A garment having an integrated shaping component, or a built-in shaper element. Long pants or long trousers comprise: a lower region formed of denim or jeans; and an upper region formed of a combination of denim with elastic fabric. The elastic fabric, or elastane or polyester, is (a) interweaved with the denim at the upper region; or is (b) glued with heating-and-pressing to an internal side of a denim layer; or is (c) glued with heating-and-pressing to be sandwiched between two layers of denim. The long pants having integrated shaper or form-fitting element, enable to shape and slim the hips area or the waist area or the belly area of the wearer, in a concealed manner.
GARMENT AND LONG PANTS WITH INTEGRATED SHAPER

FIELD OF THE INVENTION

[0001] The present invention relates to the field of articles of clothing.

BACKGROUND

[0002] Pants or trousers are an item of clothing that is typically worn from the waist downwardly towards the ankles, covering each leg separately. Such items are sometimes called “long pants” or “long trousers”, to distinguish them from tailored shorts which are sometimes called “short pants” or “short trousers”.

[0003] Pants or trousers may be manufactured from a suitable material, for example, cotton or wool. Some pants may be formed of denim, and are typically known as “jeans”.

SUMMARY

[0004] The present invention may include, for example, an article of clothing having an integrated “built-in” shaper or body-shaping element, as well as methods and systems for manufacturing, producing and/or preparing such article of clothing.

[0005] The article of clothing may be or may comprise, for example, pants, trousers, long pants, long trousers, short pants, short trousers, a skirt, a dress, a robe, sportswear, sport pants, or the like.

[0006] The present invention may comprise, for example, jeans or denim pants, which may comprise an integrated or built-in shaper or shaping component, which maybe interwoven with or within such jeans pants or denim pants.

[0007] The present invention may provide other and/or additional benefits or advantages.

BRIEF DESCRIPTION OF THE DRAWINGS

[0008] For simplicity and clarity of illustration, elements shown in the figures have not necessarily been drawn to scale. For example, the dimensions of some of the elements may be exaggerated relative to other elements for clarity of presentation. Furthermore, reference numerals may be repeated among the figures to indicate corresponding or analogous elements. The figures are listed below.

[0009] FIG. 1 is a front view of a combined pants-shaper article of clothing, in accordance with some demonstrative embodiments of the present invention;

[0010] FIG. 2 is a back view of the combined pants-shaper article of clothing, in accordance with some demonstrative embodiments of the present invention;

[0011] FIG. 3 is a left side view of the combined pants-shaper article of clothing, in accordance with some demonstrative embodiments of the present invention;

[0012] FIG. 4 is a right side view of the combined pants-shaper article of clothing, in accordance with some demonstrative embodiments of the present invention;

[0013] FIG. 5 is a perspective front-left view of the combined pants-shaper article of clothing, in accordance with some demonstrative embodiments of the present invention;

[0014] FIG. 6 is a perspective front-right view of the combined pants-shaper article of clothing, in accordance with some demonstrative embodiments of the present invention;

[0015] FIG. 7 is a perspective back-right view of the combined pants-shaper article of clothing, in accordance with some demonstrative embodiments of the present invention;

[0016] FIG. 8 is a perspective back-left view of the combined pants-shaper article of clothing, in accordance with some demonstrative embodiments of the present invention; and

[0017] FIG. 9 is a front view of the combined pants-shaper article of clothing and its components and regions, in accordance with some demonstrative embodiments of the present invention.

DETAILED DESCRIPTION OF THE INVENTION

[0018] In the following detailed description, numerous specific details are set forth in order to provide a thorough understanding of some embodiments. However, it will be understood by persons of ordinary skill in the art that some embodiments may be practiced without these specific details. In other instances, well-known methods, procedures, components, units and/or circuits have not been described in detail so as not to obscure the discussion.

[0019] The Applicants have realized that it may not be comfortable for some users, to wear a separate shaper or body-shaping article of clothing, underneath pants or particularly underneath jeans pants or denim pants.

[0020] The Applicants have realized that a user may feel uncomfortable or inconvenient, to wear a separate shaper or body-shaping article of clothing, underneath pants or particularly underneath jeans pants or denim pants. The Applicants have realized that when a person is wearing a separate shaper or body-shaping article of clothing, underneath the person’s pants, or particularly underneath the person’s jeans pants or denim pants, such shaper or body-shaping article of clothing may be apparent or may show through the pants or particularly through jeans pants or denim pants. The Applicants have realized that it may be beneficial to develop a shaper which may be combined or integrated or otherwise “built in” within a garment, particularly within pants or long pants or jeans pants or denim pants; such that the integrated shaper (e.g., its presence, its contour, its thickness) may remain unseen by observers, or may be concealed by observers.

[0021] The Applicants have realized that an attempt to wear a separate shaper or body-shaping article of clothing, underneath pants or particularly underneath jeans pants or denim pants, may cause the user to feel hot or excessively hot; may cause the user to sweat or to excessively sweat; and may cause the user to have an undesired “larger” or “fatter” look.

[0022] The Applicants have realized that an attempt to wear a separate shaper or body-shaping article of clothing, underneath pants or particularly underneath jeans pants or denim pants, may cause the shaper to lose its effectivity; and instead of providing to the user a body-fitting appearance or a “skinny” or “skinnier” appearance, the wearing of two (or more) layers over the hips or waist or legs may actually cause the user to appear “fatter” or “larger”, thereby achieving the opposite result relative to the original intent that caused the user to wear a shaper.

[0023] The present invention may comprise, for example, a garment having an integrated shaping component, or a built-in shaper element. For example, long pants or long trousers or jeans pants or denim pants, may comprise: a lower region formed of denim or jeans; and an upper region formed of a combination of denim with elastic fabric. The elastic fabric, or elastane or elasthane or stretch-cotton or polyester or...
stretch-fabric, may be: (a) interwoven with the denim at the upper region; and/or (b) glued with heating-and-pressing to an internal side of a denim layer; and/or (c) glued with heating-and-pressing to be sandwiched between two layers of denim. The long pants having integrated shaper or form-fitting element may enable to shape and slim the hips area or the waist area or the belly area of the wearer.

Reference is made to FIGS. 1-8, which are schematic illustrations of various views of a combined pants-shaper 100, in accordance with some demonstrative embodiments of the present invention; and to FIG. 9 which demonstrates in greater detail some components and elements of such combined pants-shaper 100.

Combined pants-shaper 100 may comprise, for example, a lower region 101; an upper region 102; a waist/belt region 103; and an opening-closing region 104.

The opening-closing region 104 may be located at the front side of the combined pants-shaper 100, as depicted; or alternatively, may be located at the back side of the combined pants-shaper 100; or on the right-side, or on the left side, of the combined pants-shaper 100. The opening-closing region 104 may comprise one or more open/close mechanisms, for example, a button and a respective hole; a set or series of buttons (e.g., arranged vertically, or arrange horizontally); a hook and eye mechanism; a zipper; a Velcro mechanism; or the like. The opening-closing region 104 may be formed of denim or dungaree or jeans material. The opening-closing region 104 may be non-body-fitting, and/or may be non-form-fitting, and/or may exclude any shaper component or any body-shaping components or materials.

The lower region 101 may extend, for example, from approximately the knee area downwards towards the ankle area. The lower region 101 may be formed of denim or dungaree or jeans material. The lower region 101 may be non-body-fitting, and/or may be non-form-fitting, and/or may exclude any shaper component or any body-shaping components or materials.

The waist/belt region 103 may encircle the user’s waists or hips or belly; or may comprise a belt-area component or region (e.g., bagel-shaped, donut-shaped, circular, oval, or the like). The waist/belt region 103 may be formed of denim or dungaree or jeans material. The waist/belt region 103 may be non-body-fitting, and/or may be non-form-fitting, and/or may exclude any shaper component or any body-shaping components or materials.

In contrast to other regions, the upper region 102 may be formed of denim or dungaree or jeans materials that may be interwoven with or interwoven with or entangled with: elastic or highly-elastic or partially-elastic fabric(s), for example, elastane, Spandex, Lycra, or other suitable elastic synthetic fiber, or other suitable polyester-polyurethane copolymer. Additionally or alternatively, the upper region 102 may have an elastic interlining layer, which may be glued (with heat-pressing) to an internal layer of the denim; or which may be glued (with heat-pressing) and sandwiched or trapped between two layers of denim.

In some embodiments, for example, the upper region 102 may comprise denim interwoven with elastane, or denim glued (at its internal side) to elastane. The denim may comprise a sturdy cotton warp-faced twill textile in which the weft passes under two or more warp threads; such twill weaving producing diagonal ribbing of the denim that distinguishes it from cotton duck. The elastane may be interwoven with the denim; or may be glued or bonded or otherwise attached or coupled to the denim, on the interior side of the denim.

In some embodiments, optionally, only the warp threads of the denim are dyed, whereas the weft threads of the denim may remain white. Due to the warp-faced twill weaving, one side of the textile may show the blue warp threads; and the other side of the textile may show the white weft threads. For example, an indigo dyeing process, in which the core of the warp threads remain white, may create denim’s fading characteristics, which are unique compared to other textiles. The elastane, or other body-shaping or form-fitting elastic fabric or fiber, may be intertwined or interwoven with the denim (e.g., on the internal side of the denim), or may be glued or bonded or otherwise attached (e.g., internally) to the denim.

In some embodiments, for example, the upper region 102 may comprise “blue denim” or dungaree fabric intertwined with elastane, or dungaree fabric glued (at its internal side) to elastane. For example, the dungaree fabric may comprise a coarse thick 2/2 twill-weave cotton cloth.

Optionally, upper region 102 may comprise one or more pockets 105, which may be external, or internal, or partially external and partially internal. Optionally, each pocket 105 may be formed of the same material(s) that upper region 102 is formed of (for example, denim intertwined with elastane), or may be formed of other suitable material(s) (for example, only denim).

Optionally, a shaper element 106 or shaper component or body-shaping component or body-slimming component, may be glued or bonded or otherwise attached to the internal side of the cloth or denim or fabric that forms the upper region 102. For example, a glue or adhesive may be spread or applied, to the entire surface of the shaper element 106 (or to the entire surface of the corresponding area of upper region 102), to allow gluing or bonding or heat-bonding or heat-gluing of the shaper element to the upper region 102.

In some embodiments, the shaper element 106 may be implemented as an interlining layer or an intermediate layer in an elastane layer or a form-fitting material layer, which may be “sandwiched” or surrounded or trapped within two layers of denim or two layers of fabric. For example, the interlining layer may be bonded to the cloth or denim layer(s) by applying glue and/or heat and/or pressure, for example, pressure of approximately 2 or 2.5 or 3 kilograms, over time period of 15 or 20 or 30 seconds, at a temperature in the range of 135 to 140 (or in the range of 120 to 150 degrees Celsius). Optionally, polyurethane adhesive (PA) glue or other suitable glue(s) may be used; for example, a water-resistant glue, a glue having low viscosity level, a glue that cures rapidly (e.g., within 30 seconds). Although other suitable values or ranges may be used, the Applicants have realized that the above parameters may provide improved results, since these values or ranges may reduce or eliminate the formation of “air bubbles” within the fabric or on the fabric or under the fabric, and may contribute to formation of a smooth fabric that does not suffer from bubbles or protrusions. Optionally, in order to bond the interlining, the PA or glue may be applied on the shell fabric or the shell layer or outer layer; or may be applied to the mid layer or insulating layer; or may be applied to the inner layer or base layer; or may be applied to two or more of the layers.

In some embodiments, the upper region 102, or the entire combined pants-shaper 100, may be formed of the
following materials at the following relative ratios: 68 percent cotton, 27 percent polyester, and 5 percent elastane. In some embodiments, the cotton may be between 65 to 71 percent; the polyester may be between 25 to 29 (or between 26 to 30) percent; the elastane may be between 3 to 7 (or between 2 to 8) percent. Other suitable values or ratios may be used. In some embodiments, the interlining of the shaper element 106 may be formed of polyester (e.g., 100 percent polyester, or at least 97 percent polyester). In some embodiments, tolerance of plus-or-minus 5 percent may be used, with regard to the above-mentioned demonstrative values or ranges.

[0037] It would be appreciated that the above values are non-obvious values that the Applicants have realized, after extensive and complex experimentation, to enable improved and enhanced properties of the final garment, including for example, properties such as: smooth and flat appearance; reduction or elimination of air bubbles or any other “bubble” appearance or protrusions; a slimming effect in the desired regions; a natural appearance of the garment; a seam-less appearance at the edge or border of transition between regions of the garment; and/or other advantageous properties. Accordingly, these particular values and/or ranges and/or tolerances may be used to achieve enhanced garment properties.

[0038] In some embodiments, the shaper element 106 may be glued or bonded to a pre-defined surface(s) or area(s) or region(s) of the combined pants-shaper 108. For example, the shaper element 106 or the elastic interlining may be bonded or glued from approximately under the waist, downwardly towards the upper knees; in order to enable a hip lifting effect and/or a slimming effect on the wearer.

[0039] In some embodiments, the shaper element 106 may be formed of elastic material(s) or of elastane; and the fabric from which the upper region 102 is formed may include elastic material(s) or elastane. The denim fabric and the elastane interlining may be glued together in a bubble-free manner, such that the bonded formation may be generally smooth and protrusion-free.

[0040] Applicants have realized that the shaper element 106 may have a curved or multi-curved or wave-shaped or sine-wave-shaped structure or shape of contour or finishing or ending or edge, in order to reduce or eliminate the formation of bubbles or air bubbles or protrusions or non-smooth portions, or in order to create a seam-less or seam-free connection between the layers. For example, instead of having a generally-linear or generally-straight ending, or a simple single-curve ending, the shaper element 106 may have a curved or multiple-waves shaped ending or contour, demonstrated as curved wave-shaped border 107; and Applicants have realized that such particular structure of the contour or edge may reduce or eliminate the creation of seams, and may provide a seam-less appearance or seam-free appearance. In contrast, an attempt to utilize a non-wavy contour of the interlining, may cause a non-desired seam-line or protrusion line to appear, at the edge or the ending of the interlining.

[0041] It would be appreciated that the particular curved or wave-shaped border 107 is not intended merely for ornamental goals or for decorative purposes; but rather, Applicants have realized, after numerous experiments and sophisticated experimentation, that particularly structuring the border 107 as curved wave-shaped border may provide enhanced or improved structural properties and functional properties to the garment; and particularly, such particular border 107 may reduce or eliminate the formation of air bubbles, may contribute to formation of a smooth and flat texture of the textile, may contribute to a seam-less appearance and/or seam-less feeling by the wearer of the garment, and may eliminate an uncomfortable (and sometimes itching or bothering) seam or straight-seam at the border region.

[0042] Although portions of the discussion herein may relate, for demonstrative purposes, to a shaper element 106 which is intertwined in a upper region 102 of the garment, it is clarified that such (or similar) shaper element 106 may be located or positioned or intertwined in other suitable region (s) or area(s) of the garment, which may not necessarily be central or upper relative to the garment; for example, at a top or upper region of the garment, or at a low or bottom region of the garment, or at a central region of the garment, or the like.

[0043] In some embodiments, the shaper element 106 may encircle the entire circumference of the body organ that it is intended to shape or form-fit. In other embodiments, the shaper element 106 may only partially encircle such body organ or body part; for example, the shaper element 106 may be implemented only around or near the front-side of the garment, or may be implemented only at or near the back-side (or rear-side) of the garment, or the like; for example, in order to achieve a particular slimming effect for a particular body part or body organ, while retaining other body part(s) non-slinned or maintaining their regular appearance.

[0044] Although portions of the discussion herein may relate, for demonstrative purposes, to long pants having an integrated shaper element, the present invention may comprise other types of garments or articles-of-clothing which may have shaper element(s) integrated therein, at one or more suitable locations or positions. Such integrated garments may include, for example, a skirt, a dress, a robe, a shirt, sports-wear, or the like.

[0045] In some embodiments, a method of manufacturing or producing or preparing a garment, may comprise some or all of the following steps: (A) interweaving denim with elastane; (B) knitting or producing a first region of a garment (e.g., intended for covering the hips and/or the lower waists; and/or an upper area of long pants reaching downwardly until the knees) with the interweaved denim-and-elastane; (C) knitting or producing a second region of the garment (e.g., intended for covering the legs from the knees down towards the ankles) with denim (e.g., and without interweaved elastane); (D) creating a curly or wave-shaped edge or border of the first region.

[0046] In some embodiments, a method of manufacturing or producing or preparing a garment, may comprise some or all of the following steps: (A) gluing or bonding an elastic interlining layer (e.g., made of elastane or polyester) to an internal side of a denim layer, at only a top region of the garment (e.g., intended for covering the hips and/or the lower waists; and/or an upper area of long pants reaching downwardly until the knees); and (B) creating a curly or wave-shaped edge or border of said glued region, to reduce air bubbles and/or to create a seam-less appearance at the border of the glued interlining and the denim which extends downwardly below said glued region.

[0047] In some embodiments, a method of manufacturing or producing or preparing a garment, may comprise some or all of the following steps: (A) gluing or bonding an elastic interlining layer (e.g., made of elastane or polyester) between two layers of denim, at only a top region of the garment (e.g., intended for covering the hips and/or the lower waists; and/or an upper area of long pants reaching downwardly until the
knees); and (B) creating a curly or wave-shaped edge or border of said glued region, to reduce air bubbles and/or to create a seam-less appearance at the border of the glued interfining and the denim which extends downwardly below said glued region.

[0048] In some embodiments, a system for manufacturing a garment may comprise one or more of the following components: (1) a shaper element production module, able to produce a shaper element from an elastic fabric and/or from elastane and/or from interweaving of denim with elastane and/or from interweaving of denim with elastic fabric; (2) an interweaving module to optionally interweave denim with elastic fabric and/or with elastane; (3) a gluing module or bonding module, to apply or spread glue (e.g., PA glue) to a pre-defined area of a garment being prepared; (4) a pressing and heating module, to press the bonded layers while heating the bonding area; (5) a curly-border or wave-shaped border production module, able to pre-produce an elastic interfining fabric component (or layer) which ends with a curly or wave-shaped border at its bottom part, to enable smooth and seamless connection or transition between portions of the garment; (6) an inner layer attachment module, able to glue an elastic interfining layer to only a portion of an internal side of a denim layer of the garment; (7) an intermediate layer attachment module, able to glue an elastic interfining layer to only a portion of a garment at a location between two denim layers of that garment, e.g., as an elastic interfining layer “sandwiched” between two denim layers.

[0049] In some embodiments, the production system may further include hardware components and/or software components, for example, processor, processing unit, memory unit, storage unit, workstation, input unit (mouse, keyboard, touch-screen), output unit (screen, touch-screen), logic circuits, program code or instruction, controllers, robotic arms, conveyor belts, knitting machines, knitting modules, cutting machines, cutting modules, coloring machines or modules (able to add or remove color to fabric), and/or other suitable components in order to automate some or all of the production operations.

[0050] Some embodiments of the present invention may comprise a garment comprising: long pants (or long trousers) formed of denim, wherein the long pants comprise: a first region of the long pants which covers at least hips of a user, wherein the first region of the long pants is formed of denim combined with an elastic fabric; a second region of the long pants which extends downwardly from the border of first region towards ankles of the user, wherein the second region is formed of denim, wherein the second region is free of elastic fabric; wherein a border between the first region of the long pants and the second region of the long pants is a curly wave-shaped border to enable a seam-less appearance of said border.

[0051] In some embodiments, the first region of the long pants comprises: an elastic interfining layer glued to an internal side of a denim layer.

[0052] In some embodiments, the first region of the long pants comprises: an elastic interfining layer glued and sandwiched between two denim layers.

[0053] In some embodiments, the first region of the long pants comprises: an elastic interfining layer that is interweaved with at least one denim layer.

[0054] In some embodiments, the first region of the long pants comprises: an elastic interfining layer that is formed of 100 percent of polyester.

[0055] In some embodiments, the first region of the long pants comprises: an elastic interfining layer that is formed of at least 97 percent of polyester.

[0056] In some embodiments, the first region of the long pants comprises: an elastic interfining layer that is formed of 100 percent of elastane.

[0057] In some embodiments, the first region of the long pants comprises: an elastic interfining layer that is formed of at least 97 percent of elastane.

[0058] In some embodiments, the first region of the long pants is formed of: 68 percent cotton, and 27 percent polyester, and 5 percent elastane.

[0059] In some embodiments, the first region of the long pants is formed of: 68 percent cotton, and 27 percent polyester, and 5 percent elastane; with tolerance of plus-or-minus 3 percent for each of said materials.

[0060] In some embodiments, the garment may further comprise: a third region of the long pants, that is formed of denim and excludes elastic fabric, and which is connected upwardly relative to the first region of the long pants, and which encircle the waists of the wearer.

[0061] In some embodiments, a method of manufacturing a garment may comprise: producing long pants formed of denim, wherein the producing comprises: (a) producing a first region of the long pants which covers at least hips of a user, wherein the first region of the long pants is formed of denim combined with an elastic fabric; (b) producing a second region of the long pants which extends downwardly from the border of first region towards ankles of the user, wherein the second region is formed of denim, wherein the second region is free of elastic fabric; wherein the producing of step (a) further comprises producing a border between the first region of the long pants and the second region of the long pants is a curly wave-shaped border to enable a seam-less appearance of said border.

[0062] In accordance with some embodiments of the present invention, the method may comprise: (A) interweaving denim with elastane; (B) producing a first region of a garment, intended for covering the hips, with the interweaved denim-and-elastane; (C) producing a second region of the garment, intended for covering the legs from the knees down towards the ankles, with denim and without interweaved elastane; (D) creating a curly wave-shaped border of the first region.

[0063] In some embodiments, the method may comprise: (A) gluing an elastic interfining layer to an internal side of a denim layer, at only a top region of the garment that is intended for covering the hips of the wearer; (B) creating a curly wave-shaped border of said glued region, to create a seam-less appearance at the border of the glued interfining and the denim which extends downwardly below said glued region.

[0064] In accordance with some embodiments of the present invention, the method may comprise: (A) gluing an elastic interfining layer to be glued and sandwiched between two denim layers, at only a top region of the garment that is intended for covering the hips of the wearer; (B) creating a curly wave-shaped border of said glued region, to create a seam-less appearance at the border of the glued interfining and the denim which extends downwardly below said glued region.

[0065] Functions, operations, components and/or features described herein with reference to one or more embodiments, may be combined with, or may be utilized in combination
with, one or more other functions, operations, components and/or features described herein with reference to one or more other embodiments, or vice versa.

While certain features of some embodiments have been illustrated and described herein, many modifications, substitutions, changes, and equivalents may occur to those skilled in the art. Accordingly, the claims are intended to cover all such modifications, substitutions, changes, and equivalents.

What is claimed is:

1. A garment comprising:
   long pants formed of denim, wherein the long pants comprise:
   a first region of the long pants which covers at least hips of a user, wherein the first region of the long pants is formed of denim combined with an elastic fabric;
   a second region of the long pants which extends downwardly from the border of first region towards ankles of the user, wherein the second region is formed of denim, wherein the second region is free of elastic fabric;
   wherein a border between the first region of the long pants and the second region of the long pants is a curly wave-shaped border to enable a seam-less appearance of said border.

2. The garment of claim 1, wherein the first region of the long pants comprises:
   an elastic interlining layer glued to an internal side of a denim layer.

3. The garment of claim 1, wherein the first region of the long pants comprises:
   an elastic interlining layer glued and sandwiched between two denim layers.

4. The garment of claim 1, wherein the first region of the long pants comprises:
   an elastic interlining layer that is interwoven with at least one denim layer.

5. The garment of claim 1, wherein the first region of the long pants comprises:
   an elastic interlining layer that is formed of 100 percent of polyester.

6. The garment of claim 1, wherein the first region of the long pants comprises:
   an elastic interlining layer that is formed of at least 97 percent of polyester.

7. The garment of claim 1, wherein the first region of the long pants comprises:
   an elastic interlining layer that is formed of 100 percent of elastane.

8. The garment of claim 1, wherein the first region of the long pants comprises:
   an elastic interlining layer that is formed of at least 97 percent of elastane.

9. The garment of claim 1, wherein the first region of the long pants is formed of: 68 percent cotton, and 27 percent polyester, and 5 percent elastane; with tolerance of plus-or-minus 3 percent for each of said materials.

10. The garment of claim 1, further comprising:
    a third region of the long pants, that is formed of denim and excludes elastic fabric, and which is connected upwardly relative to the first region of the long pants, and which encircle the waist of the wearer.

11. The garment of claim 1, further comprising:
    producing long pants formed of denim, wherein the producing comprises:
    (a) producing a first region of the long pants which covers at least hips of a user, wherein the first region of the long pants is formed of denim combined with an elastic fabric;
    (b) producing a second region of the long pants which extends downwardly from the border of first region towards ankles of the user, wherein the second region is formed of denim, wherein the second region is free of elastic fabric;
    wherein the producing of step (a) further comprises producing a border between the first region of the long pants and the second region of the long pants is a curly wave-shaped border to enable a seam-less appearance of said border.

12. A method of manufacturing a garment, the method comprising:

(A) interwoven denim with elastane;

(B) producing a first region of a garment, intended for covering the hips, with the interwoven denim-and-elastane;

(C) producing a second region of the garment, intended for covering the legs from the knees down towards the ankles, with denim and without interwoven elastane;

(D) creating a curly wave-shaped border of the first region.

13. The method of claim 12, comprising:

(A) gluing an elastic interlining layer to an internal side of a denim layer, at only a top region of the garment that is intended for covering the hips of the wearer;

(B) creating a curly wave-shaped border of said glued region, to create a seam-less appearance at the border of the glued interlining and the denim which extends downwardly below said glued region.

14. The method of claim 12, comprising:

(A) gluing an elastic interlining layer to be glued and sandwiched between two denim layers, at only a top region of the garment that is intended for covering the hips of the wearer;

(B) creating a curly wave-shaped border of said glued region, to create a seam-less appearance at the border of the glued interlining and the denim which extends downwardly below said glued region.

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