Dec. 26, 1950 N. DI PIETRO 2,535,487

TROUSER FLY CONSTRUCTION

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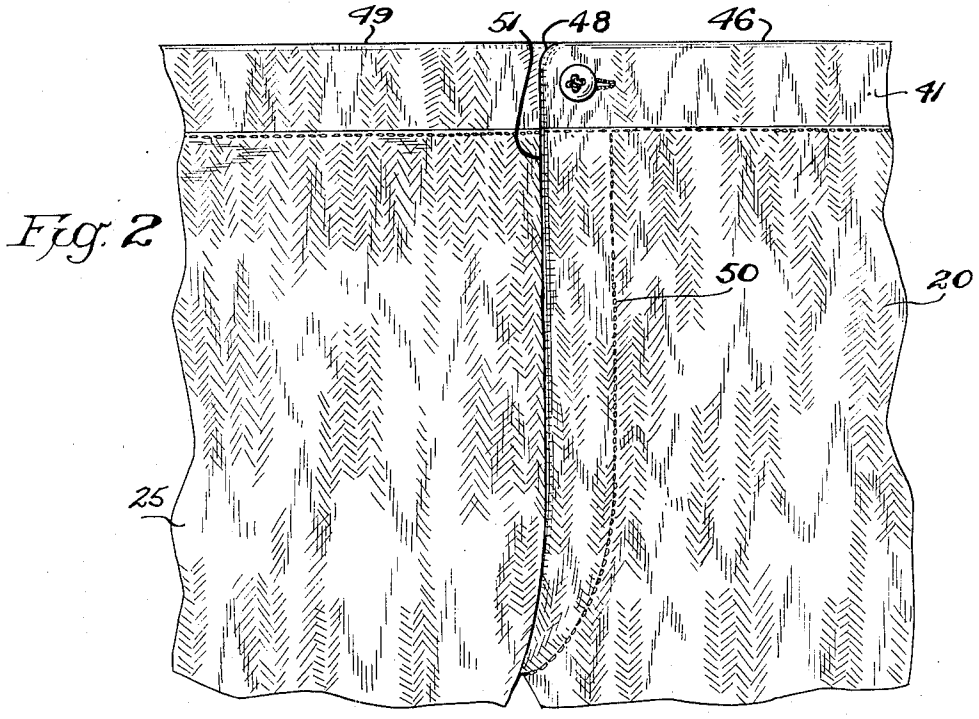


Fig. 2

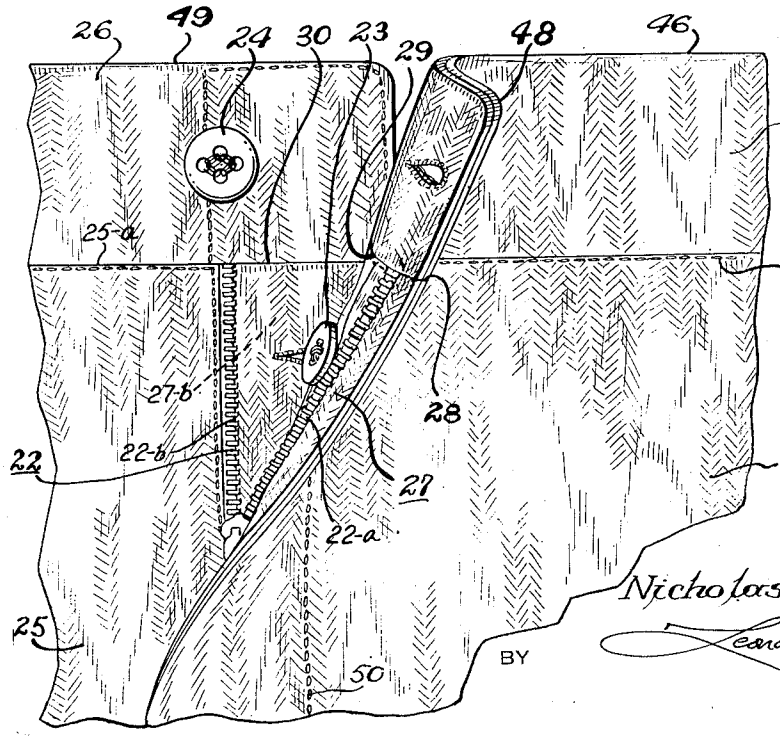


Fig. 1

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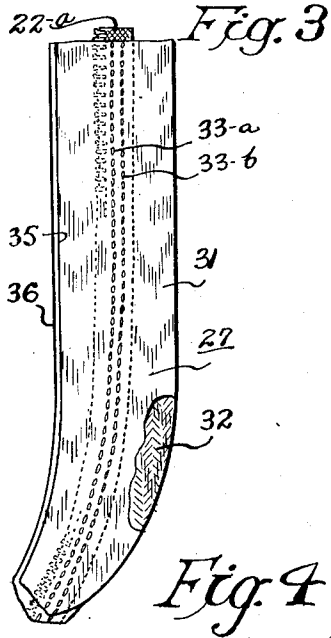
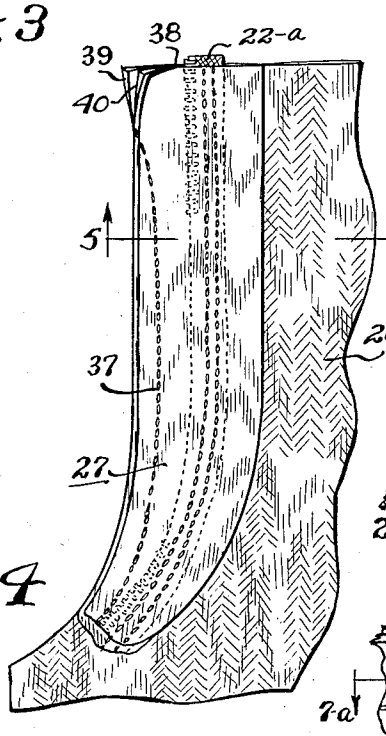


Fig. 3

Fig. 4



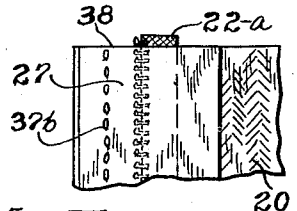


Fig. 4-a

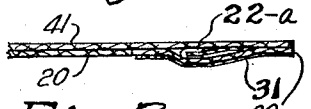


Fig. 7

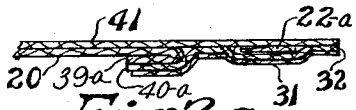


Fig. 7-a

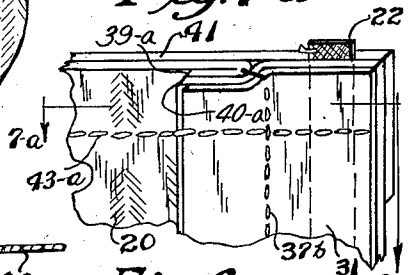


Fig. 6-a



Fig. 5

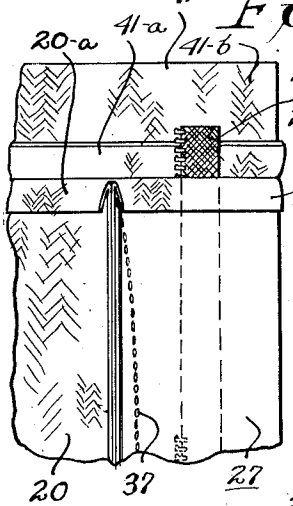


Fig. 8

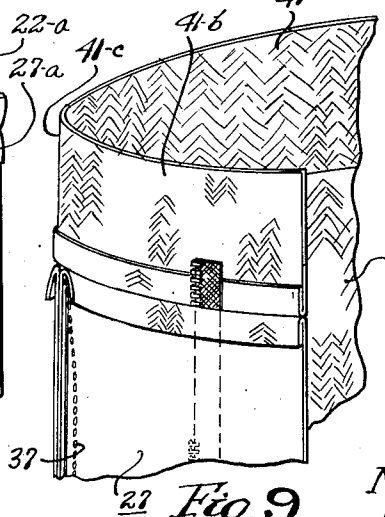


Fig. 9

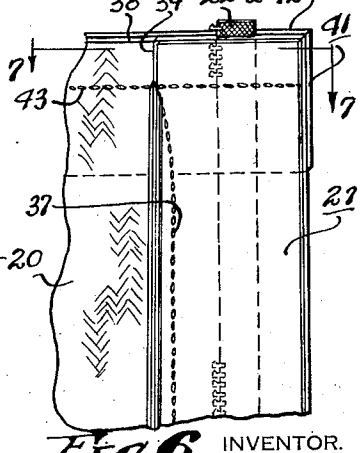


Fig. 6

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Fig. 10

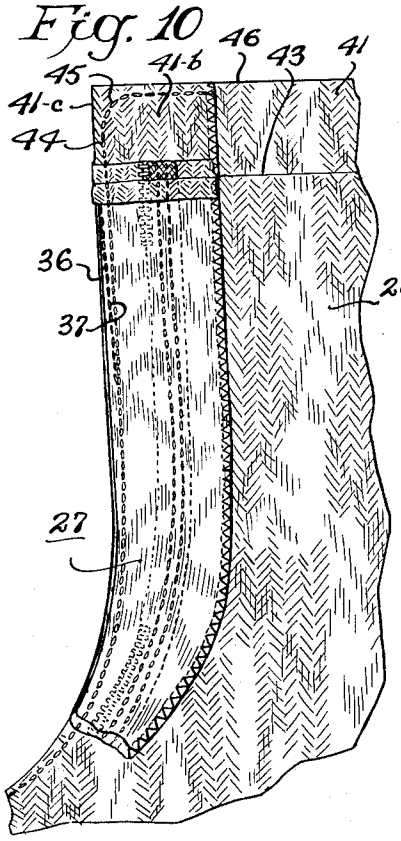
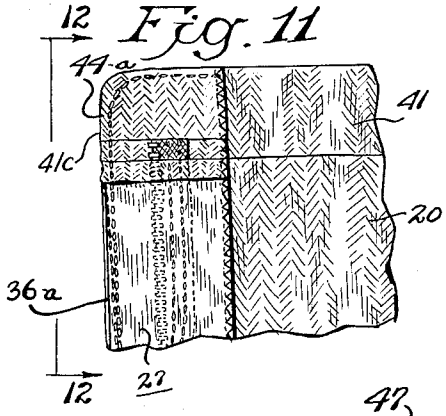


Fig. 11



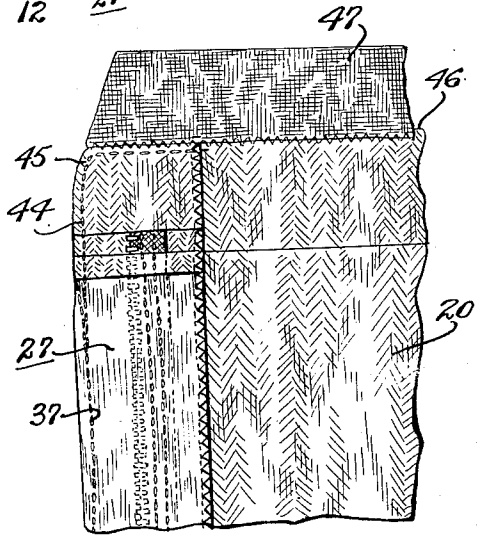


Fig. 13

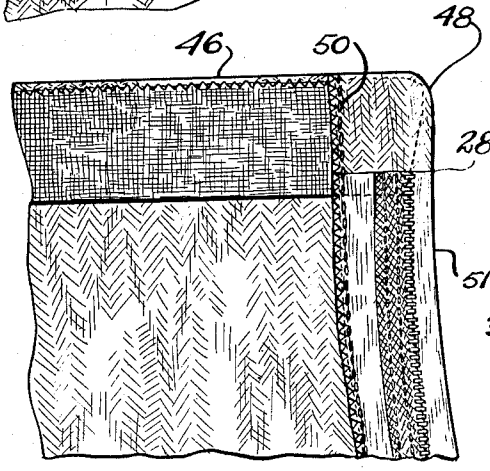


Fig. 14

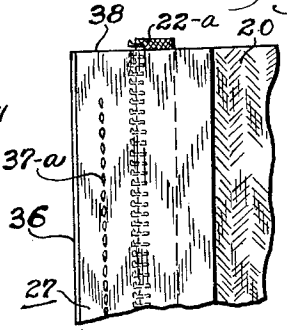


Fig. 15

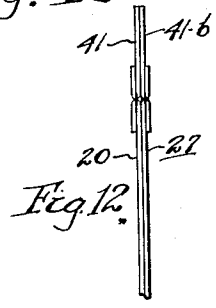


Fig. 12

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UNITED STATES PATENT OFFICE

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TROUSER FLY CONSTRUCTION

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Application June 11, 1949, Serial No. 98,490

8 Claims. (Cl. 2—234)

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The present invention relates to wearing apparel and particularly to trousers or slacks or the like.

An object of the present invention is to provide a trousers construction, and method of making the same, which will be pleasing in appearance and comfortable when worn.

Another object of the present invention is to provide a trousers construction which will be flat and non-bulky in the area of the separable fastening and which will lie flat against the waist of the wearer.

Another object of the present invention is to provide a method of constructing the waistband portion of a pair of trousers or the like, which will be an inexpensive, easy and rapid method of assembly and which will produce a far superior garment than heretofore available.

An additional object of the present invention is to provide a trousers construction which includes a slide-fastener as a closure member, and which provides neat and effective means for attaching the closure member to the fly-portion of the trousers.

Another object is to provide a fly construction for trousers wherein the upper corner is rounded and the waistband edge and fly-edge blend together around a radius.

Further objects of the present invention will be readily discernible by reference to the appended specification, claims and drawings.

Where a slide-fastener is used as the closure member of a pair of trousers or the like, it is desirable to conceal the uppermost end of the slide-fastener tape in order to provide the garment with a neat appearance. This conventionally requires that the waistband extend beyond and over the uppermost edge of the fly-portion (which is generally co-extensive with the uppermost edge of the slide-fastener tape). This conventional type of construction is not entirely satisfactory because it results in excessive bulk at the juncture zone of the waistband, the fly-portion and the leg-portion and, in addition, makes it impossible to finish off the waistband with the rounded corner which is considered important in good tailoring.

In attempts to eliminate this extra bulkiness and to secure the rounded edge construction, various special constructions have been suggested which have the disadvantage of requiring extra pieces and additional stitching operations such as appreciably add to the cost of the garment.

The present invention contemplates a new and improved construction whereby this excessive

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bulkiness is eliminated and the rounded corner obtained without the need for extra pieces or stitching operations and at a cost no greater than is the case with conventional constructions.

Generally speaking, the present invention comprehends a new and improved trousers construction as well as a novel method of making the same whereby the seam fastening the outer edge of the fly-portion to the corresponding edge of the leg-portion is formed in such a manner as to minimize the excessive bulkiness at the juncture point of the leg and fly-portions with the waistband, and whereby a second seam is thereafter applied so as to extend upward as a straight-line continuation of the first-mentioned seam and across and around the inturned end of the waistband portion so as to permit trimming off of the straight edges at the corner of the waistband portion, thereby providing a final construction wherein the vertical seam at the free edge of the waistband portion extends as a direct straight line continuation from the seam connecting the fly-portion to the leg-portion, and, at the same time, providing a smoothly-curved upper free edge for the waistband.

For the purpose of illustrating the invention, there are shown in the accompanying drawings, forms thereof which are at present preferred, although it is to be understood that the various instrumentalities of which the invention consists can be variously arranged and organized and that the invention is not limited to the precise arrangements and organizations of the instrumentalities as herein shown and described.

Referring to the accompanying drawings wherein like reference characters refer to like parts:

Fig. 1 represents a fragmentary front elevational view of a trousers embodying the present invention, with the fly-portion thereof in partly open position.

Fig. 2 represents a fragmentary front elevational view of the embodiment of Fig. 1, with the fly-portion in closed position.

Fig. 3 represents an elevational view of a liner and slide-fastener tape when sewed to the fly-panel of a trousers.

Fig. 4 represents an elevational view of the fly-panel assembly of Fig. 3 attached to a leg-panel of a trousers.

Fig. 4—*a* represents an elevational view of the fly and leg panel assembly according to prior practice.

Fig. 5 represents a horizontal, cross-sectional view taken along line 5—5 of Fig. 4.

Fig. 6 represents a fragmentary elevational view of the fly-panel and leg-panel assembly of Fig. 4 attached to the waistband portion of a trousers.

Fig. 6—*a* represents a fragmentary elevational view of the leg, waistband and fly-panel assembly according to prior practice.

Fig. 7 represents a cross-sectional view along lines 7—7 of Fig. 6.

Fig. 7—*a* represents a cross-sectional view along lines 7—*a*—7—*a* of Fig. 6—*a*.

Fig. 8 represents a fragmentary elevational view of the assembly of Fig. 6 with the waistband panel turned up so as to lie in the same plane as the leg and fly-panels and with the overlapping ends generally pressed flat against their respective body-portions.

Fig. 9 represents a perspective view of the assembly of Fig. 8, but with the fly portion and end of the waistband portion partly turned back against the leg panel and waistband panel.

Fig. 10 represents a fragmentary elevational view of fly panel and end of the waistband panel fully turned back against the waistband and leg panels and with a line of stitching fastening the turned-back portions to the leg panel and waistband panel.

Fig. 11 represents a fragmentary elevational view like that of Fig. 10, but with a portion of the vertical edge 41—*c* of the waistband portion protruding beyond the line of stitching removed.

Fig. 12 represents a vertical elevational view generally along 12—12 of Fig. 11.

Fig. 13 represents a fragmentary elevational view like that of Fig. 11, but with a liner-portion attached to the waistband member.

Fig. 14 represents a fragmentary front elevational view of the inside of the completed trousers.

Fig. 15 represents a view generally like Fig. 4, but showing a modification thereof.

Referring now to Figures 1 and 2, there is shown a trousers construction including a left-leg panel 20, permanently attached by stitches 21, to a left waistband portion 41, a slide-fastener 22, composed of tape-and-element portions 22—*a* and 22—*b*, buttons 23 and 24, and a right leg-portion 25, permanently attached by stitches 25—*a* to a right waistband portion 26. A "black-fly" portion, shown generally as at 27, is secured to the extreme edge of the left leg-panel, in a manner to be more fully disclosed hereinafter, so as to overlie and cooperate with a "white-fly" portion 27—*b* attached to a right leg panel 25 and a right waistband panel 26.

As is shown in Figure 1, the method employed in securing the slide fastener tapes 22—*a* and 22—*b* to the trousers requires seam-lines 29 and 30 between the fly-portions and waistband portions whereby the ends of the slide-fastener tapes may be securely and neatly concealed underneath the waistband.

The first step in constructing the waistband of the present invention is the assembly of the fly 27, and is shown in Figure 3. A generally elongated liner portion 31, having substantially the same shape as the fly-portion 32, is securely fastened to said fly-portion and to the slide-fastener tape 22—*a* by rows of stitching 33—*a* and 33—*b* with the edge 35 of the liner 31 spaced slightly away from the outer edge 36 of the fly portion 32. Both the fly portion 32 and the liner 31 may be somewhat "J-shaped" so as to conform generally to the body of the wearer, following a pattern well known to those skilled in the art.

Referring now to Figure 4, this view shows that the fly 27 is attached to the leg panel 20, by a row of stitching 37, spaced somewhat away from the edges 35 and 36, and for the most part parallel to said edges. However, it is noted that near the top of the assembled members the row of stitching 37 gradually approaches the edge 36, so as to meet the edge 36 at a point somewhat below the extreme upper edge 38 of the assembled body-portion and fly-portion. The point at which the seam 37 contacts the edge 36 should be approximately one-half inch (½") below the edge 38, but this dimension may vary somewhat. That is to say, the seam 37 may contact the edge 36 somewhat below or somewhat above the point indicated, but nevertheless terminate in such a manner that approximately ½" of the fly-portion and leg-portion may be separated easily (as at 39 and 40).

As shown in Figure 15, the leg-panel 20 and fly-assembly 27, may, instead, be attached by a seam 37—*a* which, at all points, is generally equidistant from the edge 36, and which terminates somewhat short of the upper edge 38. This assembly provides an upper portion of the leg panel 20 and the fly-assembly 27 which is not secured by the seam 37—*a*.

In each of the embodiments of Figures 4 and 15, therefore, the seam 37 (or 37—*a*) does not bind together the upper portions 39 and 40 of the members 20 and 27. The function of this gap will be more fully disclosed hereinbelow.

After the leg portion 20 and the fly-portion 27 have been secured by the seam 37, the assembled members are then secured to the waistband portion 41, as shown particularly in Figure 6. In this step the leg portion 20 is pivoted about the fly-portion 27 (with the seam 37 serving as a hinge), and the outer surface of the waistband portion 41 is placed adjacent the outer surfaces of portions 20 and 27, with the inverted lower edge 42 of the waistband 41 adjacent the upper edge 36 of the fly and the leg portions. In this position the edge 40 of the fly-portion is in abutting end-to-end relationship with the edge 39 of the leg portion (as shown at 34) in Figure 6. Thereafter, the waistband portion 41 is secured to the fly-portion 27 and leg portion 20 by a horizontal seam 43 which is parallel to the edges 42 and 38 and somewhat below these edges. Thus the seam 43 passes at or above the point on edge 36 at which seam 37 terminates.

Referring now to Figures 4—*a*, 6—*a*, and 7—*a*, there is illustrated the assembly of trousers according to prior practice. Figure 4—*a* is a view similar to Figure 4, but it represents the prior-art construction, wherein stitching 37—*b* is continued to the top edge 38 of the assembled portions 27 and 20. In such construction no gap, as at 39 and 40, is possible, and the edges 39—*a* and 40—*a* could not be made to lie in an abutting relation, as is possible with my construction, shown in Figure 6.

Figure 6—*a* represents the prior-art construction corresponding to my assembly shown in Figure 6. As is evident, the end portions, 39—*a* and 40—*a*, cannot abut, and must be folded against the panel 20, causing a 4-ply thickness at that point. Thereafter stitching 43—*a* must pass through all 4-plies (plus the liner 31). This multi-ply construction obviously creates a bulky garment. Such undesirable features are eliminated from the garment using my construction.

The cross-sectional views of Figs. 7 and 7—*a* further illustrate how my garment is an improvement over prior-art.

After seam **43** has secured the members **27, 20** and **41** together, the waistband portion **41** is pivoted about the seam **43** (as shown particularly in Figure 8) and the ends **41**—*a*, **27**—*a* and **20**—*a* are folded back against their respective portions. The ends **41**—*a*, **27**—*a* and **20**—*a* are then pressed flat to minimize any bulkiness created by these folds.

The next step consists in pivoting the fly-portion **27**, and the end-portion **41**—*b* of the waistband portion **41** about the edge **36** (and a continuation **41**—*c* thereof in the waistband portion). The folding operation, shown as partly performed in Figure 9, is shown in the completed step in Figure 10.

Referring now to Figure 10, a seam **44** (which is parallel to the edge **36** and the fold-line **41**—*c*) secures the fly-portion and leg portion at or below the point at which seam **37** begins to taper towards edge **36** and extends upward toward the waistband **41**. This seam **44** is, therefore, an extension of the straight part of seam **37**, upward across the seam **43** into the folded-over section of the waistband consisting of portions **41** and **41**—*b*.

In the waistband portion the seam **44** is caused to follow a radius, as at **45**, so that it can thereafter continue parallel to the upper edge **46** of the waistband portion **41**. In this manner the fly-portion **27**, and the end-portion **41**—*b* of the waistband **41**, are firmly secured in a contacting relationship to the leg-panel **20** and the waistband **41**.

After the seam **44** has been applied to the assembled members, the excess material between the edge **36** and seam **37**, and between edge **41**—*c* and seam **44**, is removed so that only a small protruding edge **44**—*a* and **36**—*a* extends beyond the seams **37** and **44**. The assembled panels, with the trimmed edges, are shown in Figure 11.

After the excess material has been removed, a waistband liner **47** may be attached to the upper edge of the waistband member as shown in Figure 13. Thereafter, the liner **47** is folded against the inside of the waistband panel **41**, and the members **27** and **41**—*b* are folded over along the seams **37** and **44** so as to expose the outer surface of the fly-portion **32** and the slide-fastener **22**. This operation is shown as completed in Figure 14. A seam **50** may be employed to hold the members in this final position.

Thus, I have provided a trousers opening which includes a minimum number of material-plies in the region of the upper end of the fly-portion, particularly at the point where the slide-fastener tape **22**—*a* passes inside the waistband portion and where the waistband and leg members are secured to the fly-portion.

Moreover, because seam **44** is a straight-line continuation of seam **37**, the final fold is made easily without any twists or bulges in the material, and the edge **51** is straight and neat-appearing. In addition, the presence of seam **44** and the radius **45**, and the use of the trimming operation aforementioned, provide an upper corner **48** of the trousers with a rounded edge which is highly desirable since edge **46** is not always accurately in-line with the opposite edge **49**, when the fly-portion of the trousers is closed by the slide-fastener **22** and the buttons **23** and **24**. This rounded edge tends to decrease the obviously undesirable appearance of any mis-alignment of the edges **46** and **49** and enhances the appearance of the trousers when in the closed position.

Thus, I have provided a trousers construction which eliminates any bulky or unsightly material at the upper edge of the fly-portions and waistband portions without materially increasing the cost of the garment.

The present invention may be embodied in other specific forms without departing from the spirit or essential attributes thereof, and it is therefore desired that the present embodiments be considered in all respects as illustrative and not restrictive, reference being had to the appended claims rather than to the foregoing description to indicate the scope of the invention.

Having thus described my invention, I claim as new and desire to protect by Letters Patent:

1. A method of forming the fly-portion of a pair of trousers which comprises cutting a leg-panel and a fly-panel having correspondingly curved free edges, assembling said panels with a generally vertical row of stitching spaced inwardly from said free edges and terminating below the upper ends of said panels, unfolding the stitched-together panels and adjusting the upper ends thereof so that the said free edges of the leg-panel and fly-panel abut above the upper end of said generally vertical seam, attaching a waistband panel to the aforesaid unfolded stitched panels by a generally horizontal row of stitching disposed not below the level of the uppermost end of the first-mentioned vertical row of stitching, turning the waistband-panel so that it extends upwardly from said horizontal row of stitching, folding the turned-up waistband-panel along a vertical line extending upward generally in continuation of the free edges of the stitched-together fly-panel and leg-panel, forming another row of stitching extending vertically along the fly-panel and leg-panel generally in continuation of the first-mentioned row of stitching and extending upwardly therebeyond and through both plies of the folded waistband-panel, said last-mentioned row of stitching being curved adjacent the upper edge of the folded waistband-panel and terminating in a generally horizontal end-portion spaced somewhat below the uppermost free edge of said waistband-panel, trimming off the edges of the plies of material extending beyond the outer side of said last-mentioned row of stitching, and turning the stitched-together leg-panel, fly-panel and waistband-panel along said last-mentioned stitch-row thereby providing a generally continuous seam defined by the first-mentioned and last-mentioned rows of stitching having a rounded uppermost edge for the free end of the waistband and having a minimum of bulkiness at the juncture zone of the leg-panel, fly-panel and waistband-panel.

2. A method of forming the fly-portion of a pair of trousers which comprises cutting a leg-panel and a fly-panel having correspondingly curved free edges, securing said panels with a generally vertical row of stitching spaced inwardly from said free edges and gradually tapering toward and terminating at said free edges below the upper ends of said panels, unfolding the stitched panels so that the upper portion of the said free edges of the leg-panel and fly-panel abut above the upper end of said generally vertical seam, attaching a waistband panel to the aforesaid unfolded stitched panels by a generally horizontal row of stitching disposed not below the uppermost end of the first-mentioned ver-

tical row of stitching, turning the waistband-panel so that it extends upwardly from said horizontal row of stitching, folding the turned up waistband-panel along a vertical line extending upward generally in continuation of the free edges of the stitched-together fly-panel and leg-panel, forming another row of stitching extending vertically along the fly-panel and leg-panel generally in continuation of the generally vertical non-tapering portion of the first-mentioned row of stitching and extending upwardly therebeyond and through said second-mentioned row of stitching and through both plies of the folded waistband-panel, said last-mentioned row of stitching being curved adjacent the upper edge of the folded waistband-panel and terminating in a generally horizontal end-portion spaced somewhat below the uppermost free edge of said waistband-panel, trimming off the edges of the plies of material extending beyond the outer side of said last-mentioned row of stitching, and turning the stitched-together leg-panel, fly-panel and waistband-panel along said last-mentioned stitch-row thereby providing a generally continuous seam defined by the first-mentioned and last-mentioned rows of stitching having a rounded uppermost edge for the free end of the waistband and having a minimum of bulkiness at the juncture zone of the leg-panel, fly-panel and waistband-panel.

3. A method of forming the fly-portion of a pair of trousers which comprises assembling a leg-panel and fly-panel, wherein a vertical and a horizontal edge of each panel are in alignment, with a generally vertical row of stitching spaced inwardly from said vertical edges and terminating below the upper ends of said panels, unfolding the stitched-together panels and adjusting the upper ends thereof so that the said free edges of the leg-panel and fly-panel abut above the upper end of said generally vertical seam, attaching a waistband panel, having an inverted lower edge in alignment with said horizontal edges, to the aforesaid unfolded stitched panels by a generally horizontal row of stitching disposed not below the level of the uppermost end of the first-mentioned vertical row of stitching, turning the waistband-panel so that it extends upwardly from said horizontal row of stitching, folding the turned-up waistband-panel along a vertical line extending upward generally in continuation of the vertical edges of the stitched-together fly-panel and leg-panel, forming another row of stitching extending vertically along the fly-panel and leg-panel generally in continuation of the first-mentioned row of stitching and extending upwardly therebeyond and through both plies of the folded waistband-panel, said last-mentioned row of stitching being curved adjacent the upper edge of the folded waistband-panel and terminating in a generally horizontal end-portion spaced somewhat below the uppermost free edge of said waistband-panel, trimming off the edges of the plies of material extending beyond the outer side of said last-mentioned row of stitching, and turning the stitched-together leg-panel, fly-panel and waistband-panel along said last-mentioned stitch-row so as to expose the outer surfaces thereby providing a generally continuous seam defined by the first-mentioned and last-mentioned rows of stitching having a rounded uppermost edge for the free end of the waistband and having a minimum of bulkiness at the juncture zone of the leg-panel, fly-panel and waistband-panel.

4. A method of forming the fly-portion of a pair of trousers which comprises cutting a leg-panel and a fly-panel having correspondingly curved free edges, securing said panels, with their external surfaces in contact by a generally vertical row of stitching spaced inwardly from said free edges and terminating below the upper ends of said panels, unfolding the stitched-together panels and adjusting the upper ends thereof so that the said free edges of the leg-panel and fly-panel abut above the upper end of said generally vertical seam, attaching a waistband panel to the aforesaid unfolded stitched panels with the external surfaces in contact by a generally horizontal row of stitching disposed not below the level of the uppermost end of the first-mentioned vertical row of stitching, turning the waistband-panel so that it extends upwardly from said horizontal row of stitching, folding the turned-up waistband-panel along a vertical line extending upward generally in continuation of the free edges of the stitched-together fly-panel and leg-panel so as to bring into contact the external surfaces of said fly-panel and leg-panel, forming another row of stitching extending vertically along the fly-panel and leg-panel generally in continuation of the first-mentioned row of stitching and extending upwardly therebeyond and through both plies of the folded waistband-panel, said last-mentioned row of stitching being curved adjacent the upper edge of the folded waistband-panel and terminating in a generally horizontal end-portion spaced somewhat below the uppermost free edge of said waistband-panel, trimming off the edges of the plies of material extending beyond the outer side of said last-mentioned row of stitching, and turning the stitched-together leg-panel, fly-panel and waistband-panel along said last-mentioned stitch-row so as to expose the external surfaces thereof, thereby providing a generally continuous seam defined by the first-mentioned and last-mentioned rows of stitching having a rounded uppermost edge for the free end of the waistband and having a minimum of bulkiness at the juncture zone of the leg-panel, fly-panel and waistband-panel.

5. A method of forming the fly-portion of a pair of trousers which comprises securing a leg-panel and fly-panel having a vertical and a horizontal edge of each in alignment by a generally vertical row of stitching spaced inwardly from said vertical edges and gradually tapering toward and terminating at said free edges below the upper ends of said panels, unfolding the stitched panels so that the upper portion of the said free edges of the leg-panel and fly-panel abut above the upper end of said generally vertical seam, attaching a waistband panel, having an inverted lower edge in alignment with said horizontal edges, to the aforesaid unfolded stitched panels by a generally horizontal row of stitching disposed not below the uppermost end of the first-mentioned vertical row of stitching, turning the waistband-panel so that it extends upwardly from said horizontal row of stitching, folding the turned-up waistband-panel along a vertical line extending upward generally in continuation of the vertical edges of the stitched-together fly-panel and leg-panel, forming another row of stitching extending vertically along the fly-panel and leg-panel generally in continuation of the generally vertical non-tapering portion of the first-mentioned row of stitching and extending upwardly therebeyond and through said second-

mentioned row of stitching and through both plies of the folded waistband-panel, said last-mentioned row of stitching being curved adjacent the upper edge of the folded waistband-panel and terminating in a generally horizontal end-portion spaced somewhat below the uppermost free edge of said waistband-panel, trimming off the edges of the plies of materia lextending beyond the outer side of said last-mentioned row of stitching, and turning the stitched-together leg-panel, fly-panel and waistband-panel along said last-mentioned stitch-row so as to expose the outer surfaces, thereby providing a generally continuous seam defined by the first-mentioned and last-mentioned rows of stitching having a rounded uppermost edge for the free end of the waistband and having a minimum of bulkiness at the juncture zone of the leg-panel, fly-panel and waistband-panel.

6. A method of forming the fly-portion of a pair trousers which comprises cutting a leg-panel and a fly-panel having correspondingly curved free edges, securing said panels, having the external surfaces in contact, with a generally vertical row of stitching spaced inwardly from said free edges and gradually tapering toward and terminating at said free edges below the upper ends of said panels, unfolding the stitched panels so that the upper portion of the said free edges of the leg-panel and fly-panel abut above the upper end of said generally vertical seam, attaching a waistband-panel to the aforesaid unfolded stitched panels, with the external surfaces in contact, by a generally horizontal row of stitching disposed not below the uppermost end of the first-mentioned vertical row of stitching, turning the waistband-panel so that it extends upwardly from said horizontal row of stitching, folding the turned-up waistband-panel along a vertical line extending upward generally in continuation of the free edges of the stitched-together fly-panel and leg-panel so as to bring into contact the external surfaces of said fly-panel and leg-panel, forming another row of stitching extending vertically along the fly-panel and leg-panel generally in continuation of the generally vertical non-tapering portion of the first-mentioned row of stitching and extending upwardly therebeyond and through said second-mentioned row of stitching and through both plies of the folded waistband-panel, said last-mentioned row of stitching being curved adjacent the upper edge of the folded waistband-panel and terminating in a generally horizontal end-portion spaced somewhat below the uppermost free edge of said waistband-panel, trimming off the edges of the plies of material extending beyond the outer side of said last-mentioned row of stitching, and turning the stitched-together leg-panel, fly-panel and waistband-panel along said last-mentioned stitch-row so as to expose the external surfaces thereof, thereby providing a generally continuous seam defined by the first-mentioned and last-mentioned rows of stitching having a rounded uppermost edge for the free end of the waistband and having a minimum of bulkiness at the juncture zone of the leg-panel, fly-panel and waistband-panel.

7. A method of forming the fly-portion of a pair of trousers which comprises assembling a leg-panel and fly-panel, having a vertical and a horizontal edge of each in alignment and having the external surfaces in contact with a generally vertical row of stitching spaced inwardly from said vertical edges and terminating below the upper ends of said panels, unfolding the stitched-together panels and adjusting the upper ends thereof so that the said free edges of the leg-panel and fly-panel abut above the upper end of said generally vertical seam, attaching a waistband panel, having an inverted lower edge in alignment with said horizontal edges to the aforesaid unfolded stitched panels with the external surfaces in contact by a generally horizontal row of stitching disposed not below the level of the uppermost end of the first-mentioned vertical row of stitching, turning the waistband-panel so that it extends upwardly from said horizontal row of stitching, folding the turned-up waistband-panel along a vertical line extending upward generally in continuation of the vertical edges of the stitched-together fly-panel and leg-panel so as to bring into contact the external surfaces of said fly-panel and leg-panel, forming another row of stitching extending vertically along the fly-panel and leg-panel generally in continuation of the first-mentioned row of stitching and extending upwardly therebeyond and through both plies of the folded waistband-panel, said last-mentioned row of stitching being curved adjacent the upper edge of the folded waistband-panel and terminating in a generally horizontal end-portion spaced somewhat below the uppermost free edge of said waistband-panel, trimming off the edges of the plies of material extending beyond the outer side of said last-mentioned row of stitching, and turning the stitched-together leg-panel, fly-panel and waistband-panel along said last-mentioned stitch-row so as to expose the external surfaces thereof, thereby providing a generally continuous seam defined by the first-mentioned and last-mentioned rows of stitching having a rounded uppermost edge for the free end of the waistband and having a minimum of bulkiness at the juncture zone of the leg-panel, fly-panel and waistband-panel.

8. A method of forming the fly-portion of a pair of trousers which comprises securing a leg-panel and fly-panel, having a vertical and a horizontal edge of each in alignment and having the external surfaces in contact, with a generally vertical row of stitching spaced inwardly from said vertical edges and gradually tapering toward and terminating at said free edges below the upper ends of said panels, unfolding the stitched panels so that the upper portion of the said free edges of the leg-panel and fly-panel abut above the upper end of said generally vertical seam, attaching a waistband panel, having an inverted lower edge in alignment with said horizontal edges to the aforesaid unfolded stitched panels, with the external surfaces in contact, by a generally horizontal row of stitching disposed not below the uppermost end of the first-mentioned vertical row of stitching, turning the waistband panel so that it extends upwardly from said horizontal row of stitching, folding the turned-up waistband-panel along a vertical line extending upward generally in continuation of the vertical edges of the stitched-together fly-panel and leg-panel so as to bring into contact the external surfaces of said fly-panel and leg-panel, forming another row of stitching extending vertically along the fly-panel and leg-panel generally in continuation of the generally vertical non-tapering portion of the first-mentioned row of stitching and extending upwardly therebeyond and through said second-mentioned row of stitching and through both plies of the folded waistband-panel, said last-mentioned row of

stitching being curved adjacent the upper edge of the folded waistband-panel and terminating in a generally horizontal end-portion spaced somewhat below the uppermost free edge of said waistband-panel, trimming off the edges of the plies of material extending beyond the outer side of said last-mentioned row of stitching, and turning the stitched-together leg-panel, fly-panel and waistband-panel along said last-mentioned stitch-row so as to expose the external surfaces thereof, thereby providing a generally continuous seam defined by the first-mentioned and last-mentioned rows of stitching having a rounded uppermost edge for the free end of the waistband and having a minimum of bulkiness at the juncture zone of the leg-panel, fly-panel and waistband-panel.

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