

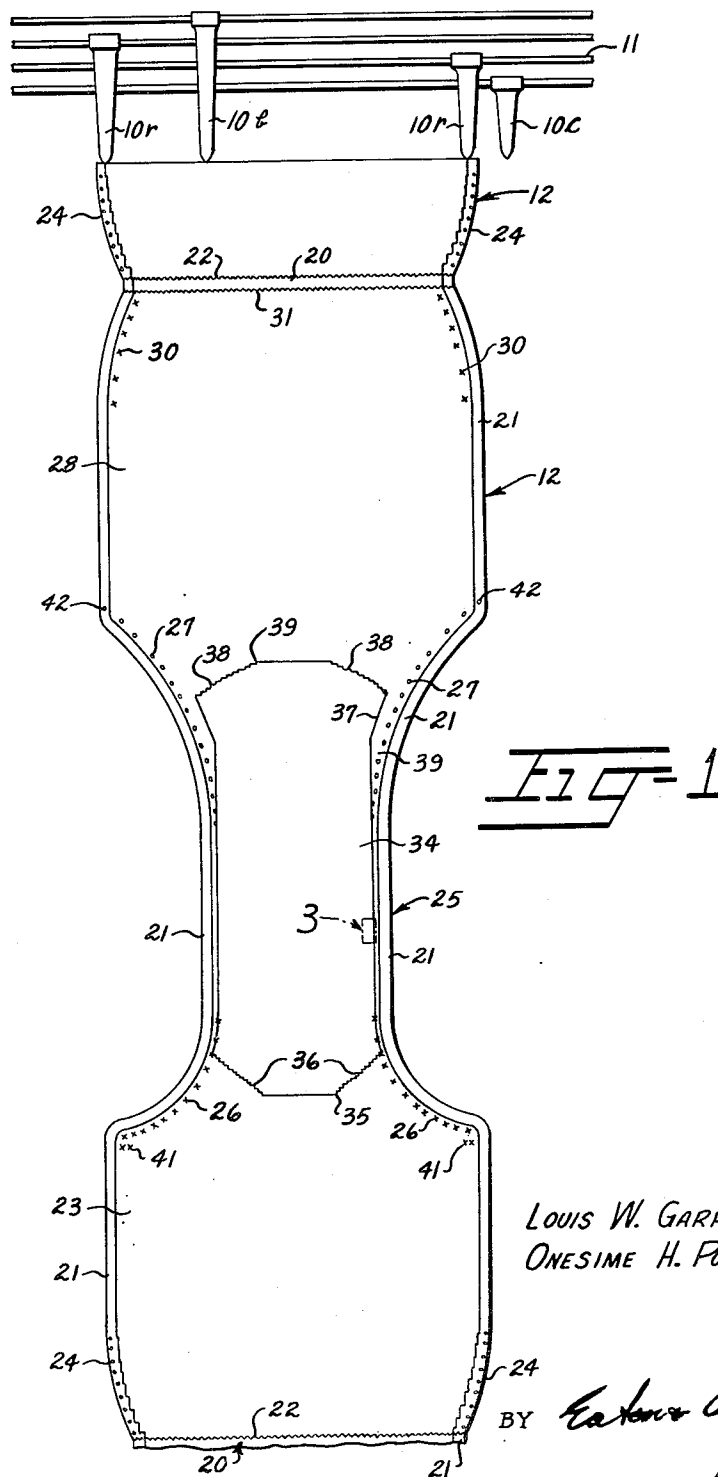
April 19, 1955

L. W. GARROU ET AL
FULL-FASHIONED PANTY AND METHOD

2,706,389

Filed Nov. 5, 1953

5 Sheets-Sheet 1



LOUIS W. GARROU &
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INVENTORS.

BY *Edward Bell*

ATTORNEYS.

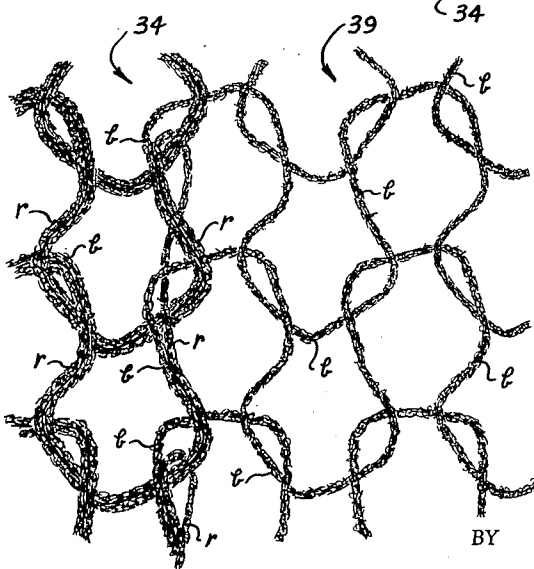
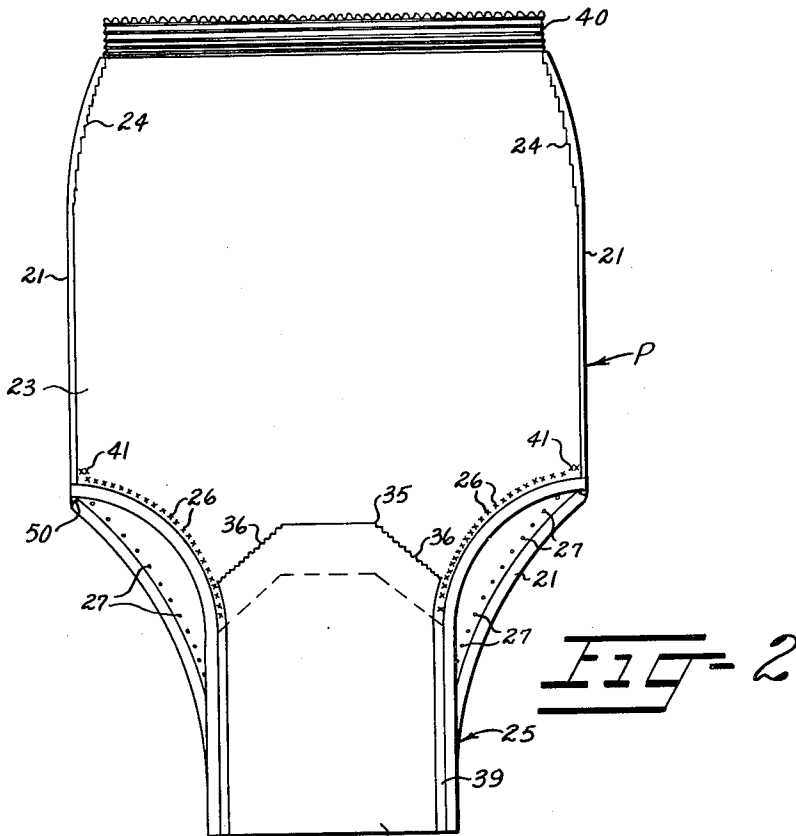
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5 Sheets-Sheet 2



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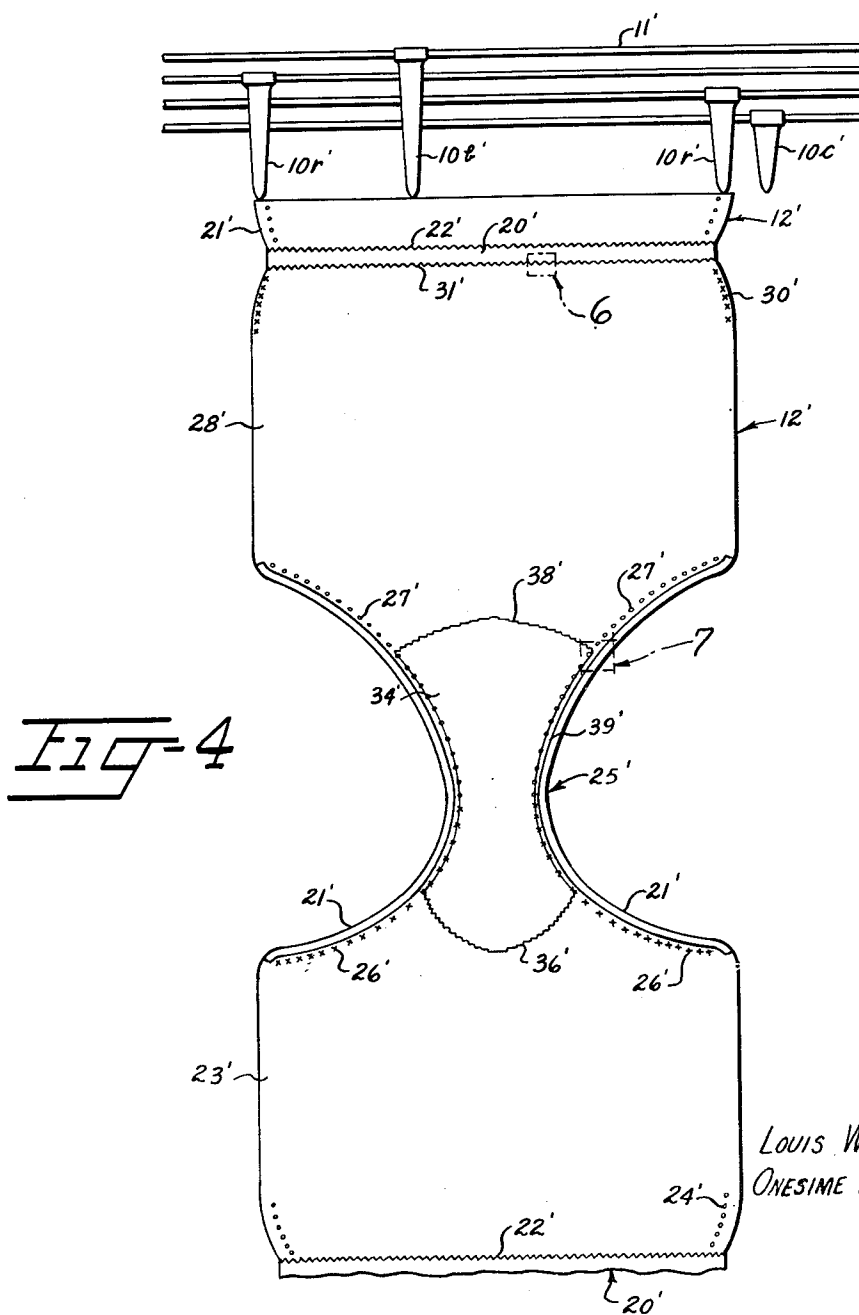
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5 Sheets-Sheet 3



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5 Sheets-Sheet 4

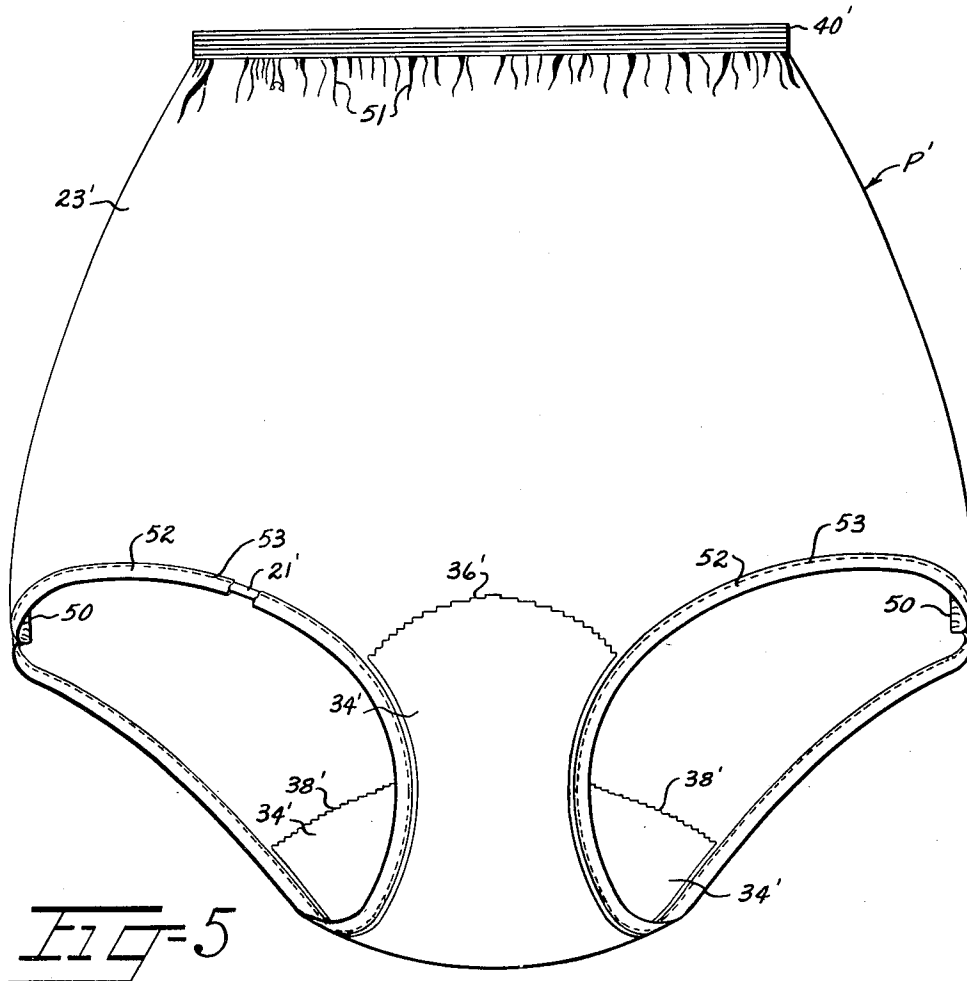


FIG-5

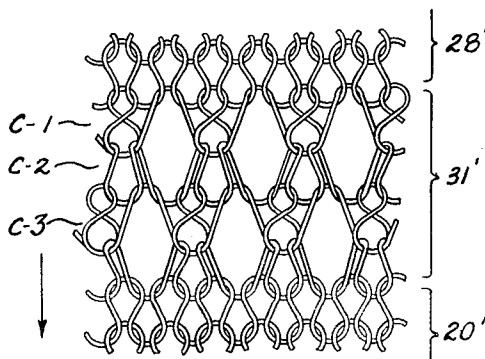


FIG-6

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2,706,389

FULL-FASHIONED PANTY AND METHOD

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Application November 5, 1953, Serial No. 390,389

20 Claims. (Cl. 66—177)

This invention relates to a method of producing full-fashioned knitted articles on full-fashioned or flat bed knitting machines and more especially to a method of producing a full-fashioned panty.

Heretofore, panties or similar undergarments have been manufactured by cutting one or more pieces of material and then joining these pieces of material to form front, rear and crotch portions. In joining the pieces of material together it has been necessary to utilize several manufacturing steps such as sewing and hemming and the like and then the leg openings of the panty have had to be hemmed. In some cases, it has been desirable or necessary to sew additional material to the garment such as in the seat or crotch portion if a reinforced crotch or seat portion is desired. All of this requires numerous steps in the manufacturing process and furthermore leaves hems and joints in the panty which are unsightly and are undesirable from the comfort standpoint. Furthermore, in a panty of this type it is impossible to completely fashion the curvature of the panty so as to make it fit the body of a wearer perfectly since the upper part of the panty must be of sufficient width to accommodate the largest portion of the wearer and this is generally accomplished by making the upper portion or waist portion of the panty relatively wide and using an elastic waistband to gather the same which leaves puckers and gathers around the waist which are not desirable.

Various attempts have heretofore been made to utilize knitted fabric for panties and generally they have resulted in cutting the knitted fabric and forming a panty from the cut pieces in the manner described above. Some attempts have been made to form a panty or similar garment on a circular knitting machine, but such attempts have not given satisfactory results.

It is therefore the primary object of this invention to provide a full-fashioned panty which is knit on a flat bed knitting machine in a plurality of continuous courses and wherein the shape of the panty is fashioned as may be desired in a manner similar to the manner in which full-fashioned stockings are fashioned.

It is another object of this invention to provide a full-fashioned panty or similar garment which is manufactured on a flat bed or full-fashioned knitting machine wherein one or more continuous strands of yarn are utilized to form a continuous plurality of courses forming first a body portion and then a crotch and then a second body portion and wherein the curvature of said portions of the garment may be varied or modified as desired by widening and narrowing and wherein the garment may be completed by connecting the selvages of the two body portions and no additional hemming or stitching or piecing is required and wherein the garment will be substantially free from unsightly and uncomfortable seams.

It is another object of this invention to provide a full-fashioned knitted panty or the like of the type described where additional reinforcing yarn may be introduced at any desired point in the panty, for example, in the crotch portion of the panty to form a reinforced crotch portion integral with the body yarn of the fabric and wherein no seams or the like are necessary.

It is another object of this invention to provide a full-fashioned panty of the type described formed from super-twisted synthetic yarns causing the finished panty to have elasticity or pull in all directions and further insuring a proper fit.

An additional advantage of this invention is the fact that a full-fashioned panty of this type utilizing super-

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twisted synthetic yarns may be made on conventional full-fashioned knitting machines used in making full-fashioned hosiery and thus provide a new product which can be made with existing machinery.

It is another object of this invention to provide a method of knitting a garment such as a panty wherein the garment is completely fashioned (1) by knitting a plurality of courses to form a first body portion of the garment and widening or narrowing said courses as may be desired to give the body portion a desired configuration; (2) forming a crotch portion of the garment by knitting a plurality of additional courses while progressively narrowing the same and then knitting a plurality of courses of a width substantially less than the width of the body portion and then knitting an additional plurality of courses while progressively widening the same; (3) forming a second body portion in a manner similar to that in which the first body portion is formed; and (4) then connecting the selvages of the two body portions together to form the full-fashioned panty. In this manner, the selvages of the fabric at the crotch portion formed by narrowing and widening will define leg openings for the panty.

It is another object of this invention to provide a method of knitting a full-fashioned panty of the type described wherein additional yarn is fed to the knitting instrumentalities to reinforce the area adjacent the leg openings and also, if desired, to provide a reinforced crotch area integral with the panty fabric.

Some of the objects of the invention having been stated, other objects will appear as the description proceeds, when taken in connection with the accompanying drawings, in which—

Figure 1 is a somewhat schematic plan view of a panty blank formed according to this invention and showing the yarn carriers of a full fashioned knitting machine;

Figure 2 is an elevation of a completed panty made in accordance with one form of this invention;

Figure 3 is an enlarged view of the area 3 in Figure 1 illustrating the manner in which additional yarn is used in reinforcing the crotch portion of the panty;

Figure 4 is a view similar to Figure 1, but on a smaller scale showing another form of panty made in accordance with this method;

Figure 5 is an elevation of the completed panty shown in Figure 4;

Figure 6 is an enlarged somewhat schematic view of the general area 6 in Figure 4 illustrating one type of lock stitch which may be used at the waistband of the panty;

Figure 7 is an enlarged view of the area 7 in Figure 4 illustrating the manner in which the garment is widened in forming a portion of the crotch area.

Referring more specifically to Figures 1, 2 and 3, there will be observed a full fashioned panty formed from super-twisted synthetic yarns. The term super-twisted yarns, as used herein, shall include various types of synthetic yarns processed in such a manner as to make the same stretchable or yieldable. Such synthetic yarns are of a thermoplastic nature and include yarns of cellulose acetate, polyamidic yarns such as nylon, polyester yarns, such as "Dacron," acrylonitrile yarns, such as "Orlon," and any other synthetic thermoplastic yarns having the desired characteristics.

These yarns are treated according to any well-known commercial processes to give the same a wool-like effect by increasing the elasticity or curliness of the yarn generally by imparting a supertwist thereto or, in some instances, by crimping the yarns in any desired manner. Such processes are disclosed in Patents Nos. 2,019,183, 2,019,185 and 2,564,245 and are generally known in the trade as the supertwisting process. According to this process, artificial yarns are provided with increased elasticity and curliness by imparting a super number of twists to the yarn, setting the twist and thereafter untwisting the yarn. One or more strands of such yarn may be utilized as desired, generally two oppositely supertwisted yarns are twisted together and the finished yarn will have a generally fuzzy appearance, such as shown more or less schematically in Figure 3 and will have a tendency to crinkle or curl so that the loops of a fabric knitted

from such yarn will be irregular in shape and the fabric will have elasticity in both directions.

By the use of such a yarn in a full-fashioned or flat bed knitting machine of a standard size as is ordinarily used in manufacturing full-fashioned stockings, a panty which would normally require a width substantially greater than the needle bed of such a machine may be formed and with this type of yarn the panty will have enough stretchability or elasticity to properly fit people of various sizes.

Furthermore, the combination in a panty or similar garment of supertwisted yarn with full-fashioning results in a garment having the finest possible fit.

Referring now to Figure 1, there will be observed a plurality of yarn carriers 10r, 10b and 10c mounted on carrier rods 11 of a conventional or other type of full-fashioned or flat bed knitting machine. The yarn carriers are reciprocated, one or more at a time as desired, to feed one or more yarns to a plurality of knitting needles, not shown, to cause the yarn or yarns to be knitted into a plurality of courses in a manner well known in the full-fashioned hosiery art. By actuating the yarn feed carriers in a desired manner and by using one or more of the yarn feed carriers the width of the garment knitted may be varied from time to time and, if desired, additional or reinforcing yarn may be introduced into various areas of the garment as desired.

The configuration of a panty formed according to this invention may vary and one form of panty is illustrated in Figures 1, 2 and 3 wherein the full-fashioned panty blank is broadly designated at 12 and it will be observed that a plurality of such blanks are knitted in a continuous series by the full-fashioned knitting machine and these blanks may subsequently be separated adjacent the waistband area thereof and each formed into a complete panty in the manner to be described.

Referring to the lower portion of Figure 1, it will be seen that in commencing the knitting of a series of blanks 12, a plurality of initial courses indicated at 20 are preferably formed and in the present illustration it will be observed that the yarn carrier 10b is utilized for feeding a body yarn to the knitting instrumentalities throughout a major portion of the width of the full-fashioned knitting machine section and additional yarn carriers 10r are utilized for introducing an additional or reinforcing yarn to a relatively small number of needles adjacent the selvages of the panty blank to form a reinforced area at each selvege indicated at 21.

After a relatively small plurality of courses 20 have been knitted in this fashion, one or more additional courses of a lock stitch construction are knitted as at 22, the lock stitches 22 serving to define the waistband edges of the panty. The knitting instrumentalities are then actuated to form a first body portion of the panty which in this instance is the front portion and is indicated at 23. Since it is usually desirable to have the panty somewhat narrower at the upper or waist portion thereof than at the center of the body portion, the initial courses in the body portion are preferably of a width somewhat less than the full width of the panty blank.

If desired, a plurality of courses may be knitted of equal width and then the courses may be widened in forming the body portion. In the present illustration, a plurality of course are knitted utilizing the yarn feed carriers 10b and 10r and these courses are progressively widened as desired, say two wales at a time every eight courses for a desired number of courses, thus forming widening marks 24 adjacent the selvages of the upper or waist area of the body portion 23. It should be understood that any desired amount of widening may be utilized in order to fashion the panty blank as may be desired.

The knitting instrumentalities are then actuated in a conventional manner to knit the center area of the body portion by straight knitting, that is, knitting courses of equal width, for any desired number of courses. This center area of the body portion is preferably of substantially the same width throughout, but it may be widened or narrowed as desired in the manufacture of a particular garment.

After a plurality of such body portion courses have been knitted, the knitting instrumentalities are actuated to narrow the fabric for a desired number of courses to commence the formation of a crotch portion broadly designated at 25. For example, the fabric may be narrowed two wales every course on each side thereof for a plurality of

courses and then narrowed two wales every two courses for an additional plurality of courses adjacent the selvages in each instance. This narrowing operation defines the upper front portion of a crotch area and the selvages of the crotch area 25 define the edges of leg openings in the completed garment and it is therefore desirable to continue the reinforcement 21 at the selvages in this area.

After the narrowing operation is completed, the center portion of the crotch area is formed by straight knitting for a desired plurality of courses. The fabric is then widened to form the other side or upper rear portion of the crotch area 25, as by widening two wales at a time every two courses for a plurality of courses and then widening two wales at a time every ten courses for an additional plurality of courses. This widening forms marks 27 in the fabric and by widening in this manner the blank 12 has a somewhat elongated curvature at the other end of the crotch portion 25 which is slightly different from that formed at the beginning of the crotch portion. Such an elongated curvature is desired in forming the rear portion of the garment as the selvages of the blank at this area also define the rear portions of the leg openings and this area of the fabric also serves as part of the seat of the garment.

A rear body portion or seat 28 of the garment blank is then formed by straight knitting for a plurality of courses, any desired number of courses being utilized, preferably substantially the same or slightly more than the number of courses of straight knitting utilized in forming the main body portion 23 of the front of the garment blank.

The blank 12 is then narrowed as at 30 to form the upper rear waist portion, said narrowings 30 conforming substantially to the widenings 24 in the upper front waist portion. One or more courses of lock stitches 31 similar to the lock stitches 22 are preferably formed to define the upper rear edge or waistband edge of the rear body portion of the garment blank. After the lock stitches 31 a plurality of additional courses 20 may be knitted to provide a severance area and then an additional panty blank 12 may be knitted in a similar manner.

It will be observed that the reinforcing yarn carried by the yarn carriers 10r forms a relatively narrow reinforcing band 21 throughout the entire selvages of the blank. This reinforced band 21 is highly desirable in the leg opening area as it serves to additionally define and reinforce the leg openings and to cause the same to snugly fit the legs of the wearer. If desired, this reinforced yarn may be omitted from the selvages of the body portion of the garment. In some instances, it may be desirable to omit the reinforced area 21 adjacent the leg openings in which instance it will probably be necessary to sew elastic or similar material around the leg openings of the completed garment. Lace or other decorative or ornamental material may be attached to the garment around the leg openings if desired.

Usually, it is desirable to reinforce the crotch portion of the garment as at 34 and according to the present method this reinforcement may be accomplished by utilizing one of the yarn carriers 10, in this instance the yarn carrier designated 10c, to feed an additional reinforcing yarn to the knitting instrumentalities to cause this additional yarn to be interknit with the body yarn throughout the desired reinforced area.

In the present illustration, the additional reinforcing yarn carried by the yarn carrier 10c is introduced to the needles at the point 35 and to a progressively greater number of needles to widen the reinforcement as at 36. The crotch area 25 is then reinforced throughout the central portion thereof and the reinforcing yarn may then be widened as at 37 in substantial conformity to the widening 27 of the crotch portion. The crotch reinforcement then is narrowed as at 38 and terminates as at 39 thus forming a somewhat wider reinforcement at the lower part of the seat area.

It will be observed that the reinforced area 34 is spaced from the reinforced selvege 21 leaving an area of fabric 39 which is not reinforced. Since the non-reinforced area will have greater elasticity than the reinforced area, the omission of reinforcement at the area 39 between the reinforced areas 21 and 34 provides for a better and more snug fit of the completed garment. The particular configuration of the reinforced crotch area may be varied as desired and as a general rule more reinforcement is desired adjacent the rear portion or seat portion of the garment than at the front portion of the gar-

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ment. Figure 3 clearly illustrates the arrangement of the reinforced yarn in the crotch area and wherein the reinforced yarn is indicated at *r* and the body yarn at *b*.

The waistband or upper edges of the garment are defined by the lock stitches 22 and 31 and these lock stitches are provided in order to permit the successive blanks to be separated from each other without causing raveling or runs in the completed garment. Any desired type of lock stitch or picot stitch may be utilized and in general practice it has been found desirable to knit a small area of courses 20 between the lock stitches 22 and 31 and then the fabric may be severed in the area 20 and the waistband may be formed in any desired manner.

The top edge of the panty may be folded upon itself and sewn together to form a welt or hem across the upper edge thereof which will serve as a waistband and due to the elasticity of the yarn, it will ordinarily be sufficient. In some instances, however, it may be desirable to knit in an additional yarn, not shown, adjacent the upper edges of the garment to form a welt which will serve as a waistband. In such an instance it may be desirable to utilize a hem stitch at the upper edge of the garment or the band of additional yarn may be used without such a hem stitch.

In some instances, in order to provide even greater elasticity at the waistband area, rubber or elastic yarn may be introduced to the knitting instrumentalities for a plurality of courses adjacent the upper edges of the garment to form an elastic or stretchable waistband. In other instances, it may be desired to attach to the upper edge of the garment a lace and/or elastic strip such as indicated at 40 in Figure 2 to form the waistband of the garment. The invention is not limited to any particular type of waistband, as it is contemplated that any desired arrangement may be utilized within the scope of this invention.

As previously stated, any desired variation may be made in the configuration of the panty blank by varying the widening and narrowings. As a specific example for illustration only but not as a limitation, the blank may be formed with supertwisted yarn wherein the initial courses may be 352 wales in width, and in forming the first waist portion, 52 courses of equal width may be knitted, then the courses are widened on each side two wales at a time every 8 courses for a total of 24 widening operations on each side, covering a total of 192 courses.

The center body portion is then formed by knitting 228 courses of equal width, and then the first part of the crotch area is formed by narrowing two wales every course on each side of the blank for 34 courses and then narrowing two wales every two courses for 34 courses, the first of said narrowings forming marks such as the marks 41. The center portion of the crotch area is then formed by knitting 200 courses of the same width.

The rear or second part of the crotch area which also forms a part of the seat of the panty is then knitted by widening 61 times, 2 wales at a time every 2 courses, for 122 courses, and then widening 2 wales at a time every 6 courses for six times for a total of 36 courses.

The rear body portion is then formed by knitting 94 courses of equal width, then widening 4 courses to make marks like the marks 42 and then knitting 134 courses of equal width. The rear waist portion is then formed by narrowing 2 wales every 8 courses 24 times for a total of 192 courses, then knitting 52 courses of equal width to form the waistband edge of the panty. Panties fashioned in this manner have been found highly satisfactory for the average figure.

After the blanks 12 have been knitted as described, they are separated along the area 20 and the selvages of the body portions 23 and 28 are joined together as by seaming or the like and any desired waistband 40 may then be added thereto to form a completed garment P as illustrated in Figure 2.

The size of the leg openings of the garment may be varied by varying the point at which the lower edges of the body portion selvages are joined together. It is frequently desirable in the knitting operation to make narrowing marks 41 adjacent the point at which the crotch narrowings begin and to make widening marks 42 adjacent the point where the crotch widenings terminate. The position of the narrowing and widening marks 41 and 42 may vary and these marks may serve as indications to the seaming operator of the particular point

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wherein the seaming of the body portion selvages should begin.

While the garment is shown as being knitted from front to rear it is to be understood that it can be knitted from rear to front and widened and narrowed accordingly. It is frequently desirable to have more fabric in the seat or rear of the garment and this may be accomplished by knitting the rear first and then narrowing and widening to form the crotch and then knitting the front portion.

Modified form

While it is highly desirable to utilize stretchable or supertwisted yarn in forming the full-fashioned garment in accordance with this method, it is also contemplated that a garment may be formed using ordinary yarn of any desired type, preferably nylon. In such an instance, it will be necessary to utilize a full-fashioned or flat bed knitting machine having a substantially greater number of needles in each section than are present in ordinary full-fashioned hosiery machines. Referring to Figures 4, 5, 6 and 7, there will be observed one type of panty which may be formed in such a fashion using ordinary, that is, non-stretchable yarn. In this form of the invention like parts will bear like reference characters with the prime notation added.

It will be observed by referring to Figure 4 that the garment is formed by conventional knitting instrumentalities, not shown, to which yarns are fed by means of yarn feed carriers 10r', 10b' and 10c' actuated by carrier rods 11'. Beginning at the bottom of Figure 4, it will be observed that a plurality of courses 20' are formed and then at least one course of lock or picot stitches 22' is formed, after which the front body portion 23' of the garment is knitted.

The front body portion 23' is knitted in substantially the same manner as that described for the first form of the invention, except that it will be observed that the width of the garment at the waistband edge or the line 22' is substantially wider than in the first form of the invention.

The garment is also widened as at 24' for a plurality of courses, but such widening is not as marked and does not extend for as great a length as is preferred in the first form of the invention. Reinforcing yarn may be knitted into a plurality of wales at the selvages as at 21', if desired, and in the present illustration such reinforcing is shown in the crotch area only omitting the same from the body portions. It will be understood that when the panty is formed from ordinary or non-stretchable yarn sufficient material will have to be provided adjacent the waistband to allow the same to be gathered so that the garment will fit over the hips of a wearer. After a predetermined desired number of courses have been knitted while widening outwardly at each side as at 24', the main portion of the front body portion 23' is knit by ordinary straight knitting for a predetermined number of courses.

The crotch portion 25' is then formed by narrowing the knitting instrumentalities inwardly for a plurality of courses as at 26', the selvages at this area defining the beginning of the leg openings of the panty. In this type of panty, it is highly desirable to provide additional fashioning in the crotch area for the best fit while in the first form of panty the center portion of the crotch area is preferably formed by straight knitting.

In the panty blank 12' the narrowings 26' are continued, however at a progressively smaller rate, to substantially the center portion of the crotch area 25'. At this point the knitting instrumentalities are actuated to widen the fabric outwardly progressively as at 27' through the remainder of the crotch portion.

After the crotch portion 25' has been knitted in this fashion the rear body portion 28' is knitted in a plurality of courses of equal width and then the upper rear edge thereof is fashioned to a somewhat limited degree by narrowing as at 30'. At the completion of this portion of the rear body portion of the panty, additional lock stitches 31' of any desired construction are knitted into the garment so as to prevent runs or raveling or the like at this point. Then an additional area 20' and an additional panty is formed by the knitting instrumentalities.

If desired, a reinforced crotch area may be formed as at 34' in a manner similar to the manner in which the reinforced crotch area 34 is formed in the panty

blank 12. This reinforcement may be fashioned at the beginning and at the end as at 36' and 38', respectively, and may extend into and form a part of the reinforcement 21' if so desired but as a practical matter since it is formed from a different carrier, it is best to leave one or two wales 39' between the reinforced areas 34' and 21'.

After the panty blank 12' has been completed in this manner the edges of the body portions 23' and 28' may be seamed together as at 50 to form a panty P', and a suitable waistband 40' preferably of elastic may be attached to the waistband edges of the garment, in this instance it being observed that the garment is gathered at the point of attachment to the waistband 40' as at 51. In this type of panty P' additional reinforcement will be needed around the leg openings, which may be in the form of elastic tape or ornamental lace or the like or a binding tape 52 which may be secured around the edges of the blank forming the leg openings as by a plurality of stitches 53.

Referring to Figure 6, there will be observed a somewhat schematic enlarged view showing the manner in which locked stitches or picot stitches may be formed at the line 31'. While Figure 6 is a view of the general area 6 in Figure 4, it is a reverse view, that is, in Figure 6 the direction of knitting is from top to bottom as indicated by the arrow. As heretofore stated, any desired type of locked stitch may be formed to prevent raveling upon severance of one panty blank from another.

It will be observed in Figure 6 that the line of locked stitches 31' at the juncture of areas 20' and 28' includes three courses indicated at C-1, C-2 and C-3 and two adjacent stitches from two adjacent wales in the last course of area 28' are interknitted with a single stitch in the course C-1, the yarn forming the course C-1 being taken by the needle hooks and stitches formed therewith after which the needle hooks shift and take the yarn from the next adjacent wale and transfer the yarn from said next adjacent wale back to the original wale so the stitches in the course C-1 are substantially in the shape of a figure eight.

The intermediate course C-2 is then knit in the usual manner wherein a stitch is formed in each wale and, thereafter, the succeeding course C-3 is knit in an identical manner as the course C-1. Therefore, if the fabric is severed at any point beyond the course C-1 it will not ravel or run beyond this course.

Figure 7 is a greatly enlarged view showing the manner in which the crotch portion 34' is widened at its juncture with the reinforced selvage 21' of the panty. It will be noted that the fabric is knitted from the bottom portion of Figure 7 upwardly and the courses are formed in the directions indicated by arrows.

As each successive course is knitted it will be observed that the area 34' is widened from course to course to form the widening points 27'. Reinforcing yarn *r'* is interknitted with the body yarn *b'* in the area 34' which forms the reinforcement for the crotch portion. An additional reinforcing yarn *sr* is interknitted with the body yarn *b'* in the selvage area 21' to provide reinforcement at this area. The manner in which reinforcing yarn is added and the manner in which the fabric is widened is conventional in the knitting of full-fashioned stockings and a further description thereof is deemed unnecessary.

It will thus be observed that we have provided a full-fashioned panty formed from a blank of knitted material knitted from a continuous yarn and widened and narrowed to fashion a desired configuration to the panty and wherein an additional yarn may be interknitted at any desired area for reinforcing or other purposes.

While the invention has been described showing one panty knitted completely of supertwisted yarn and another panty knitted of ordinary yarn or non-supertwisted yarn it will be understood that any combination may be made of the two. For example, in the panty P it may be desirable to interknit certain areas thereof with ordinary non-elastic yarn for reinforcing or ornamental purposes. For example, a reinforced area may extend throughout the center portion of the body areas 23 and 28, if desired, and this reinforced area may be formed of either supertwisted or elastic or non-elastic yarn. It may also be desirable to use yarns of different types (such as nylon and "Dacron") in various portions of the panty.

In the illustrated panty P' it may be highly desirable

to knit certain areas thereof with supertwisted yarn or to reinforce certain areas thereof with supertwisted yarn and it is contemplated that any desired combination of the same may be used in practicing this invention.

After the panty has been fabricated as described, it may be subjected to finishing operations similar to those used in the full-fashioned hosiery art. For example, it may be washed, set, boarded, treated with softeners or otherwise to enhance its appearance and feel.

Panties made in accordance with this invention may be made of relatively heavy yarn for use as bathing suit liners and the like or of relatively heavy elastic yarn to serve as a girdle. In using supertwisted yarns of relatively light weight as used in ladies' stockings, the panties will have sufficient elasticity to hold pads or the like without other support.

Throughout the specification and claims we have employed the word "panty" to include underwear not only for women and children but to include trunks and shorts for men.

In the drawings and specification there has been set forth a preferred embodiment of the invention and, although specific terms are employed, they are used in a generic and descriptive sense only and not for purposes of limitation, the scope of the invention being defined in the claims.

We claim:

1. That method of knitting a full-fashioned selvaged panty blank from at least one highly stretchable synthetic yarn which comprises knitting a first plurality of courses from said yarn to form a first body portion, knitting a second plurality of courses from said yarn to form a crotch portion, knitting a third plurality of courses from said yarn to form a second body portion and widening and narrowing some of said portions during the knitting thereof to fashion the same, wherein the widening and narrowing form fashioning marks in the blank, and wherein selvages are formed during the knitting process along the sides of the body and crotch portions.

2. That method of knitting a full-fashioned stretchable selvaged panty blank which comprises knitting a first plurality of courses with a highly stretchable synthetic yarn to form a first body portion, knitting a second plurality of courses with said yarn to form a crotch portion, knitting a third plurality of courses with said yarn to form a second body portion, widening and narrowing some of said portions during the knitting thereof to fashion the same, wherein the widening and narrowing form fashioning marks in the blank and wherein selvages are formed during the knitting process along the sides of body and crotch portions, and interknitting an additional yarn with said first-named yarn in some areas of said panty blank for reinforcing said areas.

3. That method of manufacturing a full-fashioned selvaged panty or the like from highly elastic synthetic yarn which comprises knitting a first plurality of courses to form a first body portion, knitting a second plurality of courses to form a crotch portion, knitting a third plurality of courses to form a second body portion, widening and narrowing some of said portions during the knitting thereof to fashion the same, wherein the widening and narrowing form fashioning marks and wherein selvages are formed during the knitting process along the sides of body and crotch portions, and then securing corresponding selvages of the first and second body portions together in such a manner that the selvages of the crotch portion define leg openings for the panty.

4. That method of manufacturing a full-fashioned selvaged panty or the like from highly elastic synthetic yarn which comprises knitting a first plurality of courses to form a first body portion, knitting a second plurality of courses to form a crotch portion, knitting a third plurality of courses to form a second body portion, widening and narrowing some of said portions during the knitting thereof to fashion the same, wherein the widening and narrowing form fashioning marks in the blank and wherein selvages are formed during the knitting process along the sides of body and crotch portions, interknitting an additional yarn into certain areas of some of said portions during the knitting thereof for reinforcing the same, and securing corresponding selvages of the first and second body portions together in such a manner that the selvages of the crotch portion define leg openings for the panty.

5. That method of forming a full-fashioned panty

blank from at least one highly stretchable synthetic yarn which includes the steps of knitting a plurality of successive courses to form a first body portion, thereafter, knitting a second plurality of courses while progressively narrowing the same, then knitting a third plurality of courses of substantially uniform width and of a substantially lesser width than said first plurality of courses, then knitting a fourth plurality of courses while widening from course to course until a course of substantially the same width as the first-named courses has been formed, and thereafter knitting a fifth plurality of courses of substantially uniform width to form a second body portion, wherein selvages are formed during the knitting process along the sides of body and crotch portions, and whereby the second, third and fourth pluralities of courses collectively form a crotch portion between said first and second body portions.

6. A full-fashioned panty formed from a single selvaged piece of fabric knitted with at least one highly stretchable synthetic yarn and having front and rear portions connected at their corresponding selvages and a crotch portion extending between the lower edges of said front and rear portions and integral therewith, the selvages of the crotch portion defining leg openings in the panty, and at least one portion of the panty being reinforced by an additional yarn knitted into the fabric.

7. A full-fashioned panty knitted of at least one highly stretchable synthetic yarn and having front and rear selvaged body portions, a selvaged crotch portion between and of lesser width than said body portions, means securing corresponding selvages of the front and rear body portions together to form leg openings defined by the selvages of said crotch portion, and the selvages of the crotch portion having an additional yarn interknitted therein for reinforcement.

8. A full-fashioned stretchable panty or the like formed from a selvaged blank of continuously knitted fabric, said blank being formed of at least one highly stretchable synthetic yarn and being widened and narrowed during the knitting thereof to form front and rear body portions interconnected by a crotch portion, said blank having fashioning marks therein adjacent the selvages, and corresponding selvages of the front and rear body portions being connected together to form the body of the panty with the selvages of the crotch portion defining leg openings for the panty.

9. A full-fashioned panty knitted from at least one highly stretchable synthetic yarn and having front and rear body portions, a crotch portion between and of lesser width than said body portions, at least one of said portions having reinforcing yarn interknitted in at least one area thereof, and means securing corresponding selvages of the front and rear body portions together to form leg openings defined by the selvages of said crotch portion.

10. A full-fashioned panty knitted from at least one highly stretchable synthetic yarn and having front and rear body portions and a crotch portion extending between the body portions, the width of the crotch portion being less than the width of the body portions, some of said portions having fashioning marks therein, and means securing corresponding selvages of the front and rear body portions together to form leg openings defined by the selvages of the crotch portion.

11. A full-fashioned panty knitted from at least one highly stretchable synthetic body yarn and having front and rear body portions, a crotch portion between and of lesser width than said body portions, means securing corresponding selvages of the two body portions together to form leg openings defined by the selvages of said crotch portion, and at least one reinforcing yarn knitted with the body yarn adjacent the selvages of said portions.

12. A full-fashioned panty knitted from at least one highly stretchable synthetic yarn and having front and rear body portions, a crotch portion between and of lesser width than said body portions, means securing corresponding selvages of the front and rear body portions together to form leg openings defined by the selvages of said crotch portion, and at least one reinforcing yarn knitted into a portion of the crotch portion of said panty.

13. A full-fashioned panty knitted from at least one highly stretchable synthetic body yarn and having body portions and a crotch portion extending between and being of lesser width than said body portions, means securing corresponding selvages of the two body portions

together to form leg openings defined by the selvages of said crotch portion, the crotch portion having at least one reinforcing yarn knitted with the body yarn adjacent its selvages and also having a reinforcing yarn knitted with the body yarn in areas thereof between its selvages.

14. A full-fashioned panty formed from a selvaged blank of continuously knitted fabric formed from at least one highly stretchable synthetic yarn and having first and second body portions interconnected by a crotch portion, corresponding selvages of said body portions being connected to each other and the selvages of the crotch portion defining leg openings in the panty and wherein the width of said body portions and said crotch portions is varied during the knitting thereof to fashion the garment and fashioning marks are formed in said portions.

15. A full-fashioned panty formed from a selvaged blank of continuously knitted fabric formed from at least one highly stretchable synthetic yarn and having first and second body portions interconnected by a crotch portion, the crotch portion being of less width than the body portions, the selvages of said first body portion being connected to the selvages of the second body portion and the selvages of the crotch portion defining leg openings in the panty, the width of said body portions and said crotch portions being varied in the knitting thereof to fashion the garment, and portions of said panty having an additional yarn knitted therein for reinforcement.

16. A full-fashioned panty or the like comprising a selvaged blank knit from at least one highly stretchable synthetic yarn and widened and narrowed to form first and second body portions interconnected by a crotch portion, the width of said first and second body portions being varied to fashion said blank, the width of said crotch portion being progressively narrowed from said first body portion and progressively widened toward said second body portion, the selvages of said first body portion being connected to the selvages of the second body portion, the selvages of said crotch portion defining leg openings in the panty, and at least one of said portions having an area in which an additional yarn is knitted for reinforcement.

17. A full-fashioned panty or the like comprising a selvaged blank knit from at least one highly stretchable synthetic yarn and widened and narrowed to form first and second body portions interconnected by a crotch portion, the width of said first and second body portions being varied to fashion said blank, the width of said crotch portion being progressively narrowed from said first body portion and progressively widened toward said second body portion, the selvages of said first body portion being connected to the selvages of the second body portion, the selvages of said crotch portion defining leg openings in the panty, and at least some of the selvages of said blank having an additional yarn knitted therein for reinforcement.

18. A full-fashioned panty or the like comprising a selvaged blank knit from at least one highly stretchable synthetic yarn and widened and narrowed to form first and second body portions interconnected by a crotch portion, the width of said first and second body portions being varied to fashion said blank, the width of said crotch portion being progressively narrowed from said first body portion and progressively widened toward said second body portion, the selvages of said first body portion being connected to the selvages of the second body portion, the selvages of said crotch portion defining leg openings in the panty, and a portion of the crotch portion of said blank having an additional yarn knitted therein for reinforcement.

19. As an article of manufacture, a panty formed from a fashioned knitted and selvaged blank, knitted of highly stretchable synthetic yarn and having opposed end body portions of substantially uniform width, an intermediate crotch portion of substantially less width than said body portions, opposite ends of said crotch portion being flared outwardly so the selvages of the crotch portion coincide substantially with the selvages of said body portions, at least some of said portions having fashioning marks therein, and corresponding selvages of the body portions being joined together whereby leg openings are defined by the selvages of said crotch portion.

20. A full fashioned panty having a front body portion, a rear body portion and a crotch portion between and mainly of less width than the body portions, the

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portions being knitted from highly stretchable synthetic yarn, at least one of said portions having reinforcing yarn incorporated in at least one area thereof, the side edges of one body portion being secured to the side edges of the other body portion and the side edges of the crotch portion defining leg openings of the panty. 5

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