courses 10 which extend from the selvedge edges for a predetermined distance into the body of the blank, the length of the partial loose courses depending upon the desired width of the heel tabs to be inserted in the fabric.

The provision of the partial loose courses 10, it will be understood, affords a convenient guiding line for the severing of the fabric and, for that purpose, the feed of the additional reinforcing yarn 9 is preferably stopped during the formation of said partial loose courses as is more clearly shown in Figure 4.

It is also contemplated to introduce a pull-out thread 11 at one of the loose courses 10 whereby, upon removing said pull-out thread 11, the leg and foot fabrics at the high-splice heel section 4 and sole section 7 will separate, thus obviating the necessity of cutting into the fabric.

Subsequent to the separation of the fabric, as stated, the foot portion is folded over the leg portion, and the sole sections 7 are folded upon the instep section 6 in the manner more clearly represented in Figure 6 of the drawings. By folding the stocking blank in the manner specified, it will be appreciated that the marginal row of loops 12 of the high-splice heel 4, and the marginal row of loops 13 of each of the sole fabrics 7 lay substantially on a straight line, as indicated at 14, so that said rows of loops 12 and 13 may be topped on the bank of needles of a footer converted to knit the heel tabs.

It is to be noted that because of the folding of the blank, as above set forth, the loops of the foot and sole sections are reversed so that, in the topping operation, the sinker portion of the marginal row of loops 13 of each sole section 7 will engage the corresponding needles of the converted footer, whereas the needle portion of the marginal row of loops 12 of each high-splice heel section 4 will engage the associated needles of said footer in the manner more clearly represented in Figure 9 of the drawings.

The converted footer is provided with two sets of needles, diagrammatically shown in Figures 9, 10, 11, and 12, one set of needles 15 being non-knitting needles, the other set of needles 16 being adapted to knit in the usual way.

As shown, the non-knitting needles 15 preferably consist of needles having shortened beards, which prevent the loops 13 on said needles from being pressed off during the knitting of the heel tabs 5. It is also possible to use ordinary knitting needles, instead of the shortened beard needles and, in this event, the usual presser edge, which is disposed opposite said needles, may be removed so that the needles will not press off, or the needles may be so mounted as to be moved away from their associated presser edge, which will likewise prevent pressing off.

Associated with the non-knitting needles 15 are transfer points 17 devised to pick the loops 13 off said non-knitting needles 15 and transfer them for interlooping engagement with the adjacent end loops 18 of the courses 19 constituting the heel tabs 5 as the same are being knitted.

The loops 13 on the non-knitting needles 15 are transferred the distance of one or more wales, as necessity or preference may dictate. In Figure 10, I have illustrated the single wale transfer. According to this mode of operation of knitting the heel tabs 5 and simultaneously joining the sole portions 7 thereto, the transfer points 17 descend and pick all the loops 13 off the non-knitting needles 15 and transfer said loops one needle distance, which places each end loop successively in engagement with the end knitting needle of the row of needles 16. An intermediate course 20 may be knitted on needles 16 between each transfer operation to provide the necessary fabric for the formation of the heel and to insure sufficient elasticity in the foot. This operation is repeated until all the loops 13 on the non-knitting needles 15 have been transferred the distance of one needle at a time, and interknitted to form a seam 21 uniting the sole portions 7 to the heel tabs 5.

In Figure 11, I have illustrated the two wale distance transfer. As shown, the transfer points 17 move the distance of two needles after having picked off the loops 13. It will be appreciated that since the two needle transfer, as compared with the single needle transfer, cuts in half the number of "dips" required to transfer the number of loops topped on the non-knitting needles 15, the two needle transfer operation will speed production in interknitting the loops in the manner heretofore described. However, at least three extra courses are found necessary after each interknitting course, to give the proper length to the heel, resulting in producing small openings at the line of juncture between the sole and the heel.

The defect above mentioned can be overcome by following the method of operation shown in Figure 12. In practicing this latter mode of operation, two sets of transfer points 22 and 23 are provided on the knitting machine. The transfer points 22 and 23 are adapted to simultaneously pick off the loops 13 and while points 23 are moved the distance of two needles, the points 22 (preferably two in number) are moved the distance of three needles. It will be understood that by proceeding in this manner, the first wale 24 of the heel tabs 5 is left without transfer loops. While three extra courses are also required to be knitted between each transfer course, the holes which might result are not visible because the connections or joinings are all on the second and third wales of the tabs which are usually tighter and the first wale of the heel covers whatever small holes may result.

The transfer operation causes the marginal loops of the foot fabric to become interlooped with the adjacent marginal loops of the heel tab fabric and, accordingly, no seaming operation is necessary to unite the same. Further-

more, due to the transfer of the loops in the manner specified, the foot fabric is turned automatically at substantially right angles so that the finished blank assumes the proper shape to fit the foot of the wearer. After finishing the blank according to the method above described, the selvedge edges **25** thereof may be seamed together, as is customary, to constitute the back seam **26** (Figure 1), thus forming a complete stocking.

As stated, the invention also contemplates to unite certain parts of the blanks by interknitting the same. In Figures 8 and 13, I have shown the manner in which the heel tabs may be interknitted at their lower marginal edges. According to this feature of the invention, after the completion of the heel tabs **5**, the blank is folded upon itself to bring the lower edges of the heel tabs adjacent one another so that the marginal row of loops **27** of each heel tab may be topped respectively on two relatively spaced sets of non-knitting needles **28** and **29**. Arranged between the spaced sets of non-knitting needles **28** and **29** is a set of knitting needles **30**, preferably two in number, although this number may be increased if desired. A yarn **31** is adapted to be suitably fed to the knitting needles **30** in order that relatively short courses **32** may be knitted therefrom.

Associated with each set of non-knitting needles **28** and **29** are sets of narrowing points **33** and **34**, respectively disposed to engage the rows of loops **35** and **36** and progressively transfer them in the manner set forth in the description of the knitting of the heel tabs, whereby the end loop of each row will become interlooped with the adjacent loops of the relatively short courses **32**, as more clearly shown in Figure 13 of the drawings.

It will be understood that the toe section of the foot at the point **37** (Figure 1) may be joined in the same manner as the lower edge of the heel tabs.

I wish it to be understood that the stocking construction and the method of forming the blank therefor may slightly vary without departing from the spirit of the invention. Accordingly, those modifications which come within the scope of the following claims are to be considered within the spirit of the invention.

I claim:

1. The method of uniting two knitted fabrics comprising topping the marginal loops of a knitted fabric on a set of non-knitting needles, topping the marginal loops of another knitted fabric on a set of knitting needles, knitting a series of courses as a continuation of the fabric topped on the knitting needles, and transferring the loops topped on the non-knitting needles to engage and interloop the adjacent loops of said courses.

2. The method of uniting two knitted fabrics comprising topping the marginal loops of a first knitted fabric on a set of non-knitting needles, topping the marginal loops of a second knitted fabric on a set of knitting needles, knitting a third fabric as a continuation of the said second fabric, transferring the loops topped on the non-knitting needles to engage and interloop the adjacent loops of said third fabric, and knitting plain courses in said third fabric at intervals between the transfer of said loops.

3. The method of uniting two knitted fabrics comprising topping the marginal loops of a first knitted fabric on a set of non-knitting needles, topping the marginal loops of a second knitted fabric on a set of knitting needles, knitting a third fabric as a continuation of the second fabric, transferring the loops topped on the non-knitting needles to engage and interloop the adjacent loops of said third fabric, and knitting plain courses in said third fabric between each transfer of said loops.

4. The method of uniting two knitted fabrics comprising topping the marginal loops of a first knitted fabric on a set of non-knitting needles, topping the marginal loops of a second knitted fabric on a set of knitting needles, knitting a third fabric as a continuation of the second fabric, transferring the loops topped on the non-knitting needles to engage and interloop the adjacent loops of said third fabric, and knitting a plain course in said third fabric between each transferring of said loops.

5. The method of manufacturing stocking blanks of the single unit type comprising knitting as a continuous operation a stocking blank including a leg portion and a foot portion, partially separating the leg portion from the foot portion at the opposite marginal edges of the blank, topping the separated marginal loops of the leg portion on a set of knitting needles, topping the separated marginal loops of the foot portion on a set of non-knitting needles, and knitting heel tabs as a continuation of the loops topped on the knitting needles while transferring the loops on the non-knitting needles to engage and interloop the adjacent loops of the heel tabs, as the knitting thereof progresses.

6. The method of manufacturing stocking blanks of the single unit type comprising knitting as a continuous operation a stocking blank including a leg portion and a foot portion, partially separating the leg portion from the foot portion at the opposite marginal edges of the blank, topping the separated marginal loops of the leg portion on a set of knitting needles, topping the separated marginal loops of the foot portion on a set of non-knitting needles, knitting heel tabs as a continuation of the loops topped on the knitting needles while transferring the loops on the non-knitting needles to engage and interloop the adjacent loops of the heel tabs as the knitting thereof progresses, and knitting plain courses in said heel tabs at intervals between the transfer of the loops.

7. The method of manufacturing stocking blanks of the single unit type comprising knitting as a continuous operation a stocking blank including a leg portion and a foot portion, partially separating the leg portion from the foot portion at the opposite marginal edges of the blank, topping the separated marginal loops of the leg portion on a set of knitting needles, topping the separated marginal loops of the foot portion on a set of non-knitting needles, knitting heel tabs as a continuation of the loops topped on the knitting needles while transferring the loops on the non-knitting needles to engage and interloop the adjacent loops of the heel tabs as the knitting thereof progresses, and knitting plain courses in said heel tabs between each transfer of the loops.

8. The method of manufacturing stocking blanks of the single unit type comprising knitting as a continuous operation a stocking blank including a leg portion and a foot portion, partially separating the leg portion from the foot

portion at the opposite marginal edges of the blank, topping the separated marginal loops of the leg portion on a set of knitting needles, topping the separated marginal loops of the foot portion on a set of non-knitting needles, knitting heel tabs as a continuation of the loops topped on the knitting needles while transferring the loops on the non-knitting needles to engage and interloop the adjacent loops of the heel tabs as the knitting thereof progresses, and knitting a plain course in said heel tabs between each transfer of the loops.

9. The method of uniting two knitted fabrics comprising topping the marginal row of loops of each fabric on two relatively spaced sets of non-knitting needles, knitting courses between the fabrics topped on said spaced sets of non-knitting needles, and transferring the loops topped on the non-knitting needles for interlooping engagement with the adjacent loops of said courses as the knitting thereof progresses.

10. The method of uniting two knitted fabrics comprising topping the marginal row of loops of each fabric on two relatively spaced sets of non-knitting needles, knitting courses between the fabrics topped on said spaced sets of non-knitting needles, and transferring the loops topped on the non-knitting needles for interlooping engagement with the adjacent loops of certain of said courses as the knitting thereof progresses.

11. The method of uniting two knitted fabrics comprising topping the marginal row of loops of each fabric on two relatively spaced sets of non-knitting needles, knitting courses between the fabrics topped on said spaced sets of non-knitting needles, and transferring the loops topped on the non-knitting needles for interlooping engagement with the adjacent loops of every other one of said courses as the knitting thereof progresses.

12. The method of forming a heel tab in a stocking blank having integrally knitted leg and foot fabrics comprising partially separating the leg fabric from the foot fabric at the marginal edge of the blank to provide a pair of separated partial courses of loops, knitting a heel tab fabric onto the loops of the separated partial course of the leg fabric and transferring the loops of the separated partial course of the foot fabric for interlooping engagement with the adjacent loops of said heel tab as the knitting thereof progresses.

13. The method of forming a heel pocket in a stocking blank having integrally knitted leg and foot fabrics comprising partially separating the leg fabric from the foot fabric at the opposite marginal edges of the blank to provide pairs of separated partial courses of loops, knitting a heel tab fabric onto the loops of each of the separated partial courses of the leg fabric, transferring the loops of each of the separated partial courses of the foot fabric for interlooping engagement with the adjacent loops of the heel tabs as the knitting thereof progresses, knitting relatively short courses between the loops of the last course of each of the heel tabs while transferring the loops of said last courses for interlooping engagement with the adjacent loops of the relatively short courses, and seaming the selvedge edges of the heel tabs.

14. The method of knitting a heel portion onto the leg and foot portions of a combination stocking blank which comprises knitting heel courses onto the leg portion of the blank, and during the knitting of said courses interknitting the inner edge of said heel portion into the adjoining portion of the foot fabric.

15. The method of knitting the heel portions into a combination foot and leg stocking blank having the foot portion knited onto the leg, which comprises separately supporting those portions of the last course of leg fabric and those portions of the first course of the foot fabric to which the heel portions are to be knitted, knitting heel courses into said supported course of leg fabric and during the knitting of following heel courses, successively knitting adjoining wale loops of said supported foot fabric course into the inner selvage edges of the heel portions.

16. The method of knitting a stocking which consists in knitting the leg section and the foot section of the stocking as a contiguous unitary fabric; separating a portion of the leg section from a portion of the foot section; knitting a heel tab as a continuation of the separated portion of the leg section; and interknitting in overlapping relation loops of the heel tab and loops of the foot section to form a connection therebetween as the knitting of said heel tab progresses.

17. The method of knitting a full-fashioned stocking which consists in knitting the leg section, the instep section, the sole sections, and the toe section of the stocking as a contiguous unitary fabric; separating the sole sections from the adjoining portions of the leg section; knitting heel tabs as knitted continuations of the separated portions of the leg section; and interknitting in overlapping relation loops of the heel tabs along one edge thereof and loops of the sole sections to form a connection between the heel tabs and the sole sections as the knitting of the heel tabs progresses.

18. The method of knitting a full-fashioned stocking which consists in knitting the leg section, instep section, sole sections, and toe section of the stocking as a contiguous unitary fabric; cutting the sole sections from the adjoining portions of the leg section; knitting a heel tab as a continuation of each cut portion of the leg section; and interknitting in overlapping relation the selvedge loops of one of the selvedge edges of each heel tab with a course of loops of the corresponding cut sole section to form a connection therebetween as the knitting of the heel tabs progresses.

19. The method of knitting a stocking which consists in knitting the leg section and the foot section of the stocking as a contiguous unitary fabric; separating a portion of the leg section from a portion of the foot section; knitting a heel tab as a continuation of one separated portion; and interconnecting the heel tab and other separated portion by interknitting in overlapping relation loops of the heel tab and loops of said other separated portion as the knitting of the heel tab progresses.

20. A method for seaming together at least two edge portions of a full-fashioned stocking blank on the needles of a needle bar, each of said edge portions being formed by a plurality of free terminal wale loops; said method including the steps of providing the terminal wale loops of said edge portions on the needles of said needle bar; interknitting a yarn with the adjacent terminal wale loops of the two edge portions; and then interknitting said yarn with the remainder of said terminal wale loops in a plurality of series of operations; each of said series of operations comprising at least one transfer of loops in one of said edge portions from one group of said

needles to another group of said needles, forming a course of loops on a certain group of needles of said needle bar after each transfer, and pressing off all but the newly formed loops from said last-named group of needles after each course of loops is formed thereon.

21. In a method for making a knitted article, the steps comprising knitting two groups of wales and then seaming together the terminal loops of one group of wales and the terminal loops of the other group of wales by knitting a plurality of courses and simultaneously interknitting certain of the loops of said courses with certain of said terminal loops.

22. The method of seaming together the terminal wale loops at the ends of the two heel tabs of a stocking blank which comprises the steps of providing the terminal loops at the end of said heel tabs on two groups of needles; knitting a plurality of courses of loops on certain knitting needles adjacent the inner edges of said heel tabs, and transferring the heel tabs towards each other between successive courses a distance of at least one needle and not more than the number of said certain knitting needles until all of said terminal loops have been transferred to said knitting needles and united by said courses.

23. The method of uniting at least two knitted fabric portions comprising topping the marginal row of loops of each knitted fabric portion on two relatively spaced sets of non-knitting needles, knitting courses between the knitted fabric portions topped on said spaced sets of non-knitting needles, and transferring the loops topped on the non-knitting needles for interlooping engagement with the adjacent loops of said courses as the knitting thereof progresses.

24. The method of uniting at least two knitted fabric portions comprising topping the marginal row of loops of each knitted fabric portion on two relatively spaced sets of non-knitting needles, knitting courses between the knitted fabric portions topped on the non-knitting needles, and transferring the loops topped on the non-knitting needles for interlooping engagement with the adjacent loops of certain of said courses as the knitting thereof progresses.

25. The method of uniting at least two knitted fabric portions comprising topping the marginal row of loops of each knitted fabric portion on two relatively spaced sets of non-knitting needles, knitting courses between the knitted fabric portions topped on said spaced sets of non-knitting needles, and transferring the loops topped on the non-knitting needles for interlooping engagement with the adjacent loops of every other one of said courses as the knitting thereof progresses.

26. The method of interknitting terminal loops of a full-fashioned knitted hosiery blank which consists in placing a series of terminal loops upon a portion of a row of needles of a knitting machine, placing another series of terminal loops upon another portion of the row of needles of the knitting machine, separated from the first portion by an intermediate group of needles, and knitting courses from a separate thread upon said intermediate set of needles and interlooping the same with the two series of terminal loops.

27. The method of seaming at least two individual normally separated courses of hosiery fabric which consists in placing said courses upon the needles of a knitting machine and interknitting courses of loops with said normally separated courses.

28. A method for seaming together two edge portions of a full-fashioned stocking blank on the needles of a needle bar, each of said edge portions being formed by a plurality of free terminal wale loops, said method comprising the steps of providing the loops of said edge portions on the needles of said needle bar, knitting a plurality of courses, each of said courses being knit only on certain of the needles of said needle bar, and transferring at least the terminal wale loops of one of said edge portions from one group of needles to another group of needles prior to the forming of the loops of each of said courses on the needles of said needle bar, said knitting and transfer operations being so related that said yarn is interknit with the terminal wale loops of both stocking edge portions to seam them together.

29. The method of seaming together the terminal wale loops at the ends of the two heel tabs of a stocking blank which comprises the steps of providing the terminal loops at the end of said heel tabs on two groups of needles, knitting a plurality of courses of loops on certain knitting needles adjacent the inner edges of said heel tabs, and transferring the heel tabs towards each other between successive courses until all of said terminal loops have been transferred to said knitting needles and united by said courses.

30. The method of seaming together two stocking portions having wales extending to their respective end edges and terminating in free loops, by interknitting a yarn with said loops, said method comprising the steps of forming loops of said yarn on at least two operative needles which are intermediate of two groups of idle needles, placing adjacent terminal loops on said two operative needles and the remaining terminal loops of the respective stocking portions on said idle needles, continuing said knitting by forming another course of loops of said yarn on said operative needles and then pressing off from said operative needles all but said last-named course of loops, transferring the remaining terminal loops of each portion to place the innermost terminal loop of each portion on said operative needles and the other terminal loops on idle needles, and repeating said course forming, pressing-off, and transfer operations until all of the terminal loops of the two stocking portions have been interknitted with said yarn to form a seam for the stocking portions.

31. In the finishing of a stocking made from a full-fashioned stocking blank having edge portions formed of terminal wale loops, the method comprising knitting courses of yarn to form a strip of knitted material, and joining said terminal wale loop edge portions to form a seam therefor by interknitting said terminal wale loops and said strip.

32. In the finishing of a stocking made from a full-fashioned stocking blank having heel portions with edges formed of free terminal wale loops, the method comprising knitting courses of yarn to form a strip of knitted material, and joining said terminal wale loop edges to form a seam therefor by interknitting said terminal wale loops and said strip.

33. The method of knitting a heel portion onto the leg and foot portions of a combination stocking blank comprising topping the marginal loops of the leg portion on a set of knitting needles, topping the marginal loops of the foot portion on

a set of non-knitting needles, and knitting heel tabs as a continuation of the loops topped on the knitting needles while transferring the loops from the non-knitting needles to engage and interloop the adjacent loops of the heel tabs as the knitting thereof progresses.

34. The method of knitting a heel portion onto the leg and foot portions of a combination stocking blank comprising topping the marginal loops of the leg portion on a set of knitting needles, topping the marginal loops of the foot portion on a set of non-knitting needles, knitting heel tabs as a continuation of the loops topped on the knitting needles while transferring the loops from the non-knitting needles to engage and interloop the adjacent loops of the heel tabs as the knitting thereof progresses, and knitting plain courses in said heel tabs at intervals between the transfer of said loops.

35. The method of knitting a heel portion onto the leg and foot portions of a combination stocking blank comprising topping the marginal loops of the leg portion on a set of knitting needles, topping the marginal loops of the foot portion on a set of non-knitting needles, knitting heel tabs as a continuation of the loops topped on the knitting needles while transferring the loops from the non-knitting needles to engage and interloop the adjacent loops of the heel tabs as the knitting thereof progresses, and knitting plain courses in the heel tabs between each transfer of the loops.

36. The method of knitting a heel portion onto the leg and foot portions of a combination stocking blank comprising topping the marginal loops of the leg portion on a set of knitting needles, topping the marginal loops of the foot portion on a set of non-knitting needles, knitting heel tabs as a continuation of the loops topped on the knitting needles while transferring the loops from the non-knitting needles to engage and interloop the adjacent loops of the heel tabs as the knitting thereof progresses, and knitting a plain course in said heel tabs between each transfer of the loops.

37. The method of uniting two knitted fabrics comprising topping the marginal loops of a knitted fabric on a set of non-knitting needles, topping the marginal loops of another knitted fabric on a set of knitting needles, knitting a series of courses as a continuation of the fabric topped on the knitting needles, and transferring the loops topped on the non-knitting needles to engage and interloop certain of the loops within said courses.

38. The method of uniting two knitted fabrics comprising topping the marginal loops of a first fabric on a set of non-knitting needles, topping the marginal loops of a second fabric on a set of knitting needles, knitting a third fabric with selvedge edges as a continuation of the second fabric, transferring the loops topped on the non-knitting needles to engage and interloop certain of the loops inwardly of the adjacent selvedge edge of said third fabric.

39. The method of uniting two knitted fabrics comprising topping the marginal loops of a first fabric on a set of non-knitting needles, topping the marginal loops of a second fabric on a set of knitting needles, knitting a third fabric with selvedge edges as a continuation of the second fabric, transferring the loops topped on the non-knitting needles to engage and interloop certain of the loops inwardly of the adjacent selvedge edge of said third fabric, and knitting plain courses in said third fabric at intervals between the transfer of said loops.

40. The method of uniting two knitted fabrics comprising topping the marginal loops of a first fabric on a set of non-knitting needles, topping the marginal loops of a second fabric on a set of knitting needles, knitting a third fabric with selvedge edges as a continuation of the second fabric, transferring the loops topped on the non-knitting needles to engage and interloop certain of the loops inwardly of the adjacent selvedge edge of said third fabric, and knitting a plain course in said third fabric between each transfer of said loops.

41. The method of producing a fabric, which comprises knitting a blank to have adjacent loose loop course portions in walewise register, folding the blank near adjacent ends of said course portions to remove said portions from said register and to have them substantially in coursewise alinement, topping the aligned course portions onto loop-manipulating implements of a knitting machine, knitting from one of said course portions a fabric insert while preventing the knitting of loops to said other course portion, and transferring loops of the latter portion to loops knitted to said one course portion during the knitting of the insert.

42. The method of producing a full-fashioned stocking blank, which comprises knitting on one machine the entire blank except half heel pocket elements at opposite sides of the blank, but providing adjacent loose loop course portions in walewise register at each of said sides, folding the blank near adjacent ends of said course portions to remove the same from said register and to have them substantially in coursewise alignment, topping the aligned course portions onto loop-manipulating implements of a knitting machine, knitting from one of said course portions at each of said sides a heel pocket insert while preventing the knitting of loops to the adjacent said other course portion, and transferring loops of the latter portion to loops knitted to the adjacent said one portion during the knitting of the insert.

43. The method of producing a fabric, which comprises knitting a blank to have adjacent loose loop course portions in walewise register, folding the blank near adjacent ends of said course portions to remove said portions from said register and to have them substantially in coursewise alignment, topping the aligned course portions onto loop-manipulating implements of a knitting machine, knitting from one of said course portions a fabric insert of a given number of courses greater than the number of loops in said other course portion while preventing the knitting of loops to the latter portion, and transferring loops of the latter portion to loops knitted to said one course portion in selected distribution substantially throughout the length of said insert during the knitting of the latter.

44. The method of producing a fabric, which comprises knitting a blank to have adjacent loose loop course portions in walewise register, folding the blank near adjacent ends of said course portions to remove said portions from said register and to have them substantially in coursewise alignment, topping the aligned course portions onto loop-manipulating implements of a knitting machine, with one of said portions on a group of loop-manipulating implements having long beards and the other on a group of loop-manipulating implements having short beards, knitting

from said one course portion a fabric insert while preventing casting of loops from the implements having the short beards, and successively transferring loops from the short beard implements to long beard implement loops during the knitting of the insert.

45. The method of producing a fabric, which comprises knitting a blank to have adjacent loose loop course portions in walewise register, folding the blank near adjacent ends of said course portions to remove said portions from said register and to have them substantially in coursewise alignment, topping the aligned course portions onto loop-manipulating implements of a knitting machine, with one of said portions on a group of implements having long beards and the other on a group of implements having short beards, knitting from said one course portion a fabric insert of a given number of courses greater than the number of loops in said other course portion while preventing the forming of loops on, and the casting of loops from, the implements having the short beards, and successively transferring loops from the short beard implements to long beard implement loops in selected distribution substantially throughout the length of said insert during the knitting of the latter.

46. A method of uniting preknitted fabric portions comprising interknitting loops of said portions with yarn while knitting the latter into courses and wales.

47. A method of forming a knitted seam for fabric portions comprising interjoining said portions with yarn while knitting the latter into courses and wales.

48. A method of uniting at least two knitted fabric portions on a knitting machine having at least two sets of needles, comprising knitting successive courses on one set of needles and successively transferring loops from the other set of needles onto the first mentioned set of needles as the courses of loops are knitted by the latter.

49. A method of providing a knitted fabric insert between portions of pre-knitted fabric, comprising knitting the insert and simultaneously therewith transferring loops of said portions to be interknitted with said insert.

50. A method of providing a knitted fabric insert between two portions of pre-knitted fabric, comprising knitting the insert onto loops of one of said portions and simultaneously therewith transferring loops of the other of said portions to be interknit with said insert.

51. A method of knitting, comprising engaging loops of knitted fabric portions with needles of a knitting machine, operating the machine to knit yarn into loops and, during such knitting, transferring said loops of the knitted fabric portions for interknitting with the loops being knitted from said yarn.

52. A method of knitting, comprising engaging loops of at least two knitted fabric portions with needles of a knitting machine, operating the knitting machine to knit yarn into loops as continuations of the loops of one of said knitted fabric portions and, during such knitting, transferring the loops of the other of said knitted fabric portions for interknitting with the loops being knitted from said yarn.

53. A method for seaming together at least two portions of knitted fabric on the needles of a needle bar, each of said portions having a row of free loops, said method comprising the steps of providing said free loops on needles of said needle bar, knitting a yarn on needles of said needle bar to form a plurality of courses of loops, and interknitting said yarn with the free loops in both of said rows during the formation of said courses.

54. A method for seaming knitted fabric, said fabric having groups of loops, and the method to be performed with the aid of loop supporting means including a group of active needles, said method comprising the steps of knitting yarn on said active needles to form a series of connected courses, providing said fabric loops on said loop supporting means, transferring the loops in said loop groups onto said active needles, the loops in said groups being transferred in succession to said needles and during the formation of said series of courses, whereby said loop groups are interknitted with and joined by said yarn.

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