Jan. 6, 1942. A. O. HANISCH ET AL 2,269,088

HOSIERY

Filed Nov. 14, 1939 3 Sheets-Sheet 1

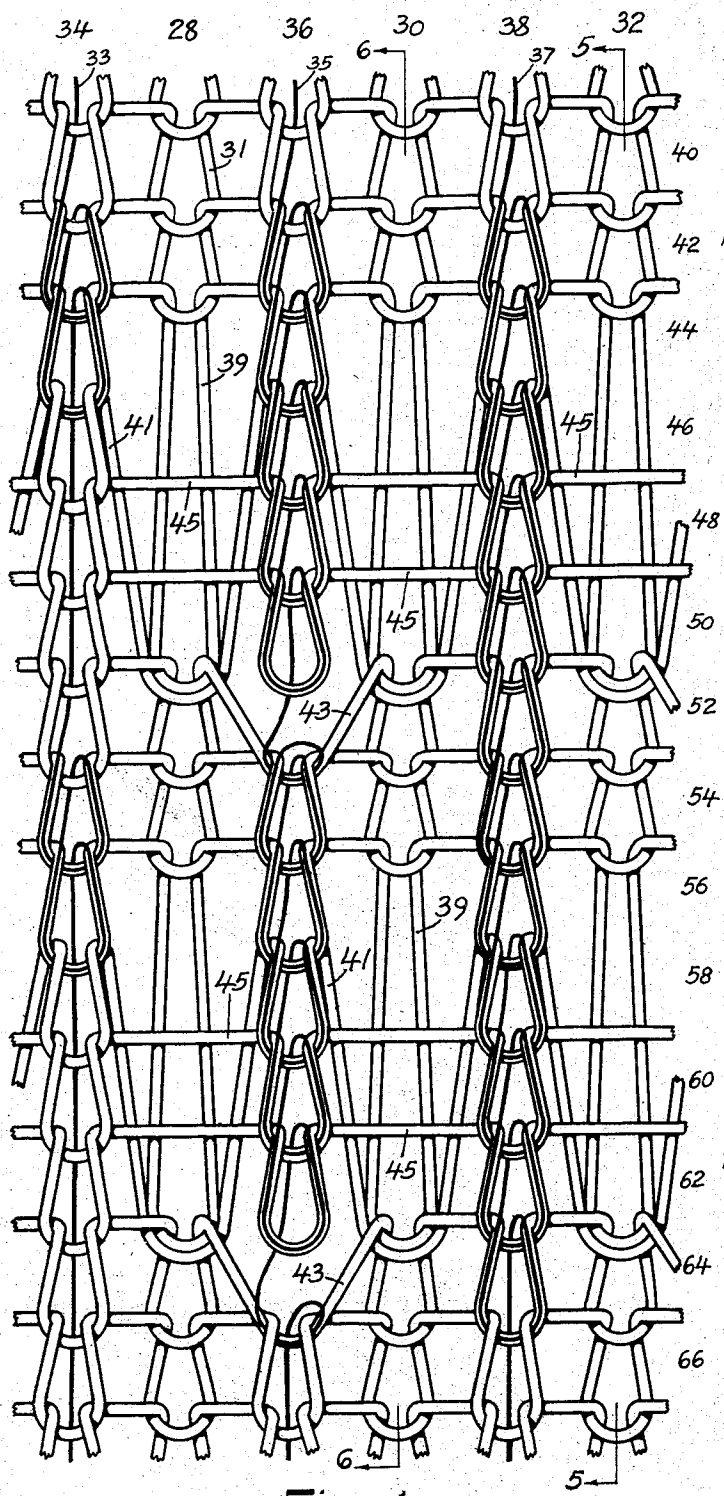


Fig. 4.

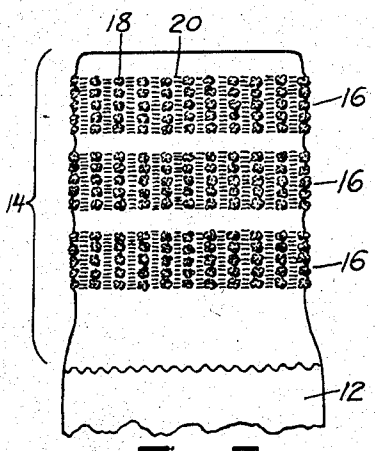


Fig. 2.

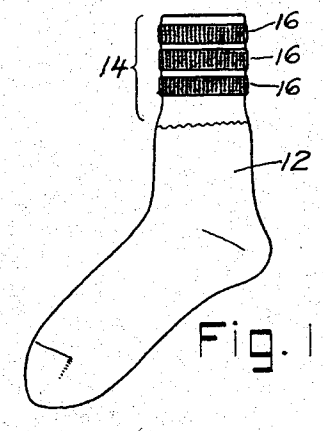


Fig. 1.

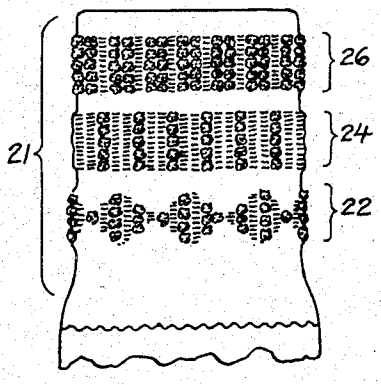


Fig. 3.

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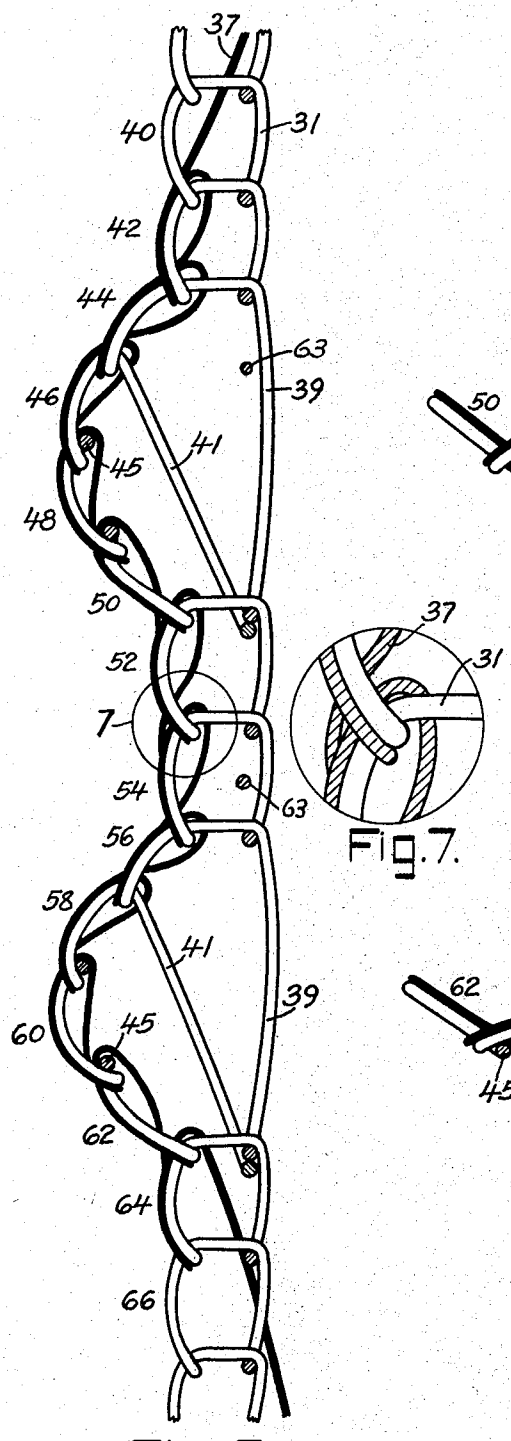


Fig. 5.

Fig. 7.

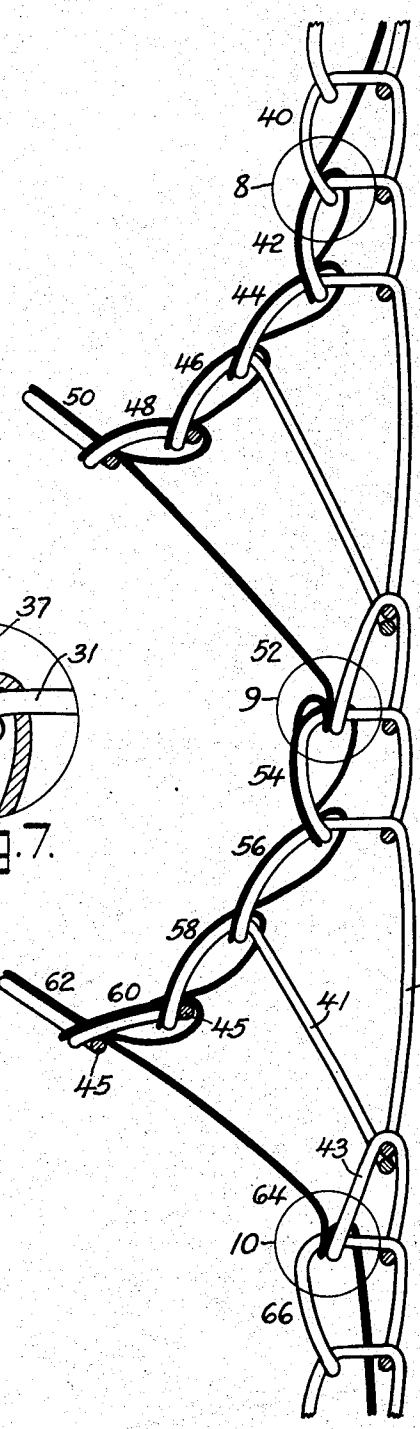


Fig. 6.

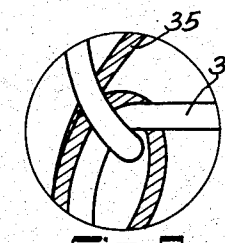


Fig. 8.

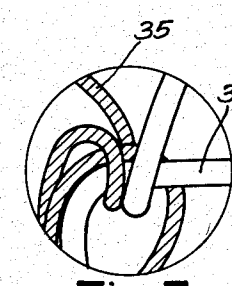


Fig. 9.

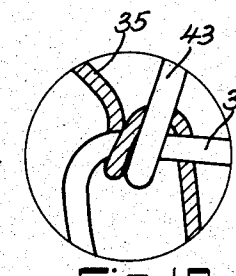


Fig. 10.

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Filed Nov. 14, 1939 3 Sheets-Sheet 3

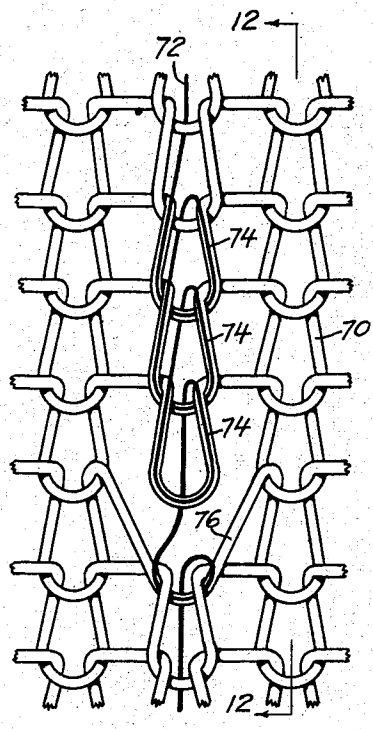


Fig. 11.

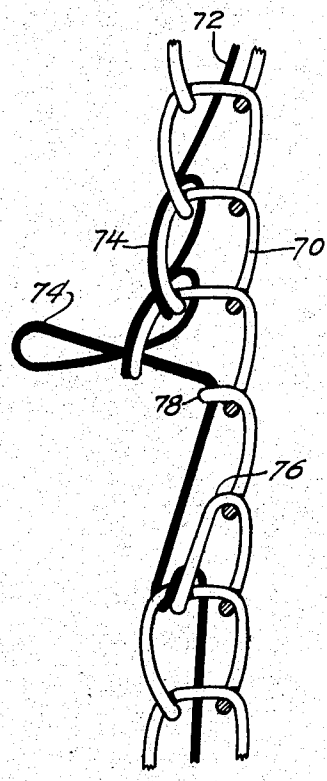


Fig. 12.

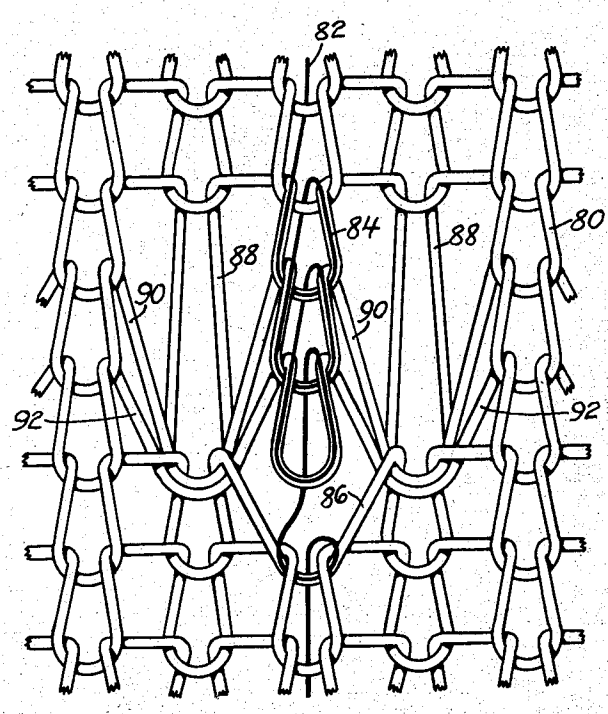


Fig. 13.

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Patented Jan. 6, 1942 2,269,088

UNITED STATES PATENT OFFICE

2,269,088

HOSIERY

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Application November 14, 1939, Serial No. 304,314

25 Claims. (Cl. 66—172)

This invention relates to a novel fabric and the method of making the same and to hosiery embodying the novel fabric as a part thereof. It is an object of this invention to provide a novel fabric on which there are raised stitches to create an ornamental effect.

In the drawings:

Figure 1 is a general view of a stocking embodying the invention,

Figure 2 is an enlarged view of the stocking top of Figure 1,

Figure 3 is an enlarged view of a stocking top showing a modification in the design,

Figure 4 is a view showing in detail a stitch arrangement for one form of the novel fabric,

Figure 5 is a view on line 5—5 of Figure 4 looking in the direction of the arrows,

Figure 6 is a view on line 6—6 of Figure 4 looking in the direction of the arrows,

Figure 7 is an enlarged detail view of the area enclosed in the circle 7 of Figure 5,

Figure 8 is an enlarged detail view of the area enclosed in the circle 8 of Figure 6,

Figure 9 is an enlarged detail view of the area enclosed in the circle 9 of Figure 6,

Figure 10 is an enlarged detail view of the area enclosed in the circle 10 of Figure 6,

Figure 11 is a view showing in detail a stitch arrangement for a second form of the novel fabric,

Figure 12 is a view on line 12—12 of Figure 11 looking in the direction of the arrows and modified and

Figure 13 is a view showing in detail a stitch arrangement for a third form of the novel fabric.

The present invention relates to fabric, either of seamless tubular construction or of flat selvage edge construction, and has for its object to provide a knitted construction by means of which raised stitches can be made to extend from the normal surface of the fabric to create a raised stitch type of ornamentation. The raised stitches are preferably, but not necessarily, knitted with different colored plated wrap yarns so as to vary the visual effect of the raised design.

Generally, the raised design is formed by means of dropped stitches of the wrap yarn, dropped along with the body stitch upon which the wrap yarn stitch was plated, the casting off and dropping action on the needle taking place before the following course of knitting is made. In the following course the then bare needle starts up knitting again. Normally, dropped stitches will run and in this fabric this is effectively lessened and practically nullified by the presence of a wrap yarn stitch in the dropped body stitch, as will be explained, either alone or with a special construction in one or more of the wales adjoining the wale in which the stitch is dropped, the special construction tending to draw the fabric together in a walewise direction for a purpose to be explained. The invention is applicable to plain, as well as rib fabrics.

Iin Figure 1 there is shown a stocking 12 having the top 14 in which there is a raised stitch design in each of the groups of horizontal courses 16. The Figure 2 shows the top 14 enlarged and it will be noted that in each of the groups of horizontal courses 16 that the alternate wales are provided with the raised stitches 18 and the intervening wales have the relatively non-raised stitches 20. It will be noted in Figure 2 that the groups of raised stitches are arranged in horizontal rows or stripes but the designs are not so limited and may extend in various shapes at an angle to the wales as is shown at 22 in the top 21 shown in Figure 3. While in Figure 2 the raised stitches have been shown to be in alternate wales only, as shown in Figure 3 in the section 24, the raised stitches may be in every third wale with the intervening two wales of relatively non-raised stitches. Likewise as shown in the section 26 of Figure 3, the raised stitches may be in two adjacent wales separated from two other like adjacent wales by a single wale of relatively non-raised stitches. The various combinations of the wales in which the raised and non-raised stitches may appear may vary according to the design desired and within certain limits as will be explained in the method of manufacturing the fabric.

The making of this invention as embodied in the rib fabric of Figure 4 is preferably carried out on a machine having cylinder and dial needles and means to wrap individual threads selectively around the cylinder needles in successive courses to make true rib fabric ornamented with wrap threads plated on the selected cylinder needles stitches. The cylinder needles are so arranged that the ones upon which the raised stitches are to be made have longer butts than the remaining needles for a purpose to be described, although obviously any type of needle selecting mechanism could be used. The machine is preferably provided with means to selectively drop only the stitches of the long butt cylinder needles in a desired course in the formation of the raised stitches in addition to the usual means for casting off and dropping the stitches of all of the cylinder needles in the formation of

a regular selvage welt for separating sections of the rib fabric into individual tops. The machine is also preferably equipped with means to selectively make one or more ornamental raised roll welts in each of which a small roll of plain jersey fabric is knitted on the cylinder or plain outside wales for one or more courses with the stitches of the dial or inside rib wales for said one or more courses being held loops as is illustrated in the patent to Longtin No. 2,153,423. Preferably, but not necessarily, the machine is equipped with means to inlay an elastic thread for one or more courses in the rib fabric so as to produce an elastic effect in the fabric due to the presence of the elastic yarn and to thus cause the wales of the fabric to be drawn closer to each other, such a machine attachment is illustrated in Longtin Patent No. 2,120,939 which is also illustrative of the type of true rib wrap machine which may be used to produce the fabric of the present invention.

Referring now to Figure 4, there is shown enlarged a section of rib fabric having the dial wales 28, 30 and 32, the cylinder wales 34, 36 and 38 and the even numbered courses 40 to 66 inclusive, knitted of the body yarn 31 although more than one body yarn may be used if desired as in the case of multiple feed machines. The body yarn 31 itself may be made up of more than one thread as in the case of two or more threads being used as a single body yarn. Individual to the cylinder wales 34, 36 and 38 are the wrap yarns, 33, 35, and 37 respectively which may be of contrasting colors, and if no design is desired in a selected cylinder wale, the wrap yarn for that wale may be omitted entirely without departing from the spirit of the invention.

Knitting proceeds in the usual manner and taking up the process at the course 40, it will be seen that this course is one of rib knitting of the body yarn 31 with all of the wrap yarns floating vertically behind the cylinder wales. In the course 42 there is rib knitting of the body yarn 31 with each of the wrap yarns forming a plated stitch on the body stitches as required by the design chosen. If the design chosen does not require the knitting of the wrap thread at any course of any wale, then instead of being plated as in course 42, the wrap yarn will float in back of the wale. The course 44 is the first course of a pocket welt formation varied as will be explained. In this course, the cylinder needles knit the body yarn and the wrap yarns in plated relation, according to the design, while the dial needles knit the body yarn into the loops 39, these loops 39 are shown elongated in Figure 4 for the reason that they are held on the dial needles for the several courses during which the pocket welt is made and are knitted off the dial needles in the formation of the course 52. The Figures 4, 5 and 6 are diagrammatic representations only of the stitch structure. In the course 46 the cylinder needles knit the body yarn and the wrap yarns in plated relationship, according to the design, while the dial needles, which are now tucked and holding the loops 39 within their hooks, also take the body yarn 31 within their hooks to form the tuck stitches 41, the tuck stitches 41 and the held loops 39 both being retained in the hooks of the dial needles and being cast off together in the formation of course 52. In the formation of course 48, the cylinder needles knit the body yarn and the wrap yarns in plated relationship in wales 36 and 38, according to the design, while the dial needles, which are now in welt position retaining the loops 39 and the tucks 41 within their hooks, do not take the body yarn which floats past the dial wales as at 45. In the formation of course 50 which is the last course of the pocket welt formation, in the first part thereof, the cylinder needles knit the body yarn and the wrap yarns in plated relationship in wales 36 and 38, according to the design, while the dial needles remain in the welt position as in the previous course and the body yarn floats past the dial wales as at 45 between the cylinder wales. Later on in the same course 50, that is, after the formation of the stitches just described and before the knitting feed passes the mentioned wales again to form course 52, a selective cam on the machine passes the said wales and is then in a selective position to raise to cast off position, preparatory to dropping the stitches of only those cylinder needles having long butts passing by the regular butt cylinder needles. Since the cylinder needle forming the wale 36 is the only one shown in Figure 4 with a long butt, the stitch on that needle in wale 36 of course 50 will be dropped as is clearly shown in said Figure 4. The raising of the selected needles to cast off position causes the stitches thereon to be positioned on the needle shanks below the opened latches thereof and these stitches are then dropped by drawing down the selected needles a sufficient distance with an appropriate cam without feeding any yarn so that the stitches are cast off from the needles and are dropped leaving the needles bare. In like manner all around the machine all the long butt cylinder needles will be caused to drop their stitches in the last course of the pocket welt but as has been pointed out these long butt needles are arranged in a selected intercalated relation with the short butt needles so the dropped stitches will be likewise intercalated with the wales in which the stitches are not dropped. In the formation of course 52, the dial needles have been returned to knitting position and both the cylinder and dial needles knit a course of rib fabric, the dial needles casting off both the loop 39 and the tuck 41 and the needle of wale 36 taking the body yarn 31 and forming the tuck 43 thereof, there being no other loop on this needle. The wrap yarn is plated in wale 38 according to the design and in wale 36 the wrap yarn 35 as well as the body yarn is taken by the needle in forming the tuck 43. In the formation of course 54 all of the needles take the yarn and form a course of regular rib knitting, the wrap yarns being plated according to the design and a complete loop being drawn through the tuck 43. From then on in the even numbered courses 56 to 66 there is a repetition of the structure described in the even numbered courses 44 to 54. It will be noted that a complete pocket welt is started upon all of the cylinder needles and that the pocket welt is not completed as to certain intercalated wales (having long butt needles). In the pocket welt structure the dial needles hold a loop and a tuck while the cylinder needles knit and thus these held loops tend to draw the fabric together vertically at those places where the dial needles were so actuated. Normally the dropped cylinder wales would tend to run back but in the present invention this is effectively retarded by the vertical drawing action of the dial wale structures on both sides of a cylinder wale in which the stitches were not dropped and which completed the pocket welt

formation. Furthermore, the run back action is also effectively retarded by the presence of the wrap yarn in plated relation in the dropped stitch and in the stitches of that wale preceding the dropped stitch, the presence of the wrap yarn causing the stitches to be less likely to run. In a run caused by stretching fabric, the pull exerted by the stretching action is only partially transmitted to the wrap threads due to their localized position and their lack of contact with each other, thus a pull which contracts a fabric stitch does not contract a wrap stitch to the same extent and the wrap stitch thus acts as a stop to the run back action of the base fabric stitches and this is true in plain as well as in rib fabrics. The additional safeguard against raveling, that is the vertical pulling action of the welt structure, may be used with the dropped stitches but is not absolutely necessary, although in order to further insure against the possibility of imperfect work, it may be used.

The Figure 5 illustrates diagrammatically how the held loops **39** act to draw the fabric together adjacent a cylinder wale in which the pocket welt has been completed. The Figure 6 illustrates diagrammatically only the position of the dropped loops in the wale **36** the body yarn not being shown ravelled and how they extend outwardly from the face of the fabric to form a raised design.

It has been found that if too many adjacent cylinder needles have long butts and consequently drop their loops at the end of the pocket welt formation, that the area of fabric so affected, may run back due to the lack of an intervening cylinder wale which has not been dropped and so it is desirable to have not over three or four adjacent cylinder needles with long butts. In other words, the raised design should not be made on more than three or four adjacent cylinder wales without including intervening cylinder wales which are not dropped. The selectively movable cam acting on the long butts only may move radially of the needle cylinder under pattern control for single courses so that in its outward position the cam is inoperative and in its inward position the cam operates only the long butt needles or alternatively the cam mechanism may be of a construction wherein the cam moves vertically to engage and raise the long butt needles while not engaging the regular butt needles, in other words, a vertically movable thin cam under pattern control for single courses. If a needle control is used which individually controls each needle in vertical position, then the needles may be of all the same butt length.

The rubber yarn inlay mechanism previously referred to may be used to insert a rubber yarn **63** for one or more courses at one or more places throughout the rib fabric as in the Longtin patent referred to and while the insertion of the rubber is not essential to the stitch structure comprising the raised effect, yet it combines with the rib fabric to give a desirable elastic effect to the rib fabric. In the case of the raised stitch effect, the drawing together of the wales of the rib fabric by means of the rubber yarn tends to accentuate the effect of the raised stitches against the background of rib fabric.

In Figure 11 a rib ground fabric **70** is shown in which the wrap thread **72** has been knitted into three plated stitches **74** in the outside or cylinder wale. The lowermost plated stitch **74** has been dropped and the needle starts knitting again with the loop **76**. The showing of Figure 11 is diagrammatic only and once the fabric is stretched there is the usual tendency for runs to start, such raveling, if any, is not shown in this figure. However, in Figure 12 there is shown what happens when the raveling starts and herein the ground loop of body yarn of the lowermost plated loop **74** has run and is shown at **78**. The plated portion of this loop has not run because there is no stretching action on the wrap threads, as explained previously, and therefore the plated loop extends, as a stop, through the next plated ground loop thus preventing the run from continuing. It will be obvious that such action will be present whether the invention is used in a plain or a rib fabric, for while the outer two wales in Figure 11 are shown as dial wales, they could just as well be cylinder wales so far as the construction of the center wale is concerned. The wrap yarns may be plated upon the cylinder wales at any one or more desired courses and may be dropped at any desired course to provide the raised designs.

The stop action illustrated in Figure 12 wherein a loop of the wrap yarn, from which the loop of the body yarn has raveled, acts as a stop inside the next adjacent plated loop of body and wrap yarn (or of body yarn alone if not plated) is equally applicable to the fabric of Figure 4 or of Figure 13, if the body yarn of the dropped stitches of either of these two modifications should start raveling as they may do under sufficient pulling action on the ground fabric. The Figures 4 and 13 being diagrammatic only do not show the ravelling of the body yarn stitch of the dropped wrap plated stitch.

In Figure 13 a rib ground fabric **80** is shown as having three outside or plain wales and two inside or rib wales with the wrap thread **82** knitted into three plated stitches **84** over the ground fabric stitches in the center plain wale. The lowermost plated stitch **84** has been dropped and knitting commences again in this wale with the loop **86**. In the two dial or rib wales there are tuck stitches formed adjacent the dropped stitch to exert a walewise force in a manner similar to the welt structure of Figure 4. The tuck stitches begin with the held loops **88** and the two rounds of tuck knitting **90** and **92** which are knit off into regular knitting in the same course in which the plated stitch in the intervening plain wale is dropped. The tuck stitches may be of more or less than the two rounds of tuck here shown and need not necessarily be knitted off in the same course in which the plated stitch is dropped. The construction of Figure 13 is equally applicable to plain fabric for in a plain fabric the tuck stitches would be in the plain wales adjacent the wale in which the plated stitch is dropped. In a like manner the modification of Figure 4 could be used with a plain fabric for the only change required would be that the then cylinder needles of wales **28**, **30** and **32** would take the loops **39** with or without the tuck **41** and would then miss the yarns **45** for two courses. In other words, in either a rib or a plain fabric, the wales, on either side of the wale containing the dropped stitches, may contain either tuck stitches, held stitches, or a combination of both to exert a walewise pull in the fabric in the immediate vicinity of the dropped plated loop or loops. In all of the modifications elastic yarn may be inserted in the fabric coursewise to draw the wales together and accentuate the raised stitches.

We claim:

1. A knitted fabric comprising wales and

courses of a body yarn, wrap yarns individual to the wales and selectively plated on the stitches and in one or more wales one or more free loops of wrap yarn extending outwardly respectively through one or more otherwise free loops of body yarn to ornament said fabric and to prevent the body yarn from raveling.

2. A knitted fabric comprising wales and courses of a body yarn, wrap yarns extending walewise of said fabric and incorporated therein and in one or more wales one or more free loops of wrap yarn extending outwardly respectively through one or more otherwise free loops of body yarn to ornament said fabric and to prevent the body yarn from raveling.

3. A tubular knit rib fabric having courses comprising inside rib and outside plain wales, wrap yarns individual to said plain wales and incorporated therein and in one or more plain wales one or more free loops of wrap yarn extending outwardly respectively through one or more otherwise free loops of body yarn to ornament said fabric and to prevent the body yarn from raveling.

4. A stitch construction intermediate the ends of a wale of a knitted body yarn fabric having walewise extending wrap yarns comprising in a course thereof a free loop of wrap yarn extending outwardly through an otherwise free loop of body yarn to ornament said fabric and to prevent the body yarn from raveling.

5. A stitch construction in a wale of a knitted body yarn fabric having walewise extending wrap yarns comprising in a course thereof a loop of body yarn which is the end stitch of a series of stitches in said wale, a free loop of wrap yarn extending outwardly through said end loop to ornament said fabric and to prevent said series of stitches from raveling and a series of body yarn stitches in succeeding courses in said wale.

6. A stitch construction intermediate the ends of a wale of a knitted body yarn fabric having walewise extending wrap yarns comprising in a course thereof a float of body yarn across the same and a free loop of wrap yarn, said free loop of wrap yarn extending outwardly through an otherwise free loop of body yarn of the preceding course to ornament said fabric and to prevent the body yarn from raveling.

7. A stitch construction as set forth in claim 6 in which the float of body yarn comprises a raveled dropped stitch of body yarn.

8. A stitch construction intermediate the ends of a wale of a knitted body yarn fabric having a wrap yarn individual to said wale comprising in a course thereof a free loop of said wrap yarn extending outwardly through an otherwise free loop of body yarn to ornament said fabric and to prevent said body yarn from raveling.

9. A stitch construction in a wale of a knitted body yarn fabric having a wrap yarn individual to said wale comprising in a course thereof a loop of body yarn which is the end stitch of a series of stitches in said wale, a free loop of said wrap yarn extending outwardly through said end loop to ornament said fabric and to prevent said series of stitches from raveling and a series of body yarn stitches in succeeding courses in said wale.

10. A stitch construction intermediate the ends of a wale of a knitted body yarn fabric having a wrap yarn individual to said wale comprising in a course thereof a float of body yarn across the same and a free loop of wrap yarn, said free loop of wrap yarn extending outwardly through an otherwise free loop of body yarn of the preceding course to ornament said fabric and to prevent the body yarn from raveling.

11. A stitch construction intermediate the ends of a wale of a knitted body yarn fabric having a wrap yarn individual to said wale comprising in a course thereof a free loop of said wrap yarn extending outwardly through an otherwise free plated loop of said wrap yarn on the body yarn to ornament said fabric and to prevent the body yarn from raveling.

12. A stitch construction in a wale of a knitted body yarn fabric having a wrap yarn individual to said wale comprising in a course thereof a loop of body yarn which is the end stitch of a series of stitches in said wale, a free loop of said wrap yarn extending outwardly through said end loop to ornament said fabric and to prevent said series of stitches from raveling and a series of body yarn stitches in succeeding courses in said wale, an opening preceding said last named series of stitches, said wrap yarn extending from said free loop of wrap yarn across said opening to and being incorporated in one or more of the initial stitches of said second named series of stitches.

13. A stitch construction in a wale of a knitted body yarn fabric having a wrap yarn individual to said wale comprising in a course thereof a loop of body yarn which is the end stitch of a series of stitches in said wale, a free loop of said wrap yarn of the next course extending outwardly through said end loop to ornament said fabric and to prevent said series of stitches from raveling, a float of body yarn across said next course, in the following course said body yarn being tucked as the first stitch in a series of body yarn stitches in succeeding courses, an opening preceding said tuck stitch, said wrap yarn extending from said free loop of wrap yarn under said float and across said opening to and being incorporated in said tuck stitch.

14. A stitch construction as set forth in claim 9 in which said wrap yarn is selectively plated on one or more of the stitches of said series of stitches.

15. A tubular knit stocking having a plain leg and a rib top, said top comprising inside rib and outside plain wales of body yarn, wrap yarns individual to said plain wales and incorporated therein and in one or more plain wales one or more free loops of wrap yarn extending outwardly respectively through one or more otherwise free loops of body yarn to ornament said top and to prevent the body yarn from raveling.

16. A tubular rib knitted fabric comprising inside rib and outside plain wales of body yarn, wrap yarns individual to the plain wales and incorporated therein, one or more constructions each of which contains plain jersey selectively wrap plated fabric knitted on the plain outside wales only for one or more courses in continuation of the stitches of the plain wales of a rib course with the stitches of the inside rib wales of said rib course being held loops for said one or more courses, one or more free loops of wrap yarn in selected wales of said jersey fabric extending outwardly respectively through one or more otherwise free loops of body yarn to ornament said fabric and rib courses knitted in continuation of and joining the last course of said jersey fabric and said course of held loops.

17. The method of knitting a fabric on a series of needles including the step of feeding a body yarn to said needles and of feeding individual wrap yarns to selected ones of said needles

for a course of said fabric, knitting said course thus containing plated stitches of wrap yarn on body yarn on said selected needles, the step of dropping said plated stitches from said selected needles and the step of feeding and knitting subsequent courses of fabric on said needles.

18. The method of knitting a fabric on a series of needles including the step of feeding a body yarn to said needles and of feeding individual wrap yarns to selected ones of said needles for a course of said fabric, knitting said course thus containing plated stitches of wrap yarn on body yarn on said selected needles, the step of dropping selected ones of said plated stitches from their needles and the step of feeding and knitting subsequent courses of fabric on said needles.

19. The method of knitting a fabric on a series of needles including the step of feeding a body yarn to said needles and of feeding individual wrap yarns to selected ones of said needles for each of one or more courses of said fabric, knitting each of said one or more courses thus containing plated stitches of wrap yarn on body yarn on said selected needles, the step of dropping selected ones of said plated stitches from their needles in each of said one or more courses and the step of feeding and knitting subsequent courses of fabric on said needles.

20. The method of knitting a tubular rib fabric on a circular series of cylinder and dial needles including the step of feeding a body yarn to both sets of needles and of feeding individual wrap yarns to selected cylinder needles for a rib course of said fabric, knitting said rib course thus containing plated stitches of wrap yarn on body yarn on said selected cylinder needles, the step of dropping said plated stitches from said selected cylinder needles and the step of feeding and knitting subsequent rib courses of fabric on said needles.

21. The method of knitting a tubular rib fabric on a circular series of cylinder and dial needles including the step of feeding a body yarn to both sets of needles and of feeding individual wrap yarns to selected cylinder needles for each of one or more rib courses of said fabric, knitting each of said one or more rib courses thus containing plated stitches of wrap yarn on body yarn on said selected cylinder needles, the step of dropping selected ones of said plated stitches from their cylinder needles in each of said one or more rib courses and the step of feeding and knitting subsequent rib courses of fabric on said needles.

22. The method of knitting a tubular rib fabric on a circular series of cylinder and dial needles including the step of feeding a body yarn to both sets of needles and knitting rib fabric, the step of feeding body yarn to the cylinder needles only and of feeding individual wrap yarns to selected cylinder needles for one or more plain courses on said cylinder needles only, knitting each of said one or more plain courses thus containing plated stitches of wrap yarn on said selected cylinder needles while holding the loops of the last rib course on the dial needles, the step of dropping selected ones of said plated stitches from their cylinder needles and the step of feeding body yarn to both sets of needles and knitting rib fabric.

23. The method of knitting a tubular rib fabric on a circular series of cylinder and dial needles including the step of feeding a body yarn to both sets of needles and of feeding individual wrap yarns to selected cylinder needles for a rib course of said fabric, knitting said rib course thus containing plated stitches of wrap yarn on body yarn on said selected cylinder needles, the step of dropping selected ones of said plated stitches from their needles, the step of feeding said body yarn to both sets of needles and of feeding said individual wrap yarns to selected ones of said cylinder needles including the bare needles for the next rib course of fabric, knitting said next rib course of fabric and the step of feeding and knitting subsequent courses of rib fabric on said needles.

24. The method of knitting a fabric on a circular series of independent needles including the step of feeding individual wrap yarns to selected needles and feeding a body yarn to said needles for a course of said fabric, at a knitting point in said circular series of needles knitting said course thus containing plated stitches of wrap yarn on body yarn on said selected needles, the step of simultaneously dropping selected ones of said plated stitches from their needles at another point in said circular series of needles and the step of feeding and knitting subsequent courses of fabric on said needles.

25. The method of knitting a fabric on a circular series of independent needles including the step of feeding individual wrap yarns to selected needles and feeding a body yarn to said needles for a course of said fabric, progressively actuating said needles as the latter pass relative to a knitting station to knit said course thus containing plated stitches of wrap yarn on body yarn on said selected needles, the step of simultaneously dropping selected ones of said plated stitches from their needles at a point spaced from said knitting station and the step of feeding and knitting subsequent courses of fabric on said needles.

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