Oct. 28, 1941. C. S. FOWLER 2,260,372

SLIDE-FASTENED KNITTED CUFF CLOSURE

Filed Sept. 5, 1940 4 Sheets-Sheet 1

Fig. 1

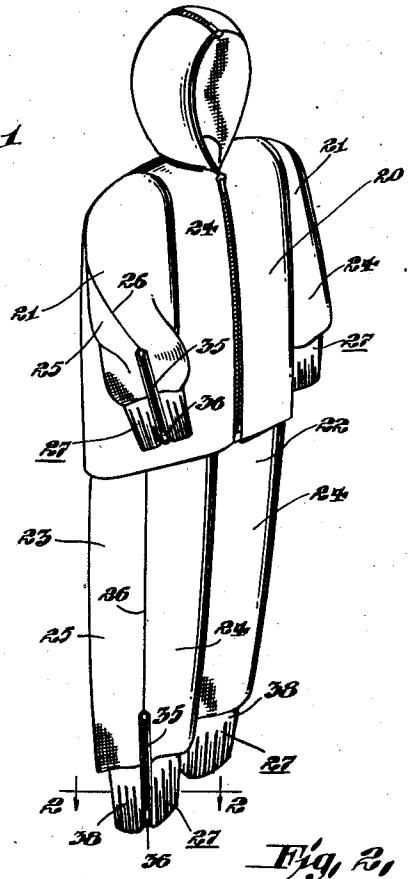


Fig. 3

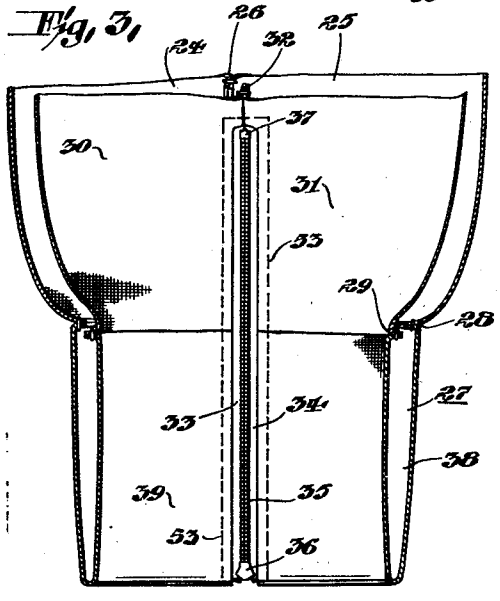
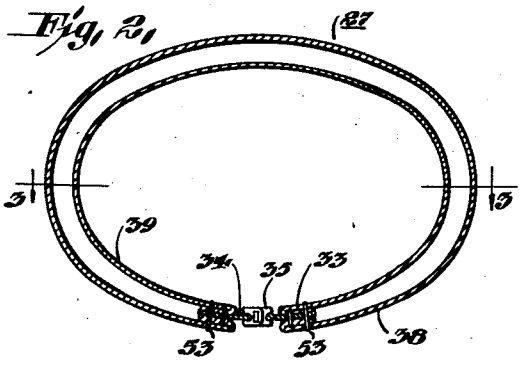


Fig. 2



INVENTOR.
Carl S. Fowler,
BY R. S. Kelley.
ATTORNEY.

Oct. 28, 1941. C. S. FOWLER 2,260,372

SLIDE-FASTENED KNITTED CUFF CLOSURE

Filed Sept. 5, 1940 4 Sheets-Sheet 2

Fig. 4.

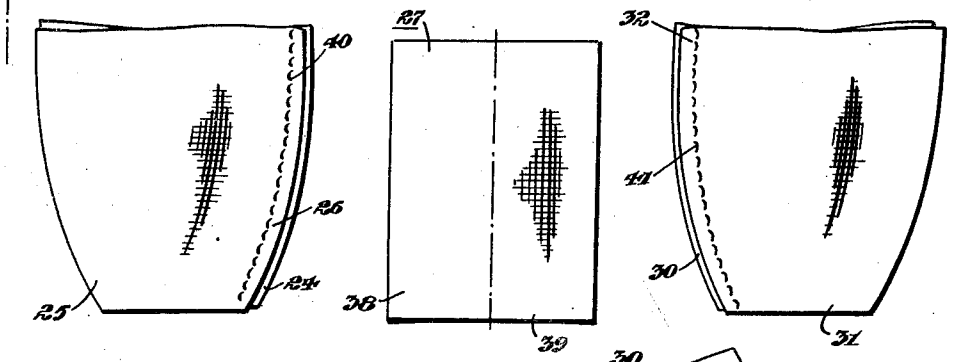


Fig. 5.

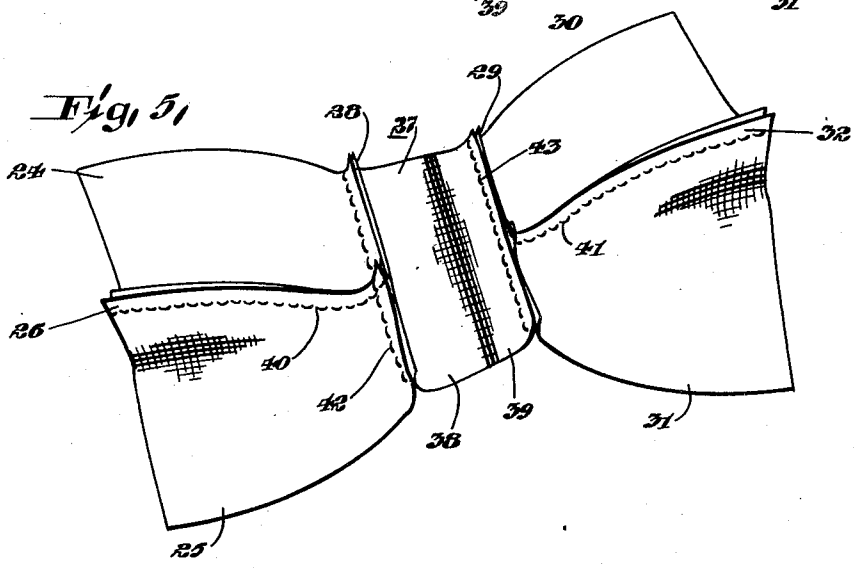
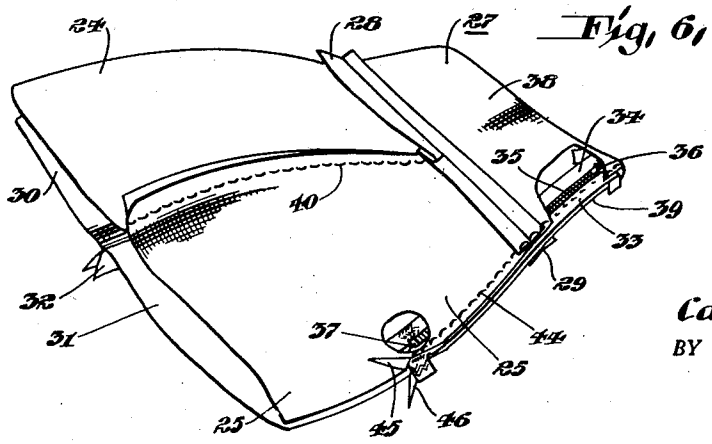


Fig. 6.



INVENTOR.
Carl S. Fowler,
BY R. S. Kelley.
ATTORNEY.

Oct. 28, 1941. C. S. FOWLER 2,260,372

SLIDE-FASTENED KNITTED CUFF CLOSURE

Filed Sept. 5, 1940 4 Sheets-Sheet 3

Fig. 7.

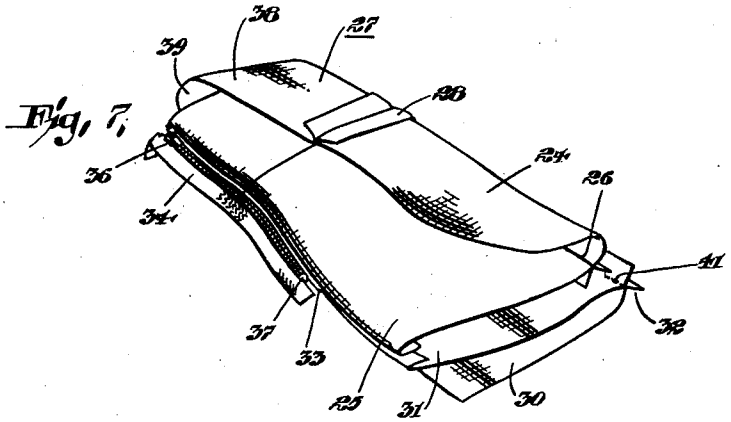


Fig. 8.

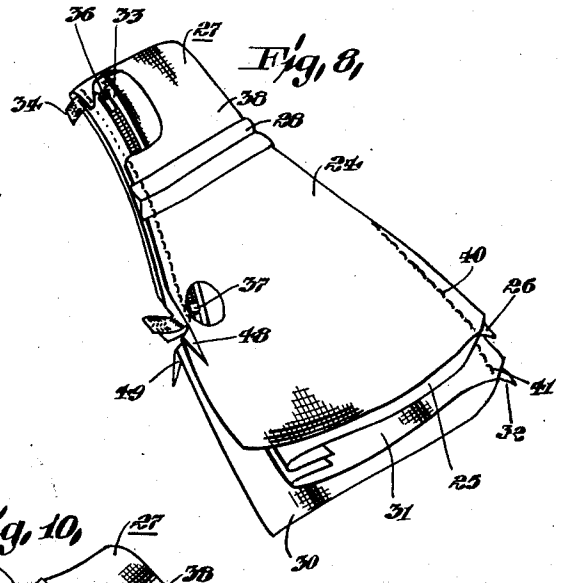


Fig. 9.

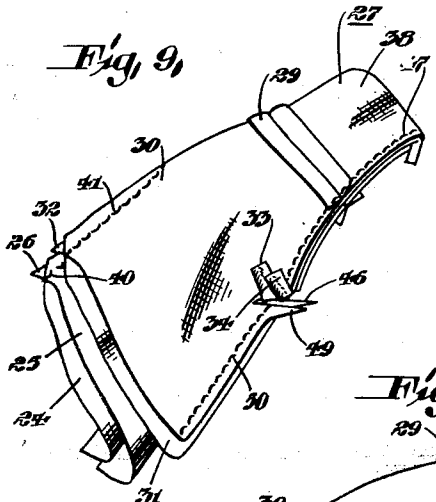
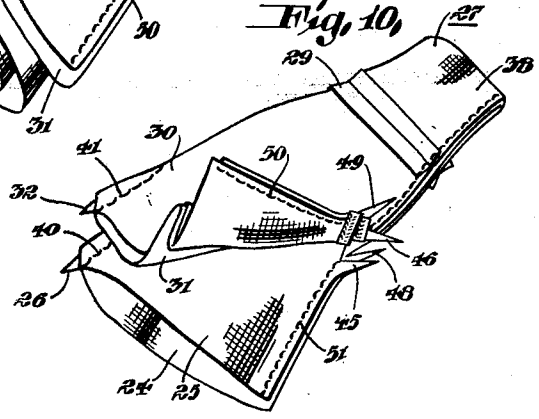


Fig. 10.



INVENTOR.
Carl S. Fowler,
BY R. S. Kelley.
ATTORNEY.

Oct. 28, 1941. C. S. FOWLER 2,260,372

SLIDE-FASTENED KNITTED CUFF CLOSURE

Filed Sept. 5, 1940 4 Sheets-Sheet 4

Fig. 11.

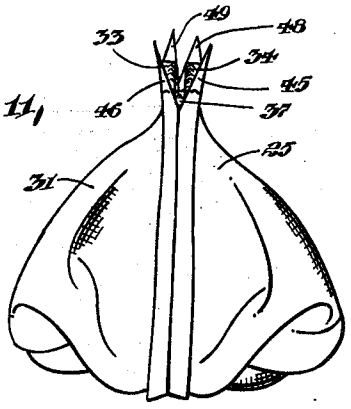


Fig. 12.

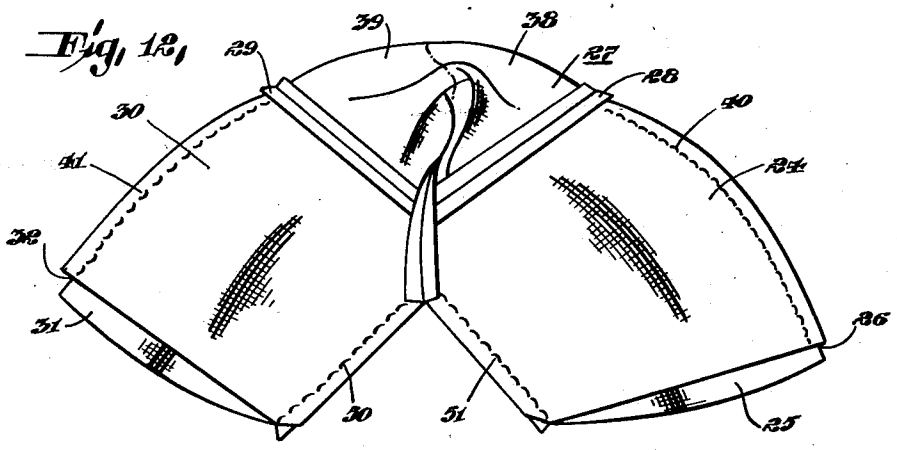
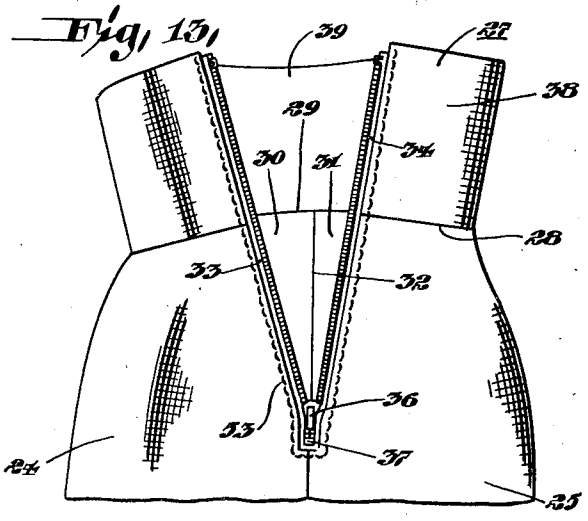


Fig. 13.



INVENTOR.
Carl S. Fowler,
BY R. S. Kelley.
ATTORNEY.

Patented Oct. 28, 1941

2,260,372

UNITED STATES PATENT OFFICE

2,260,372

SLIDE-FASTENED KNITTED CUFF CLOSURE

Carl S. Fowler, Philadelphia, Pa., assignor to Talon, Inc., a corporation of Pennsylvania

Application September 5, 1940, Serial No. 355,493

12 Claims. (Cl. 2—270)

This invention relates to garments and, in particular, to garments, such as ski garments and/or snowsuits which are provided with knitted cuffs at the extremities or openings of the garment limb portions.

It is an object of this invention to provide such a garment construction which is lined, wherein the knitted cuffs are provided with slide-fastened closures extending therethrough and therebeyond, and wherein the raw edges of the seams in the garment limb portions, as well as the stringer tapes of the slide fastener, are disposed between the garment proper and the lining in such manner that obstructions caused in the garment interior by raw edges are totally obviated in order to provide the garment with a smooth unobstructed interior.

It is a further object of this invention to provide such a garment construction wherein the knitted cuff is formed of a single, seamless, knitted cuff piece forming a two-ply cuff, with its surface uninterrupted save for the slide fastener which extends through the knitted cuff.

It is a further object of this invention to provide a new and improved method of forming the limb portions, i. e. legs and arms of such garments.

It is a further object of this invention to provide such a method wherein a slide fastener may be incorporated in the seamless, two-ply cuff of such garments with utmost facility and convenience.

These and other objects and advantages of the invention will appear from the following description taken in conjunction with the accompanying drawings which form a part thereof, and will be pointed out in the appended claims.

In the drawings:

Fig. 1 is a view, in perspective, of an illustrative garment embodying a slide-fastened knitted cuff construction according to this invention:

Fig. 2 is a section taken substantially on the line 2—2 of Fig. 1;

Fig. 3 is a fragmentary section taken substantially on the line 3—3 of Fig. 2;

Fig. 4 is a fragmentary plan view illustrating the parts of a slide-fastened knitted cuff construction according to this invention, illustrating the first step in the assembly thereof;

Fig. 5 is a fragmentary view, in perspective, illustrating a subsequent step in the method;

Fig. 6 is a view similar to Fig. 5, but illustrating a step of the method following the step of Fig. 5, wherein one free edge of each of the garment and lining panels is stitched to an interposed stringer of a slide fastener and wherein the panel edge portions overlying the attached stringer tape are clipped concurrently to form manipulative tabs;

Fig. 7 is a view similar to Fig. 6 of a step of the method following the step of Fig. 6 and illustrating the turning inside out of the structure shown in Fig. 6 prior to alignment of the free edges of the garment and lining panels with the free stringer tape prior to being stitched thereto;

Fig. 8 is a view similar to Fig. 7, but showing the step of the method following the step of Fig. 7, wherein the free edges of the garment and lining panels are stitched to the free stringer tape and the overlying free edge portions of the garment and lining panels are clipped to form manipulative tabs;

Fig. 9 is a view similar to Fig. 8, but showing the step of the method following that of Fig. 8, in which step the side seam of the lining is extended beyond the fastener and beyond the above-described manipulative tabs;

Fig. 10 is a view similar to Fig. 9, but illustrating the following step of the method wherein the side seam of the garment panels is extended beyond the slide fastener and the manipulative tabs previously formed therein;

Fig. 11 is a fragmentary view illustrating the step of the method following that of Fig. 10, wherein the manipulative pull tabs are drawn away from the garment material and lining and secured to the stringer tapes adjacent and below the bottom stop of the fastener by a row of transverse stitching;

Fig. 12 is a fragmentary view, in perspective, illustrating the step of the method following the step of Fig. 11, wherein the knitted cuff construction is folded flat, wrong side out, in order that it may be telescoped with the lining inside to bring the parts to the position shown in Fig. 13; and

Fig. 13 is a similar view illustrating the last step of the method wherein the plies of knitted material are secured together and the garment material and lining are secured together adjacent the closure opening by a single line of top stitching extending throughout the length of one stringer tape, transversely adjacent and below the bottom stop of the fastener and thence throughout the length of the other fastener stringer, to form the construction shown in Figs. 1, 2 and 3.

The illustrative garment shown in Fig. 1 comprises a hooded jacket 20, wherein the limb portions comprise sleeves 21 and a trouser garment 22, wherein the limb portions comprise legs 23. Each of the limb portions 21 and 23 are of similar construction and each comprises a front panel 24 and rear panel 25 connected at each side by seams 26, the outer seam 26 of each garment limb portion terminates at its lower end in a slide-fastened closure. This slide-fastened closure extends downwardly throughout the length of the two-ply knitted cuff 27 which is preferably formed of a single piece of elastic knitted mate-

rial folded over upon itself, having its outer upper edge secured by a seam 28 to the lower edges of the front and back panels 24 and 25 and having its inner upper edge secured by a seam 29 to the lower edges of front and back lining panels 30 and 31. These panels 30 and 31 are of size and shape similar to that of garment front and back panels 24 and 25 and have their side edges secured together by longitudinal seams 32 which are similar to the above-described seams 26 and which are similarly disposed, though oppositely directed. The seams 26, 28, 29 and 32 have their raw edges disposed between the inner and outer walls of the leg portion formed by the front and back garment panels 24 and 25, the knitted cuff 27 and the front and back lining panels 30 and 31.

As shown in Fig. 3, the slide fasteners in the slide-fastened closures of the garment are of conventional form, each comprising a pair of stringer tapes 33 and 34, each having thereon a row of predeterminedly spaced cooperating interlocking fastener members 35 which are progressively meshed and unmeshed by a slider 36 slidable on the rows of interlocking fastener members 35 and having its movement in each direction limited by top stops at the upper end of stringer tapes 33 and 34 and a bottom stop 37 connecting the stringer tapes 33 and 34 adjacent the lower end of the rows of fastener members 35. The stringer tape 33 is stitched in sandwiched relation between the plies of the cuff piece 27 and the adjoining plies of the front garment panel 24 and underlying front lining panel 30, while the stringer tape 34 is secured in like manner between the plies of the cuff piece 27 and the back garment and lining panels 25 and 31, the fastener members 35 being arranged substantially centrally of the closure opening throughout its length.

Since the fastener extends throughout the length of the knitted cuff and for a substantial distance upwardly into the garment limb portion, when the slider 36 of the fastener is drawn upwardly adjacent the bottom stop 37, a closure opening of substantial size is provided in the garment for facilitating ingress and egress of the wearer. Likewise, when the fastener is closed by drawing the slider to a point adjacent the top stops, as shown in Fig. 3, this closure is closed from end to end whereby the two-ply knitted cuff will fit snugly about the ankle or wrist of a wearer.

From the above description, and as shown in Figs. 1, 2 and 3, it will be readily seen that the raw edges of the seams 26, 28, 29 and 32 are all disposed between the walls or shells of the garment, whereby the interior surface of the lining is completely without obstruction which might impair appearance and ease of ingress and egress. This construction, with its resultant advantages, is achieved as follows:

The component parts of each garment limb portion, exclusive of the slide fastener, are assembled, as shown in Fig. 4. These parts comprise the front garment panel 24 and a similar back garment panel 25, which panels 24 and 25 form the outer wall or the outer shell of the garment limb portion, as explained above. Also included are the front lining panel 30 and a similar back lining panel 31, which lining panels 30 and 31 form the lining, inner wall, or inner shell of the garment limb portion. The other part included is the cuff piece 27. This cuff piece is folded about a lateral axis substantially midway of its length to form the outer cuff panel 38 and the inner or lining cuff panel 39. The front and back garment panels 24 and 25 are superposed, as shown in Fig. 4, and adjacent edges thereof are secured together by a line of stitching 40 which forms one of the above-described side seams 26. The front and back lining panels 30 and 31 are superposed in like manner, and the edges thereof are secured together by a similar line of stitching 41, which forms one of the above-described side seams 32.

The garment panels 24 and 25 are then opened out and laid flat, wrong side up, and with the raw edges of the seam 26 up, as shown in Fig. 5. The lining panels 30 and 31 are likewise opened out and laid flat, wrong side up, and with the raw edges of the seam 32 disposed up, as also shown in Fig. 5. Then the cuff piece 27 is laid flat between the spaced lower edges of the connected garment panels and lining panels and the lateral edge of the outer cuff panel 38 is secured to the lower edges of the connected garment panels 24 and 25 by a line of stitching 42 which forms the above-described seam 28. The lateral edge of the inner or lining cuff panel 39 is secured to the lower edges of the lining panels 30 and 31 in like manner by a line of stitching 43 which forms the above-described seam 29. Due to this manner of attachment of the parts, the raw edges of the respective seams all lie on the wrong sides of the connected pieces of the garment limb portion, as shown in Fig. 5.

The following step of the method is illustrated in Fig. 6. In this step, the assembly shown in Fig. 5 is folded over upon itself along the fold line of the cuff piece 27. The garment panels 24 and 25 are disposed in alignment with and in overlying relation to the lining panels 30 and 31, and the cuff piece 27 is folded, as above described, to form the cuff panels 38 and 39, the outer cuff panel 38 being disposed upwardly and the wrong side of each piece of material being disposed outwardly, with the raw edges of the seams, as shown in Fig. 6. The slide fastener is then inserted between the back garment panel 25 and back lining panel 31 at one edge, with the (then) righthand stringer tape 33 aligned substantially with the aligned edges of the panels 25, 31, 38 and 39. A line of stitching 44 then secures the stringer tape 33 to the aligned overlying edge portions of the panels 23, 31, 38 and 39. The stitching 44 extends from the fold in the cuff piece 27 substantially to the bottom stop 37 of the slide fastener. Adjacent and below the bottom stop 37, aligned slots are cut from the superposed edges of the panels 25 and 31 substantially to the bottom stop 37 and inclined at a suitable angle, as for instance 45 degrees, from the aligned edges of the panels 25 and 31 to form manipulative tabs 45 and 46, respectively, on the panels 25 and 31. The extremity of the stringer tape 33 adjacent the bottom stop 37 is then pulled out beyond the edges of the panels 25 and 31, as shown in Fig. 6. The structure of Fig. 6 is thus achieved.

In the next operation, the free fastener stringer tape 34 is grasped and pulled to the left, as seen in Fig. 6, while the panels 25 and 31 are telescoped into, or drawn between, the panels 24 and 30, as shown in Fig. 7. This accomplishes also the telescoping of the cuff panels 38 and 39 which occurs concurrently.

The next operation, as shown in Fig. 8, comprises aligning the free edges of the panels 24, 30, 38 and 39 with the free stringer tape 34 and the application of the line of stitching 47, similar

to the above-described line of stitching 44, and of similar extent, for securing the stringer tape 34 in sandwiched relation between aligned adjacent edges of the panels 24 and 30 and the cuff panels 38 and 39. Aligned slots, similar to those described above, are cut into the superposed edges of the panels A and C substantially to the bottom stop 37 and inclined at a suitable angle, as described above, for forming manipulative tabs 48 and 49 at the edge portions of the panels 24 and 30 respectively. The extremity of the stringer tape 34 adjacent the bottom stop 37 is then pulled out beyond the edges of the panels 24 and 30, as shown in Fig. 8. This forms the structure shown in Fig. 8.

The next operation, illustrated in Fig. 9, comprises placing the structure of Fig. 8 up-side down without disturbing the relative position of parts with the panel 24 lowermost and the panel 30 uppermost. A line of stitching 50 is then placed through the aligned edges of the panels 30 and 31, which line of stitching 50 begins at the manipulative tabs 46 and 49 and extends upwardly throughout the length of the panels 30 and 31.

The next operation which is illustrated in Fig. 10 comprises folding back the edges of the panels 30 and 31 which have been connected by the line of stitching 50 and then applying a line of stitching 51 to the aligned free edges of the superposed panels 25 and 24, which line of stitching 51 begins at the manipulative tabs 45 and 48 and extends upwardly throughout the length of the panels 25 and 24.

Thereafter, the manipulative tabs 45, 46, 48 and 49 and the ends of the stringer tapes 33 and 34 are manually pulled away from the attached parts which are allowed to extend downwardly from these grasped parts, as indicated in Fig. 11. The manipulative tabs 45 and 48 are aligned with one another and with the intermediate end of the stringer tape 34, and the manipulative tabs 46 and 49 are likewise aligned with one another and with the end portion of the stringer tape 33 which is disposed therebetween. Thereafter, as shown in Fig. 11, a transverse line of stitching 52 is passed through these aligned parts adjacent the bottom stop 37 at the lower end of the slide fastener to insure compactness and flatness at the upper end of the slide-fastened closure.

The formation of manipulative tabs 45, 46, 48 and 49 greatly facilitates the alignment of the ends of the fastener tapes 33 and 34 with respect to the end of the closure aperture, and the transverse line of stitching 52 fixes the position of the bottom stop 37 and the lower ends of the stringer tapes 33 and 34 with respect to the panels and closure opening. This insures a smooth flat construction adjacent the inner end of the slide-fastened closure opening which constitutes a substantial advance over the prior art practice in neatness and compactness or flatness.

The next operation comprises releasing the manipulative tabs 45, 46, 48 and 49 which have been secured together by the transverse line of stitching 52 and returning the parts to the position shown in Fig. 10. The connected panels 30 and 31 are then grasped and pulled to the left, as seen in Fig. 10, and the connected panels 24 and 25 are flattened out fanwise with the panel 25 lowermost, and the cuff panels 38 and 39 spread, all as shown in Fig. 12.

The next and last operation comprises telescoping of the connected panels 30 and 31 inside the connected panels 24 and 25 and flattening down the parts with the right side of the garment panels disposed outwardly and the right side of the lining panels disposed inwardly with the raw edges therebetween, and then applying the top stitching 53 which extends completely around the closure opening and the metallic parts of the fastener, as shown in Fig. 13. The parts are then aligned and pressed in place, and one limb portion of a garment such as that shown in Fig. 1 is produced. Thereafter, the limb portions, each of which has been formed as explained above, are incorporated into the garment or a part thereof in a manner which will be readily understood.

Although it is preferable that the double wall or lined knitted cuff be formed of a single piece of material, it may, of course, be formed of a plurality of pieces connected in known manner by seams, the raw edges of these seams being preferably disposed between the outer wall and the lining of the garment leg portion.

From the above description, it will clearly appear that I have produced a new and improved garment of the class described, embodying lined limb portions having knitted cuffs provided with slide-fastened closures extending therebetween and therebeyond, wherein the raw edges of the seams connecting the constituent parts or panels are disposed between the lining and the outer wall of the garment limb covering portion. Likewise, in the preferred embodiment of this garment construction, the knitted cuff is formed of a single seamless knitted cuff piece forming a two-ply cuff. Likewise, it will clearly appear that I have produced a new and improved method of forming such garments and garment limb covering portions, directed particularly toward snug application of the slide fastener in the slide-fastened closure of the knitted cuff.

It is, of course, to be understood that the above description is merely illustrative and in nowise limiting and that I desire to comprehend within my invention such modifications as are included within the scope of the appended claims.

Having thus fully described my invention, what I claim as new and desire to secure by Letters Patent is:

1. In a garment, a lined limb portion having a slide-fastened knitted cuff closure comprising an outer wall of garment material, a lining wall inside said outer wall, a double walled knitted cuff having its outer and inner walls connected by seams to the lower edges of said outer and lining walls respectively, the raw edges of said last-named seams being disposed between said outer and lining walls, said limb portion having a closure opening extending throughout the length of said cuff and therebeyond, and a slide fastener in said closure opening having its stringer tapes sandwiched and stitched between the walls of said cuff, and between said outer wall and said lining wall.

2. In a garment, a lined limb portion having a slide-fastened knitted cuff closure comprising an outer wall of garment material, a lining wall inside said outer wall, a seamless knitted cuff piece folded about a transverse axis intermediate its ends with its transverse end edges connected by seams to the lower edges of said outer and lining walls respectively to form a seamless double-walled knitted cuff, the raw edges of said last-named connecting seams being disposed between said outer and lining walls, said limb portion having a closure opening extending throughout the length of said cuff and therebeyond, a slide fastener in said closure opening

having its stringer tapes disposed between the walls of said cuff, and between said outer wall and said lining, and top stitching extending around said closure opening and securing said stringer tapes to overlying portions of said outer and lining walls.

3. In a garment, a lined limb portion having a slide-fastened knitted cuff closure comprising limb panels of garment material connected by seams having their raw edges at the wrong side of the garment material and directed inwardly, said panels forming an outer wall, lining panels of lining material connected by seams having their raw edges directed outwardly and disposed at the wrong side of the lining material to form a lining wall disposed inside said outer wall, a double walled knitted cuff having its outer and inner walls connected by seams to the lower edges of said outer and lining walls respectively, the raw edges of said last-named seams being disposed between said outer and lining walls, said limb portion having a closure opening extending throughout the length of said cuff and therebeyond into seams connecting said limb panels and lining panels respectively and a slide fastener in said closure opening substantially coextensive therewith and having its stronger tapes disposed between the walls of said cuff, and between said outer wall and said lining and stitching connecting said stringer tapes to overlying portions of said outer and inner walls and said cuff.

4. In a garment, a lined limb portion having a slide-fastened knitted cuff closure comprising limb panels of garment material connected by seams having their raw edges at the wrong side of the garment material and directed inwardly, said panels forming an outer wall, lining panels of lining material connected by seams having their raw edges directed outwardly and disposed at the wrong side of the lining material to form a lining wall disposed inside said outer wall, a cuff piece of knitted material folded about a transverse axis intermediate its length, the end edges of said cuff piece being connected by seams to the lower edges of said outer and lining walls respectively to form a seamless double walled knitted cuff, the raw edges of said last-named connecting seams being disposed between said outer and lining walls and the walls of said cuff, said limb portion having a closure opening extending throughout the length of said cuff and into seams connecting said limb panels and lining panels respectively and a slide fastener in said closure opening substantially coextensive therewith and having its stringer tapes disposed between the walls of said cuff, and between said outer wall and said lining, and a row of top stitching surrounding said closure opening and extending through said walls and said stringer tapes for securing said slide fastener in said closure opening.

5. In a method of forming a lined garment limb covering portion with a knitted cuff having a slide-fastened closure extending throughout and beyond the knitted cuff; securing the composite panels of the outer and lining walls of a limb covering garment portion together and to a cuff-forming cuff piece by seams applied at the wrong side of said panels and said cuff piece and with the raw edges of the seams extending on the wrong side of the panels and cuff piece, while maintaining a slide fastener receiving opening in one side seam of the limb covering garment portion above said cuff and at each side of said cuff piece, folding the formed limb covering garment portion intermediate the cuff edges with the wrong side out and the raw edges of the seams at the outside, sandwiching in the fastener stringer tapes between plies of said folded garment portion adjacent said fastener-receiving opening, and stitching said fastener stringer tapes to overlying portions of said garment adjacent said opening by top stitching extending throughout the length of said closure opening at each side and across the end thereof.

6. In a method of forming a lined garment limb covering portion with a knitted cuff having a slide-fastened closure extending throughout and beyond the knitted cuff; securing the composite panels of the limb covering garment portion and lining portion together by seams having their raw edges extending on the wrong side of the respective composite panels, while maintaining an opening in one side of the limb covering garment and lining portions, connecting the lower edges of the connected panels of the limb covering garment portion and lining portion with opposite edges of a cuff piece by seams applied at the wrong sides of said panels and cuff piece and with the raw edges at the wrong side of the respective panels, folding the garment portion intermediate the edges of said cuff piece to superpose said garment and lining portions, sandwiching in one stringer tape of a slide fastener between superposed free edges of said garment portion and lining portion respectively and between adjacent superposed edge portions of said folded cuff piece, pulling the remaining free edges of said garment portion, lining portion and cuff portion over the free stringer tape to place said last-named stringer tape in sandwiched relation therebetween, and stitching said last-named stringer tape in said relation.

7. In a method of forming a lined garment limb covering portion with a knitted cuff having a slide-fastened closure extending throughout and beyond the knitted cuff; securing the composite panels of the limb covering garment portion and lining portions together by seams having their raw edges extending on the wrong side of the respective composite panels, while maintaining an opening in one side of the limb covering garment and lining portions, connecting the lower edges of the connected panels of the limb covering garment portion and lining portion with opposite edges of a cuff piece by seams applied at the wrong sides of said panels and cuff piece and with the raw edges at the wrong side of the respective panels and cuff piece, folding the garment portion intermediate the edges of said cuff piece with the wrong side out and the seam raw edges exposed to superpose said garment and lining portions, sandwiching in one stringer tape of a slide fastener between superposed free edges of said garment portion and lining portion respectively and between adjacent superposed edge portions of said folded cuff piece, pulling over the free stringer tape the remaining free edges of said garment portion, lining portion and cuff portion to place the said stringer tape in sandwiched relation therebetween, stitching said last-named stringer tape in said relation, and thereafter stitching together the free edges of said garment portion and lining portion beyond said fastener to close said garment portion and said lining portion.

8. In a method of forming a lined garment limb covering portion with a knitted cuff having a

slide-fastened closure extending throughout and beyond the knitted cuff; securing the composite panels of the limb covering garment portion and lining portion together by seams having their raw edges extending on the wrong side of the respective composite panels, while maintaining an opening in one side of the limb covering garment and lining portions, connecting the lower edges of the connected panels of the limb covering garment portion and lining portion with opposite edges of a cuff piece by seams applied at the wrong sides of said panels and cuff piece and with the raw edges at the wrong side of the respective panels and cuff piece, folding the garment portion intermediate the edges of said cuff piece with the wrong side out and the seam raw edges exposed to superpose said garment and lining portions, sandwiching in one stringer tape of a slide fastener between plies of superposed free edges of said garment portion and lining portion respectively and between adjacent superposed edge portions of said folded cuff piece, pulling over the free stringer tape the remaining free edges of said garment portion, lining portion and cuff portion to place the said stringer tape in sandwiched relation therebetween, stitching said last-named stringer tape in said relation, stitching together the free edges of said garment portion and lining portion beyond said fastener to close said garment portion and said lining portion, and anchoring the stringer tape end portions to adjacent overlying seam raw edges by a line of transverse stitching.

9. In a method of forming a lined garment limb covering portion with a knitted cuff having a slide-fastened closure extending throughout and beyond the knitted cuff; securing the composite panels of the limb covering garment portion and lining portion together by seams having their raw edges extending on the wrong side of the respective composite panels, while maintaining an opening in one side of the limb covering garment and lining portions, connecting the lower edges of the connected panels of the limb covering garment portion and lining portion with opposite edges of a cuff piece by seams applied at the wrong sides of said panels and cuff piece and with the raw edges at the wrong side of the respective panels and cuff piece, folding the garment portion intermediate the edges of said cuff piece with the wrong side out and the seam raw edges exposed to superpose said garment and lining portions, sandwiching in one stringer tape of a slide fastener between plies of superposed free edges of said garment portion and lining portion respectively and between adjacent superposed edge portions of said folded cuff piece, pulling over the free stringer tape the remaining free edges of said garment portion, lining portion and cuff portion to place the said stringer tape in sandwiched relation therebetween, stitching said last-named stringer tape in said relation, stitching together the free edges of said garment portion and lining portion beyond said fastener to close said garment portion and said lining portion, anchoring the stringer tape end portions to adjacent overlying seam raw edges, and thereafter telescoping said lining portion into said garment portion with the right side of said garment portion extending outwardly and the right side of said lining portion extending inwardly.

10. In a method of forming a lined garment limb covering portion with a knitted cuff having a slide-fastened closure extending throughout and beyond the knitted cuff; securing the composite panels of the limb covering garment portion and lining portion together by seams having their raw edges extending on the wrong side of the respective composite panels, while maintaining an opening in one side of the limb covering garment and lining portions, connecting the lower edges of the connected panels of the limb covering garment portion and lining portion with opposite edges of a cuff piece by seams applied at the wrong sides of said panels and cuff piece and with the raw edges at the wrong side of the respective panels and cuff piece, folding the garment portion intermediate the edges of said cuff piece with the wrong side out and the seam raw edges exposed to superpose said garment and lining portions, sandwiching in one stringer tape of a slide fastener between plies of superposed free edges of said garment portion and lining portion respectively and between adjacent superposed edge portions of said folded cuff piece, pulling over the free stringer tape the remaining free edges of said garment portion, lining portion and cuff portion to place the said stringer tape in sandwiched relation therebetween, stitching said last-named stringer tape in said relation, stitching together the free edges of said garment portion and lining portion beyond said fastener to close said garment portion and said lining portion, anchoring the stringer tape end portions to adjacent overlying seam raw edges, telescoping said lining portion into said garment portion with the right side of said garment portion extending outwardly and the right side of said lining portion extending inwardly, and applying a line of top stitching around the edges of said closure opening to finish said closure.

11. In a method of attaching a slide fastener in the closure opening of a lined garment, separately stitching the fastener stringer tapes between the plies of the garment at each side of the closure opening while leaving the tape ends free, cutting on a bias the raw edges of the seams formed by said stitching to form manipulative tabs, manually pulling out the free tape ends and manipulative tabs to secure snug alignment of the stringer tapes and garment plies adjacent the end of the closure opening, and applying a transverse line of stitching through said free tape ends and the superposed garment plies to anchor said stringer tapes in said closure opening.

12. In a method of attaching a slide fastener in the closure opening of a lined garment, separately stitching the fastener stringer tapes between the plies of the garment at each side of the closure opening while leaving the tape ends free beyond the bottom stop, cutting on a bias the raw edges of the seams formed by said stitching to form manipulative tabs, manually pulling out the free tape ends and manipulative tabs to secure snug alignment of the stringer tapes and garment plies adjacent the end of the closure opening, applying a transverse line of stitching at the wrong side of the plies through said free tape ends and the superposed garment plies adjacent and beyond the bottom stop to anchor the tapes at the end of the closure opening, turning the garment right side out, and applying a row of top stitching through said plies and through said fastener stringer tapes to finish the closure construction.

CARL S. FOWLER.