Oct. 18, 1938. E. A. LOCKWOOD 2,133,749

METHOD OF GARMENT MANUFACTURE

Filed June 2, 1937 2 Sheets-Sheet 1

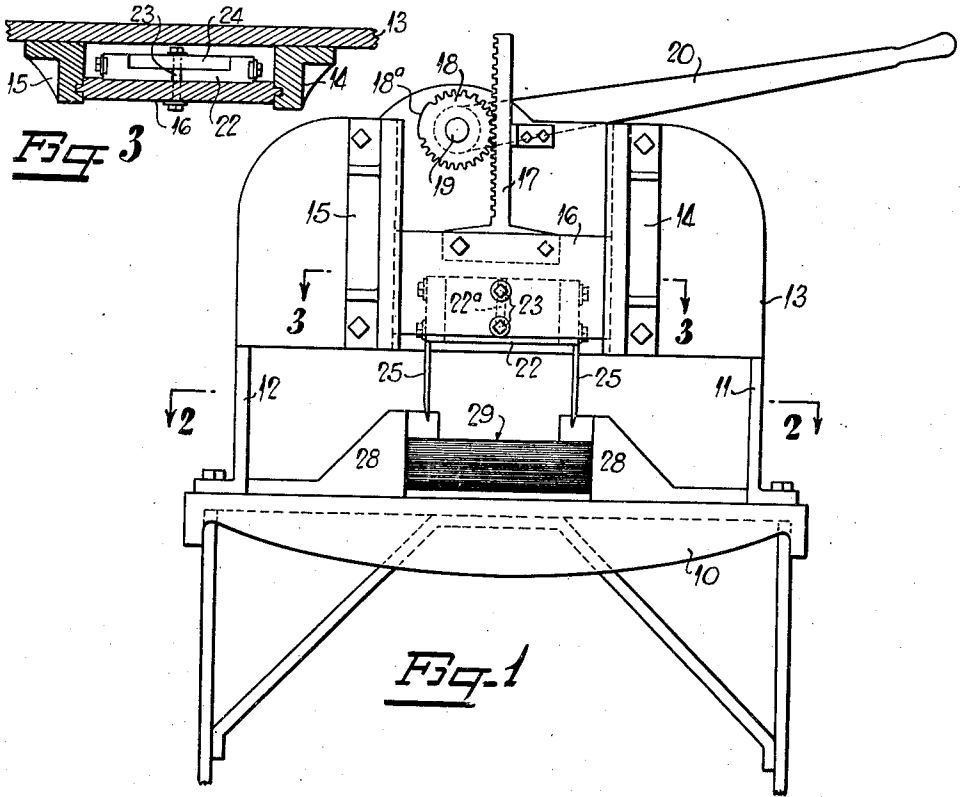


Fig. 3

Fig. 1

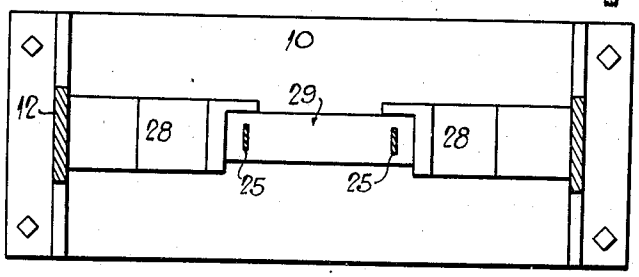


Fig. 2

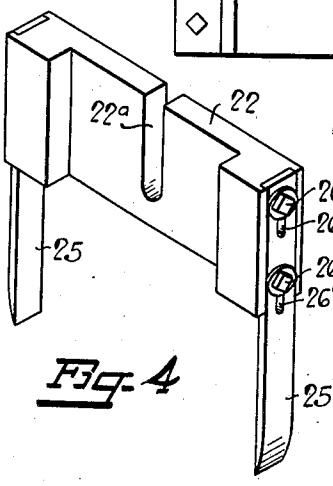


Fig. 4

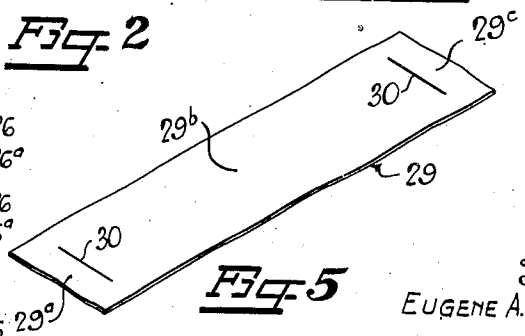


Fig. 5

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METHOD OF GARMENT MANUFACTURE

Filed June 2, 1937 2 Sheets-Sheet 2

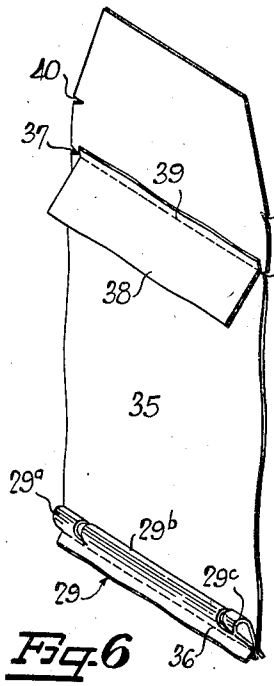


Fig. 6

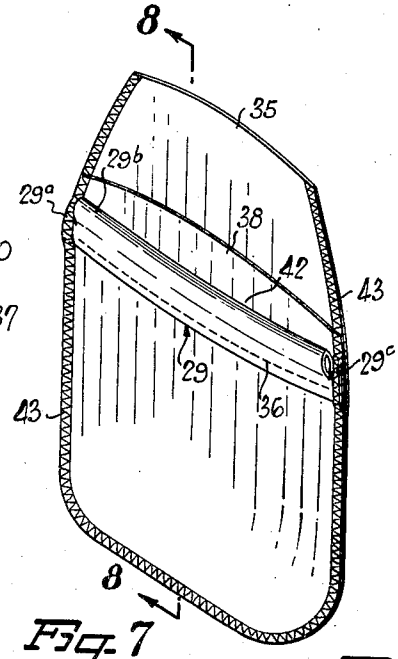


Fig. 7

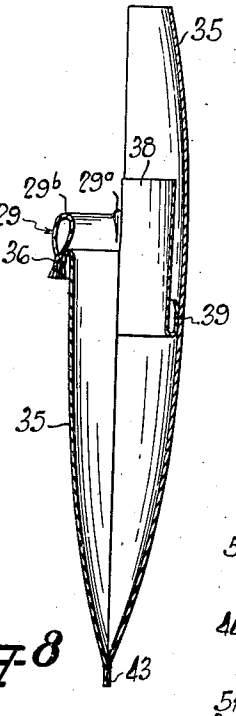


Fig. 8

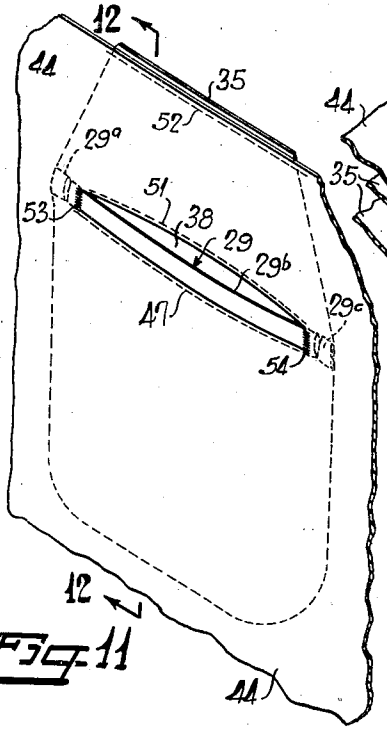


Fig. 11

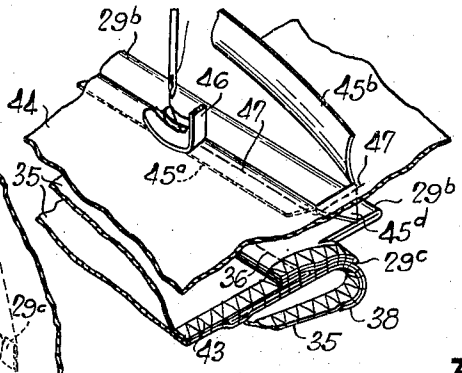


Fig. 10

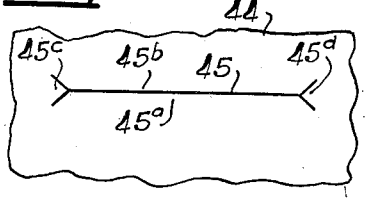


Fig. 9

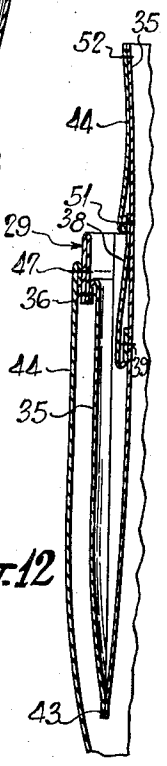


Fig. 12

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UNITED STATES PATENT OFFICE

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METHOD OF GARMENT MANUFACTURE

Eugene A. Lockwood, High Point, N. C.

Application June 2, 1937, Serial No. 145,941

3 Claims. (Cl. 2—247)

This invention relates to a method and means for constructing and attaching a pocket to a garment and more especially to a pre-fabricated welt which is used in the construction of the pocket and as an attaching strip whereby the pocket is joined to an outer garment.

Heretofore, it has been the practice to fold a welt strip upon itself and secure it to the upper outer edge of the pocket by stitching the same at each end of the welt and to the top of the pocket fabric. This folded strip, when secured to an outer surface, constitutes the top outer edge of the pocket, but before the pocket is secured to an outer garment it is necessary to then clip the top of the welt a substantial amount at points immediately adjacent the stitched ends of the folded welt so that the intermediate portion between the clips can be folded down and its entire length stitched to an outer garment by an ordinary sewing machine. This clipping operation after the welt had been sewed in position on the pocket prior to the fastening of the pocket to the garment, has proven to be very expensive, in fact, this clipping consumes one-third of what is known as the serging operation on the pocket.

It is therefore, an object of this invention to provide a method and means for prefabricating this welt strip prior to its being sewed onto the pocket to thereby eliminate this subsequent clipping operation.

It is a further object of this invention to provide an apparatus for cutting spaced parallel slits in a plurality of welt strips, comprising a pair of spaced knives secured to a movable slide, a base member upon which the welt strips are adapted to be placed, one above the other, and means for operating the spaced knives relative to said base member to punch spaced slits in a plurality of welt strips at one operation. By using this apparatus one person can pre-fabricate enough welt strips in a short time to supply the demands of an ordinary garment manufacturing business for many months, since several dozen welts are punched in one operation which only takes a few seconds to complete.

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 an elevation of a punching apparatus used for punching slits in a plurality of welt strips at one operation;

Figure 2 is a sectional, plan view taken along line 2—2 in Figure 1:

Figure 3 is a sectional, detail, plan view taken along line 3—3 in Figure 1;

Figure 4 is an isometric view of the knives used for punching spaced holes in the welt strips;

Figure 5 is an isometric view of a single welt strip after it has been punched with spaced slits therein, by the knives shown in Figures 1 and 4;

Figure 6 is an isometric view of a pocket strip after the pocket facing and welt strips have been sewed thereon;

Figure 7 is an isometric view of the parts shown in Figure 6 after the serging operation has been completed in which the pocket strip is folded upon itself and the ends of the pocket facing and welt strip have been secured to the back side of the pocket;

Figure 8 is a sectional view taken along line 8—8 in Figure 7;

Figure 9 is a view of a portion of an outer garment showing a slit cut therein to provide an opening for attaching the pocket, shown in Figure 7;

Figure 10 is an isometric, detail view showing the position of the welt of the pocket and the outer garment, shown in Figure 9, as they are being stitched together;

Figure 11 is an isometric view of an outer garment showing the pocket after it has been stitched and bar-tacked to the garment;

Figure 12 is a vertical sectional view taken along line 12—12 in Figure 11.

Referring more specifically to the drawings, the numeral 10 indicates a suitable base member which supports upright legs 11 and 12, said legs having secured to the upper end thereof a lintel 13. This lintel has secured thereto vertically disposed grooved guides 14 and 15 between which a slide 16 is adapted to have vertical movement. This slide has an upwardly extending rack 17 which has teeth in one side thereof normally engaging a pinion 18. The pinion 18 is fixedly secured on stud shaft 19 which shaft has secured on its other end a lever 20 for operating the rack 17 and its associated slide 16 relative to the base member 10. The lower end of slide 16 has a member 22 secured thereto by any suitable means such as bolts 23. The bolts 23 penetrate the member 22, slide 16, as well as a washer plate 24 placed on the rear side thereof, Figure 3. A slot 22a is provided in the member 22 in order that this member may be adjusted relative to the slide 16. Adjustably secured in the ends of the member 22 are knives 25 which knives are secured to the member 22 by means of stud bolts 26. These knives have slots 26a therein which will also permit adjust-

ment of the lower ends of these knives relative to the base member **10**.

It will be noted that the pinion **18** has a space **18***a* which has no gear teeth therein and this portion acts as a stop to limit the downward movement of the slide **16** and its associated parts. By utilizing the adjustments made possible by the slots **22***a* and **26***a*, it is possible to determine very accurately the stopping point of the lower edge of the knives **25** when they are in a lowermost position.

A pair of spacing blocks **28** are placed on top of the base member **10** which are so constructed that the space therebetween will accommodate a stack of welt facing strips **29**. When these strips are placed between the blocks **28** then the lever **20** is rotated in a clockwise manner in Figure 1 to cause the knives to move downwardly to punch slits **30** near each end of the strips **29**.

It is of course evident that the above operation takes very little time and in addition to this fact, many welt facings can be punched at a time. After this operation each welt facing strip **29** is folded upon itself and sewed to the lower end of a piece of pocket material **35** by means of a row of stitches **36** in the manner shown in Figure 6.

The piece of pocket material **35** has a pair of sight notches **37** cut near the upper portion thereof in Figure 6. These notches are merely indicating marks to guide the seamstress in placing a suitable pocket facing strip **38** on the pocket material **35**. This facing material **38** is of a slightly shorter width than the pocket material so that the strip may be placed thereon without concealing the notches from view. When the facing **38** is properly positioned, it is secured to the pocket material **35** by means of a row of stitches **39**.

The pocket material **35** also has another pair of sight notches **40** which are used to indicate the position at which the top edge of the welt strip **29** is to be placed prior to the serging operation. After the strip of material **35** is folded upon itself in the manner shown in Figures 7 and 8, the edges of the pocket are sewed together and sheared in what is known as the serging operation, leaving an opening **42** in the upper edge thereof. When the parts are thus sewed together, it is seen that the facing **38** is also secured at each end under the serging stitch **43** together with the end portions **29***a* and **29***c* of the welt **29**. This leaves the intermediate portion **29***b* free, so that the upper portion of the pocket **35** and facing **38** can be doubled upon itself while being attached to an outside fabric such as **44** in the manner shown in Figure 10. The fabric **44** has a slit **45** cut therein so that four flaps can be folded therefrom. These flaps more specifically, are designated by the reference characters **45***a*, **45***b*, **45***c* and **45***d*. The flap **45***a* is turned inwardly upon the inside portion of fabric **44** and then placed upon the intermediate welt portion **29***b* of the welt **29**. Both of these layers are placed beneath a suitable presser foot **46** of a sewing machine and a row of stitches **47** is placed in these layers to join the fabrics together. If it were not for the end slits **30** in each end of the welt **29**, it would be impossible to place the row of stitches **47** close to the ends of the welt **29***b*. On the other hand, by providing these slits, it makes it easier to fold the upper portion of the pocket upon itself and place both layers of fabrics which are desired to be joined together, beneath a presser foot and sewed together (Figure 10). Also, by prefabricating this piece of material, it not only saves time which is necessary to clip the same prior to securing the pockets to the outer fabric **44**, but a greater degree of uniformity in the slits is obtained. The human element enters into the clipping of these end slits and very often the slits are cut too deep or too shallow thus resulting in an imperfect garment.

The next step in the formation of the pocket is to fold the lower edge of flap **45***b* inwardly upon itself and stitch the same to the piece of pocket material as at **51**, said stitches being adapted to penetrate the upper edge of pocket facing **38** as well as the pocket material **35**. An additional row of stitches **52** is placed at the upper edge of the pocket material **35** to secure this material to the outer garment **44**.

The flaps **45***b* and **45***d* are folded inwardly upon themselves in the manner shown in Figure 10 and then suitable bar-tacks **53** and **54** are placed through the end flaps **45***b*, **45***d* and **45***c*, and the fabric **44** and welt portion **29***b* to secure all of the portions at this point together; however, prior to the placing of the bar-tacks the row of stitches **47** is also placed at the ends as well as through the pocket welt to temporarily secure all of the parts in the proper position. The bar-tacks are merely used as an additional re-inforcement for the ends of the pockets.

By providing a pre-fabricated welt **29** as shown, it is seen that the ends **29***a* and **29***c* are also secured beneath the serge stitches **43** thereby firmly securing the welt in position on the pocket. It is very essential that the end portions be properly secured since the welt is of vital importance when the pocket is secured to an outer fabric.

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 set forth in the appended claims.

I claim:

1. That method of forming a pocket which comprises forming a pair of spaced slits in a welt fabric, doubling said fabric upon itself so that the fold line traverses said slits to form an intermediate welt and two end welts, securing the folded edges of said fabric to one end of a piece of pocket material, then folding said pocket material upon itself and securing the end welts in the side edges of said pocket, cutting a second slit of a shorter length than said intermediate welt in a garment material and then securing the intermediate welt to the material adjacent the second slit.

2. That method of forming a welt on a pocket which comprises forming a pair of parallel spaced transversely disposed slits in a rectangular piece of welt material, spaced a predetermined distance apart, and which extend short of the edges of the piece of welt material, folding the piece of welt material along its longitudinal center to cause the fold line to bisect said slits, stitching said edges to one end of the piece of pocket material, forming a suitable slit in a garment, overlapping the folded welt portion which is disposed between said first slits with one edge of said second slit, and stitching said folded welt portion to the material adjacent said slit in the garment.

3. That method of forming a pocket in a garment which comprises forming a plurality of welt pieces, simultaneously cutting a pair of transverse spaced parallel slits a predetermined distance apart in said welt pieces, and which are disposed adjacent the ends of said welt pieces, folding said

welt pieces along their longitudinal center so that the line of fold traverses said slits, stitching the edges of a folded welt piece to one end of a piece of pocket material, doubling said piece of pocket material and securing its sides together to form a pocket, forming a slit in the garment material of a shorter length than the intermediate folded welt portion disposed between the slits, overlapping said welt portion with one edge of said second slit in the garment material and securing the intermediate folded welt portion to the material adjacent the slit in the garment.

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