

April 24, 1962

M. A. LAW

3,030,691

HIGH-LOW TERRY PILE FABRIC AND METHOD

Filed March 17, 1960

3 Sheets-Sheet 1

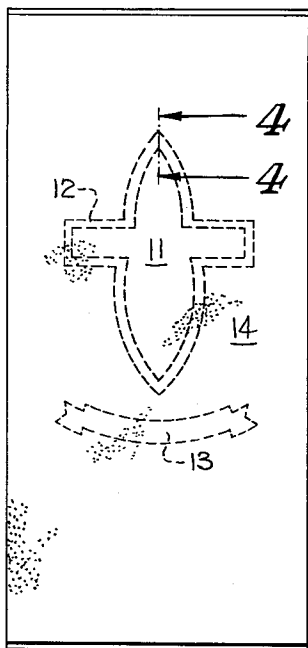


Fig-1

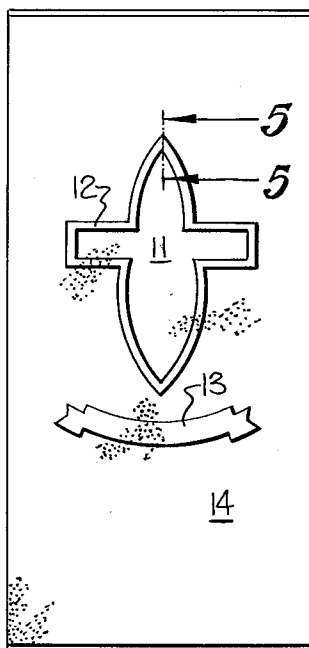


Fig-2

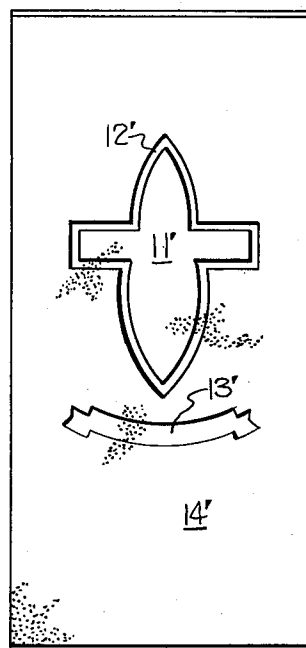


Fig-3

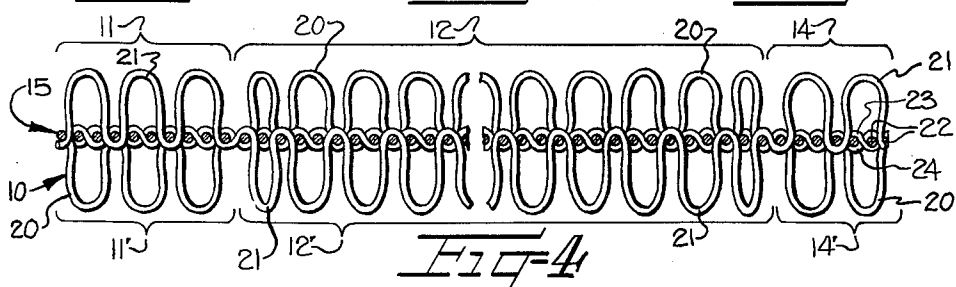


Fig-4

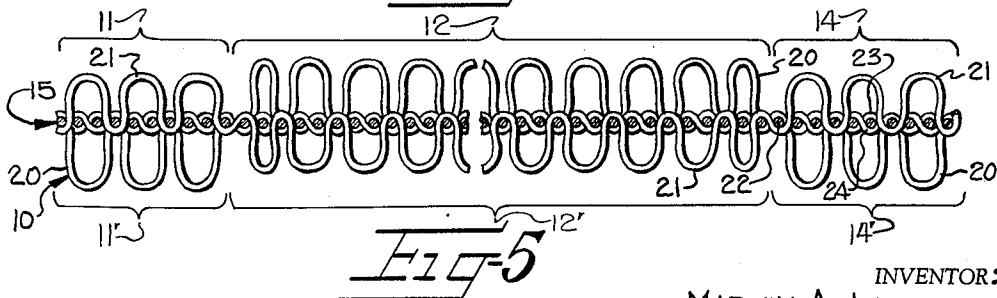


Fig-5

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3 Sheets-Sheet 2

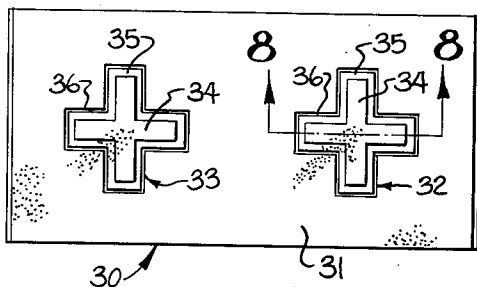
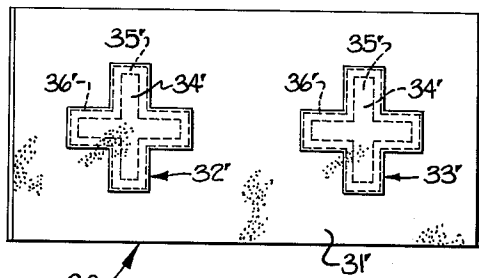


Fig-6



30 Fig-7

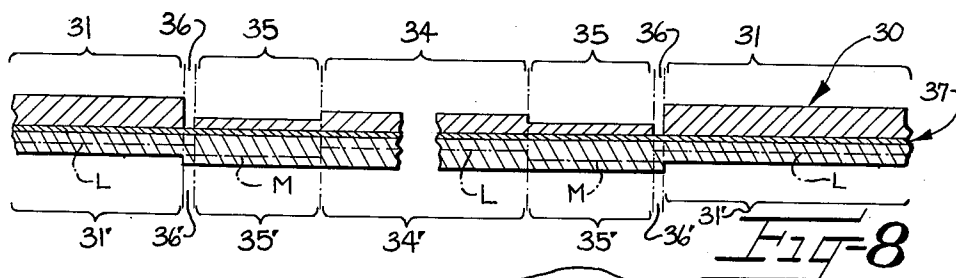


Fig-8

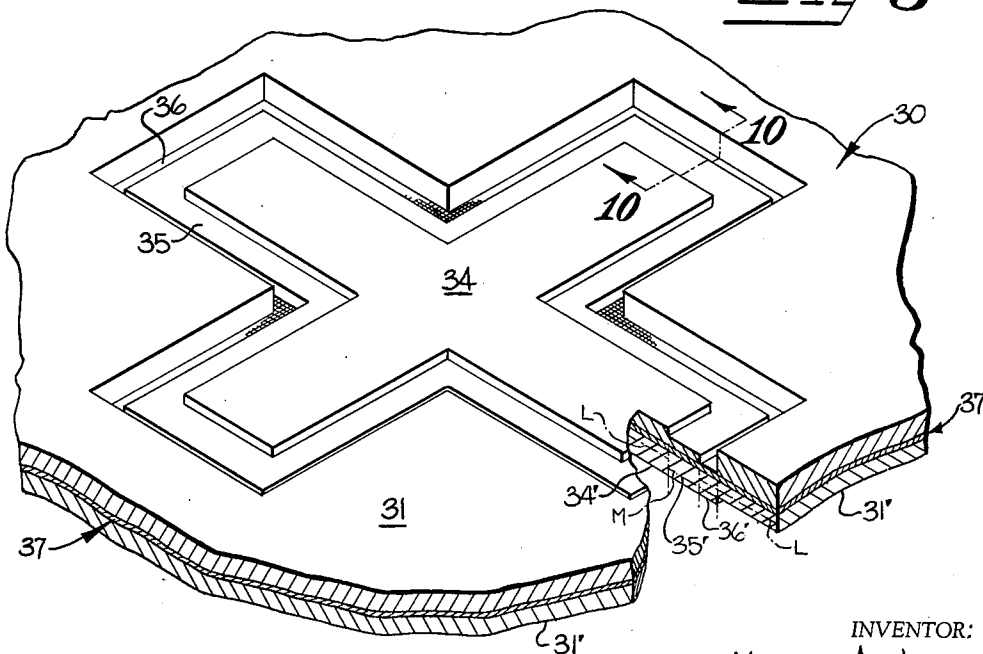


Fig-9

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HIGH-LOW TERRY PILE FABRIC AND METHOD

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3 Sheets-Sheet 3

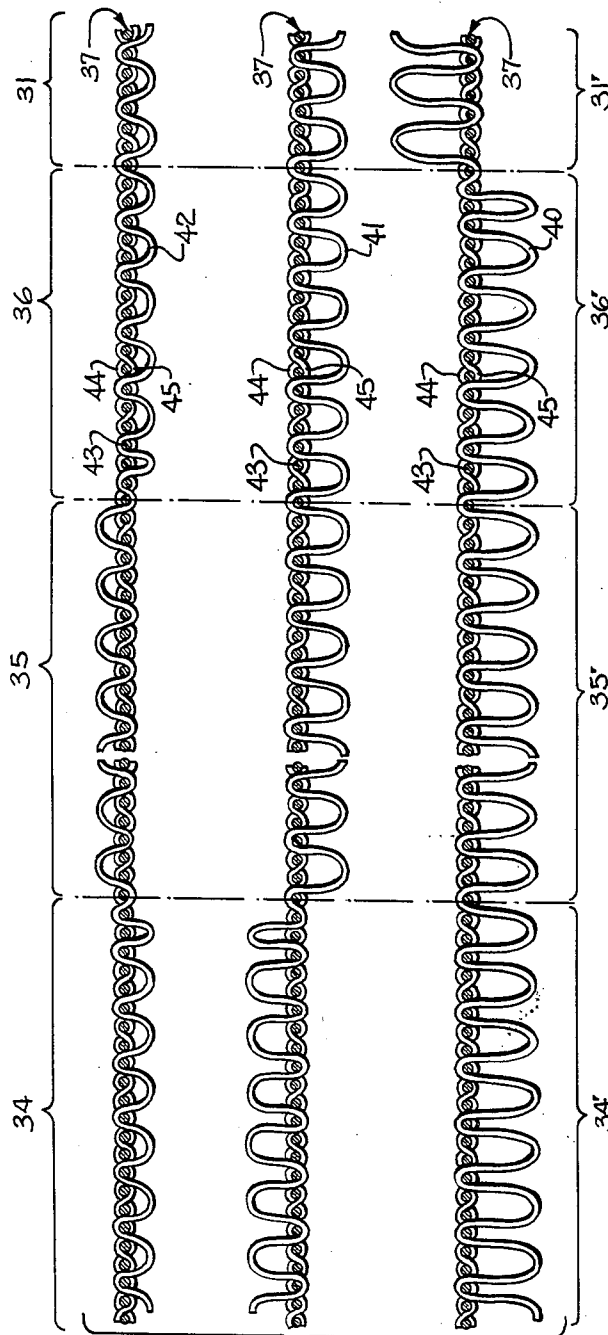


FIG. 11

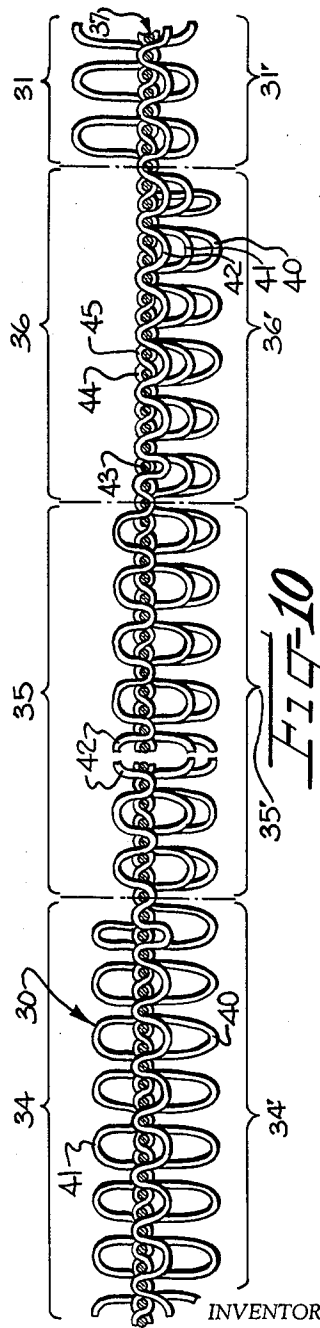


FIG. 10

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HIGH-LOW TERRY PILE FABRIC AND METHOD
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3 Claims. (Cl. 28—73)

This invention relates to a novel terry fabric suitable for towels, garments, bedspreads, draperies and the like and to a method of making such a fabric.

It is the primary object of this invention to provide a terry fabric and method of making the same wherein the fabric has a base with terry loops projecting from both faces of the base, the terry loops being formed of two or more types of yarns of relatively varying shrinkability which are so arranged that loops formed of at least one of the types of yarns project from one face of the base, and loops formed of at least one other of the types of yarns project from the opposite face of the base, in at least a portion of the fabric, so that opposite faces of the fabric are of different appearance.

It is another object of this invention to provide a novel terry fabric which is inexpensive to manufacture and wherein the finished fabric includes one or more relatively high or long pile design areas surrounded by relatively lower pile areas, and vice versa, on both faces thereof.

It is a more specific object of this invention to provide a novel terry fabric and method of making the same and wherein the fabric has a woven base, terry loops carried by and projecting from both faces of the base, and the loops being formed from two or more types of yarns of varying shrinkability. In certain areas, first loops of at least one of the types of yarns project from one face of the base opposite from the face of the base from which the loops of at least one of the other types of yarns project. In other areas the respective aforesaid yarns are arranged in an opposite manner therefrom to project from the other face of the fabric.

It is still another object of this invention to provide a terry fabric and method of the character described and wherein at least one of the terry pile yarns is a bulk yarn.

According to the present method a terry fabric is woven of two or more pile yarns of different shrinkage characteristics with the different types of yarns appearing in the form of terry loops arranged in predetermined order on opposite faces of the fabric, and with all the terry loops projecting substantially the same distance from the base fabric at each face thereof. Thereafter, the fabric is treated to cause the yarns to shrink relative to each other or to cause at least one of the types of yarns to shrink relative to the other type or types of yarns so that loops of different length are produced from the different types of yarns of which the fabric was originally woven and on opposite faces of the fabric.

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

FIGURE 1 is an elevational view of one face of a towel, representative of a terry fabric embodying the present invention, showing the same as it comes from a loom with areas defined in broken lines representing loops formed from different types of yarns;

FIGURE 2 is a view similar to FIGURE 1 showing the embossed and recessed effects produced by shrinking the fabric of FIGURE 1;

FIGURE 3 is a view looking at the opposite face of the finished fabric from that shown in FIGURE 2;

FIGURE 4 is a greatly enlarged fragmentary sectional view taken substantially along line 4—4 in FIGURE 1 showing the loops formed of a set of two yarns of different

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shrinkability, with all the loops being of the same height on opposite faces of the fabric;

FIGURE 5 is a view similar to FIGURE 4, but being taken substantially along line 5—5 in FIGURE 2, to illustrate the different heights of pile formed from the two terry pile yarns after shrinking the fabric;

FIGURE 6 is a view similar to FIGURE 2 showing a different design on the finished towel and embodying a second form of the invention in which loops of three different lengths are provided;

FIGURE 7 is a view of the opposite face of the fabric from that shown in FIGURE 6;

FIGURE 8 is a somewhat diagrammatic vertical sectional view taken substantially along line 8—8 in FIGURE 6, with the central portion thereof broken away and showing areas formed of the various loop lengths in block form;

FIGURE 9 is an isometric view of the basic design areas 32 shown in FIGURE 6, wherein the areas of different loop lengths are shown in block form;

FIGURE 10 is a fragmentary warpwise sectional view through the second form of terry pile fabric taken substantially along line 10—10 in FIGURE 9 and showing the different heights of loops produced by three different types of terry pile yarns of different shrinkability, and showing the fabric after it has been subjected to a shrinking treatment;

FIGURE 11 is a view similar to FIGURE 10, but showing the three terry pile yarns of one set in exploded relationship.

Heretofore, in order to produce various aesthetic effects in terry fabrics, such as blocks, stripes or figures of terry loops, commonly known as jacquard designs, it has been common practice to form the effect areas by weaving sections in which all the terry loops were formed on the opposite face or back of the fabric, thus leaving complementary sections of the terry fabric which were devoid of terry loops; or lateral stripes were formed in the fabric by varying the amount of slack produced in the terry warps during weaving to produce terry loops of different heights. In another method, terry fabric was woven from terry warps which were previously dyed two or more colors, or two or more colors and white, and wherein the figure or design was produced by forming the loops of one color on one face of the fabric to outline the design and the loops formed of another color or white were arranged to surround the figure. Of course, the areas of the face which were not to include some colors while including another color would have said some colors of loops formed on the opposite face of the fabric.

The present fabric includes intricate jacquard designs which can be produced on a conventional terry loom without varying the extent to which the terry yarns are slackened during the formation of different terry loops. The fabric may be woven on any type of terry loom equipped with a pattern device, although it is preferable that such loom be provided with a jacquard pattern mechanism for controlling the terry pile yarns so that selected loops may project from either face of the base.

In the terry pile fabric in accordance with this invention, a base fabric is woven from non-shrinkable or low shrink ground warps and wefts concurrently with which terry loops are formed on both faces of the base and in which all the loops are of substantially the same length or height with adjacent warpwise rows of loops being formed from terry yarns of different shrinkability. Adjacent terry pile yarns may include a non-shrinkable yarn and one or more individual relatively shrinkable yarns, or all the terry pile yarns in each set or group may be shrinkable but capable of shrinking varying amounts.

As is well known, terry fabrics are woven by looping terry yarns around spaced weft yarns in each instance,

then forming one or more loose picks in which the wefts are spaced from the fell of the fabric being woven, then slackening the terry pile yarns relative to the ground warps and drawing the slack out of the pile yarns with a fast pick wherein the respective weft is beat-up with the one or more wefts cast with the loose picks to thus pile up the pile yarns in the form of loops whose bights are spaced from the one or more wefts of which the loose picks were previously formed and whose legs are anchored in the base by the wefts preceding those of which successive fast picks are formed.

As heretofore stated, the warpwise rows of loops may be formed from sets of two or more terry pile yarns of different shrinkability. In weaving the fabric, mottled effect areas may be formed by throwing the loops formed of a first terry pile yarn to one face of the base while throwing loops formed of a second relatively shrinkable terry pile yarn to the other face of the base during the formation of every other weftwise row of terry loops. The faces to which the loops of the first and second yarns are thrown may be reversed in forming the intervening weftwise rows to produce a mottled area when the fabric is subsequently subjected to a shrinking treatment.

A pleasing effect may be produced by causing all the loops formed of a first yarn to project from one face of the base fabric and causing all the loops formed of a second relatively shrinkable terry pile yarn to project from the other face of the base. The latter type of fabric, when subjected to a shrinking treatment, is particularly useful in making bath mats.

In other instances, the fabric may be formed by throwing the terry loops formed of a first terry pile yarn or yarns to a first face of the fabric while throwing the loops formed of a second relatively shrinkable yarn or yarns to the second or other face of the base. The latter arrangement may be confined to a relatively large area or areas and this procedure is reversed at other adjacent areas. The fabric is then subjected to a shrinking treatment so that the first-mentioned areas on the first face of the fabric are recessed relative to adjacent areas, and the first-mentioned areas on the other or second face of the fabric are raised relative to said adjacent areas. Of course, the mottled effect, set forth above, may also be combined with the raised and recessed effects to produce further design variations.

In one embodiment of the invention, a relatively low shrinkable or non-shrinkable terry pile yarn is used in alternation with a second relatively high shrinkable yarn across the fabric to produce the above effects. In a second form of the invention, several different types of pile yarns of relatively varying shrinkability are arranged across the fabric in each of a plurality of groups, there being three different yarns used in this instance, so that, in selected areas, three different lengths of loops may be formed in any predetermined order to provide loop pile areas of predetermined configuration which may be of three different heights on either or both faces of the base, the extent of pile length variation in the effect areas being limited only by the number of different types of yarns of varying shrinkability which may be practically combined in each set of terry pile yarns.

Referring more specifically to the drawings, a first embodiment of the invention is shown in FIGURES 1 through 5 and is illustrated in the form of a towel or bath mat, which is representative of many different types of articles which may be produced according to the present method, such as towels, bedspreads, draperies, rugs, carpets or certain types of wearing apparel.

FIGURE 1 shows a front face of the article 10 as it comes off of the loom, with design effect areas 11, 12, 13 being defined in dotted lines in FIGURE 1, since they are not normally visible as the fabric comes off of the loom. The areas 11, 12, 13 are surrounded by a main effect or body area 14. Areas 11', 12', 13', 14', on the back face of the fabric 10 (FIGURE 3) complement the areas

11-14. As shown in FIGURE 4, all the areas 11-14 and 11'-14' are formed of terry loops which project substantially the same distance from each of opposite faces of a base, broadly designated at 15.

However, the terry loops are formed from two different types of terry pile yarns 20, 21 of relatively varying shrinkability. For example, the terry pile yarn 20 may be formed solely from cotton fibers and the terry pile yarn 21 may be formed from cotton fibers blended with other types of cellulosic, natural, animal or synthetic thermoplastic fibers or strands. If desired, both of the terry pile yarns 20, 21 in each set may be made from blends or plied strands of different types of fibers with the first terry pile yarn 20 being blended with different fibers or different proportions of fibers than the second terry pile yarn 21 in such a manner that the loops formed of the terry pile yarn 21 will shrink to a greater extent than the loops formed of the terry pile yarn 20 when the fabric is subjected to a shrinking treatment, as shown in FIGURE 5.

The base 15 is of usual construction, to the extent that it is formed of weft yarns 22 interwoven with ground warps 23, 24 and, as is usual, one or more of the ground warps 23, 24 may be disposed between each adjacent pair of terry pile yarns 20, 21. In FIGURES 4 and 5, the terry fabric is shown in the form of a so-called three-pick terry wherein the terry yarns are normally looped about every third weft yarn. However, it is to be distinctly understood that the fabric need not be limited to a three-pick terry.

By comparing FIGURE 5 with FIGURE 2, wherein the fabric 10 is shown after finishing, it will be noted that long loops are formed of non-shrinkable or low-shrink yarns 20 in effect areas 12, 13, and short loops are formed of the second higher-shrink yarns 21 in areas 11, 14. At the same time, short loops are formed of yarns 21 in areas 12', 13' at the back face of fabric 10 (FIGURE 3), and long loops are formed from the first yarns 20 in areas 11', 14'.

The yarn capable of the higher shrinkage and which forms the shortest loops, such as the yarn 21 in FIGURES 4 and 5, is preferably of a type which will bulk; i.e., become lofty and soft, relative to the yarn of which the higher loops are formed when the fabric is subjected to the shrinking treatment. Many different types of yarn will bulk when subjected to a shrinking treatment, and such types of yarns are generally formed by blending a normal or low shrink fiber with a relatively high shrink fiber so that, during shrinking or other finishing treatments, the high shrink fiber is caused to shrink in length to, in effect, produce loops or bulges in the low shrink fibers, causing the low shrink fibers to stand further apart within the yarn and increasing the diameter of the yarn to a much greater extent than the extent to which the length thereof is decreased.

Yarns capable of desirable shrinkage and bulkiness may be obtained by blending cotton fibers with high shrink acrylic fibers, such as Orlon, Acrilan, Dynel and Verel; by blending cotton fibers with vinyl chloride-vinyl acetate fibers such as Vinyon HH; blending cotton fibers with polyethylene fibers or other polyolefins; and with other combinations of synthetic fibers. Where the relatively high shrink yarns are made from synthetic fibers or filaments, the desired shrinkage may be obtained by steaming the fabric from one-half minute to five minutes in boiling water or steam at boiling temperature (212° F.). Acrylic fibers start to shrink at approximately 180° F. and are completely shrunk at approximately 212° F. The polyolefins start shrinking at approximately 165° F. and complete shrinkage is attained at approximately 212° F., and the vinyls shrink completely at approximately 150° F. The amount of these various synthetic fibers blended with cotton, rayon and other normal or non-shrinking fibers may vary from 10 percent to 35 percent and shrink-

age obtained therefrom may vary from 22 percent to 60 percent.

Water shrinking rayon fibers commonly known as "latent crimp water fibers" may also be used for forming the relatively high shrink terry pile yarns, the only treatment normally required in the water shrinking fibers is that of soaking the product and then drying it under a minimum of tension. Water shrinking fibers include so-called L.C.W. fibers manufactured by American Viscose Company, and a so-called Narco #1 rayon manufactured by North American Rayon Company. Nearly all rayon manufacturers are familiar with the processes of manufacturing water shrinking fibers. Water shrinking fibers may be blended with cotton fibers at a proportion of from 15 percent to 50 percent, and the resultant yarns may shrink from 15 percent to 30 percent.

The shrinkable terry pile yarns may also be of a type capable of being chemically treated to effect the desired shrinkage in the yarn. One such fiber which may be blended, in the range of from 15 percent to 30 percent, with cotton, is a "latent crimp caustic" rayon sold under the name "L.C.C." by E. I. du Pont de Nemours & Company. Latent crimp caustic rayon yarn will shrink from 15 to 30 percent. Many fiber processing companies are capable of producing chemically shrinkable fibers and it is within the scope of the present invention to use any type of combination of synthetic, natural, cellulosic, protein or animal fibers for producing the different types of yarns of relatively varying shrinkability.

The shrinkable yarns may also be formed by plying a relatively high shrink strand or strands with a non-shrinkable or low-shrinkable strand or strands. For example, a direct spun rayon strand may be plied with a plain rayon strand to effect the desired shrinkage and bulkiness in the finished fabric. A direct spun rayon strand is produced by attenuating or drafting rayon fibers, and then breaking the fibers during the spinning of the fibers, and the plain rayon is formed of fibers which are cut before the spinning operation.

The various types of shrinkable yarns set forth above are exemplary of many different types of yarns which may be used to produce the fabric of the present invention, since it is well known that yarns of practically any desired shrinkage characteristics may be produced by choosing and processing strands to obtain various degrees of shrinkage, and several strands or fibers of different shrinkage characteristics may be combined to produce various degrees of shrinkage and bulkiness.

Second Form of the Invention

A modified form of the fabric is shown in FIGURES 6-11 after the fabric has been finished; i.e., subjected to a shrinking treatment, and wherein the terry loops are formed of sets of three types of yarns of different shrinkability. A first or front face of the second form of fabric 30 is shown in FIGURE 6, which includes a main terry loop effect area or body on which two basic design areas 32, 33 are formed of terry loops of different heights or lengths. Each of the basic design areas 32, 33 of the fabric 30 includes a central, medium-length terry pile area 34 surrounded by an inner border effect area 35 formed of relatively short terry loops, and a narrow outer border effect area 36 which is devoid of terry loops on the front face of the fabric 30 (see FIGURES 8 and 9).

In FIGURE 7, the back or second face of the fabric 30 is shown having a main effect area 31' formed of intermingled medium-length and short-length loops surrounding basic design areas 32', 33' which complement the respective areas 32, 33 on the front face of the fabric 30. Each of the basic design areas 32', 33' is formed of effect areas 34', 35', 36' which complement the respective areas 34, 35, 36 of the respective basic design areas 32, 33. It will be noted that the central effect areas 34' and the inside border areas 35' are defined in broken lines in

FIGURE 7 for the purpose of illustrating the fact that, while these areas 34', 35' differ in appearance and also differ with respect to the appearance of the outer marginal areas 33', such differences are not entirely clear, especially when all the terry pile yarns are of the same shade or color, since all of these areas include relatively long loops, but which loops appear to vary as to density because of the fact that the long loops are interspersed with short loops in the areas 34', the long loops are interspersed with medium-length loops in the inner border areas 35', and the long loops are interspersed with loops of both medium and short lengths in the outer border areas 36'. This is more clearly illustrated in FIGURE 8, wherein it will be observed that on the back of the fabric the outer surfaces of the short loops are represented by respective dot-and-dash lines L, the outer surfaces of the medium-length loops are represented by dot-and-dash lines M. Since FIGURES 8 and 9 represent the various loop heights in block form, the base fabric 37 is shown in the form of a thin strip in FIGURES 8 and 9.

In order to clearly understand how the various design and effect areas are produced on the fabric shown in FIGURES 6 and 7, FIGURES 10 and 11 each illustrates one of the sets of different types of relatively shrinkable terry pile yarns, following the shrinking treatment, and wherein the non-shrinkable or relatively low shrink terry pile yarn is indicated at 40, the medium shrink terry pile yarn is indicated at 41 and the high shrink terry pile yarn is indicated at 42. These terry pile yarns 40, 41, 42 are interwoven with the base 37, which base comprises wefts 43 and ground warps 44, 45. With the exception of the different shrinkage characteristics of the terry pile yarns 40, 41, 42, the fabric 30 may be constructed generally in the same manner as the fabric 10, and all the terry loops may project substantially the same distance from opposite faces of the base 37 while the fabric is being woven. Although FIGURES 10 and 11 show a single set of three terry pile yarns, it is apparent that such sets may be repeated throughout all or a substantial portion of the width of the fabric 30.

Referring to the right-hand portions of FIGURES 10 and 11, it will be observed that, during the weaving of the complementary main effect areas 31, 31', the loops formed from the terry pile yarns 41, 42 are caused to project from the back face of the fabric and the loops formed of the terry pile yarns 40 are projected above the front face of the fabric. In forming the outer border areas 36, 36', the loops formed of all three of the terry pile yarns 40, 41, 42 are caused to project from the back face only of the fabric, so the base is visible in the outer border area 36.

In forming the complementary inner border areas 35, 35', loops formed of terry pile yarns 42 are projected from the front face of the fabric while loops formed of the terry pile yarns 40, 41 are projected from the back face of the fabric. In forming the complementary central effect areas 34, 34', the loops formed from the terry pile yarns 40, 42 are projected from the back face of the fabric while the loops formed from the terry pile yarns 41 are projected from the front face of the fabric.

Thus, after the fabric is treated to at least cause the terry pile yarns 41 and 42 to shrink relative to each other and relative to the non-shrinkable or low shrink pile yarns 40, relatively long loops of terry pile yarns 40 project from the front face of the fabric 30 in area 31 while short and medium-length loops formed of the terry pile yarns 42, 41 project from the back face of the fabric in area 31'. Loops of all three lengths formed of yarns 40, 41, 42 project from the back face only of the fabric in area 36'; relatively long and medium-length loops project from the back face of the fabric in area 35' while relatively short loops project from the front face of a fabric in area 35. Also, relatively long and short loops, formed from the respective terry pile yarns 40, 42, project from

the back face of the fabric 30 at the area 34' while medium-length loops project from the front face of the fabric 30 in the area 34'.

In the area 36', the long loops formed of terry pile yarns 40 appear as though they are spaced substantially further apart from each other than they do in the areas 31, 34', 35'. The loops in areas 31, 34, 35 appear to be more dense than the loops in the respective areas 31', 34', 35' due to the fact that loops of two different lengths are intermingled in each of the areas 31', 34', 35' and loops of only one of any of the three lengths are present in each of the areas 31, 34, 35.

As heretofore stated, the individual yarns 40, 41, 42 in each set may be of any desired construction to effect the desired relative shrinkage thereof during the shrinking treatment. By way of example, the low shrink or non-shrinkable yarns 40 may be made solely from cotton fibers, the medium-shrink yarn 41 may be made from a blend of 84 percent cotton and 16 percent acrylic fibers and the high shrink yarn 42 may be made from a blend of low shrink Orlon and high shrink Orlon.

It is thus seen that I have provided a novel terry fabric and method of making the same wherein all the terry loops may be formed of the same height during the weaving of the fabric and, by subjecting the fabric to a shrinking treatment, embossed and/or recessed effect areas of any desired configuration which project varying distances from the face of the fabric may be formed.

The fabric made according to the present invention may be further enhanced by dyeing one or more, but not all, of the terry pile yarns before the fabric is woven and then shrinking and dyeing the fabric, either separately or at the same time, using with the same color dye as that used in dyeing said one or more of the terry pile yarns, so that loops formed of the previously dyed terry pile yarn or yarns will be of a darker shade than loops formed of the remaining terry pile yarns, thus giving the fabric an appearance of greater depth at any recessed areas, for example.

Although terry pile yarns of varying shrinkage characteristics are necessary in those portions of the width of the fabric to be embraced by the design areas, it is apparent that other warpwise areas of the fabric may be made all from one type of yarn. In addition, lateral areas, such as border areas, may be formed wherein all the loops formed of one type of yarn appear on one face of the base and all the loops formed of another or other types of yarns would project from the other, opposite, face of the base. Also, there are instances in which it may be desirable to provide narrow bands across the fabric which are entirely devoid of terry loops on either face of the base. This simply requires that all the terry pile yarns be interwoven, in taut condition, with the base fabric.

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

I claim:

1. A method of making terry pile fabric utilizing at least two different types of terry pile yarns wherein one of the types of yarns has a greater shrinkage capacity than the other, said method comprising weaving a base

from ground warps and wefts while concurrently forming terry loops from the different types of yarns with the loops projecting from both faces of the base according to a predetermined pattern, and then subjecting the fabric to a shrinking treatment to reduce the length of at least those loops formed of said one of the types of yarns whereby the latter loops are shorter than the loops formed of the other type of yarns.

2. A terry pile fabric made in accordance with claim 1.

3. A method of making terry pile fabric utilizing at least two types of terry pile yarns wherein one of the types of yarns has a greater shrinkage capacity than the other, said method comprising weaving a base from ground warps and wefts while concurrently forming terry loops from both types of yarns with loops of both types of yarns projecting from both faces of the base according to a predetermined pattern, and then subjecting the fabric to a shrinking treatment to reduce the length of at least those loops formed of said one type of yarns whereby the latter loops are shorter than the loops formed of the other type of yarns.

4. A terry pile fabric made in accordance with claim 3.

5. A method of making a terry fabric which comprises weaving a base of relatively non-shrinkable base yarns, simultaneously interweaving with the base a series of alternately arranged sets of shrinkable terry pile yarns and non-shrinkable pile yarns in the form of terry loops of substantially equal length on opposite faces of the base with loops of the non-shrinkable pile yarns projecting from one face of at least a portion of the base and loops of the shrinkable yarns projecting from the opposite face of said portion of the base, and then subjecting the fabric to a shrinking treatment capable of shrinking and reducing the length of the loops formed from the shrinkable yarns with respect to the length of loops formed from the non-shrinkable yarns.

6. A terry pile fabric made in accordance with claim 5.

7. A method of making a terry towel fabric having complementary design areas on opposite faces thereof which comprises interweaving at least two types of terry pile yarns, each of different shrinkability than the other, with a base fabric and in the form of pile projecting substantially the same amount from each face of the base while projecting the pile formed of one of the types of yarns from one face in at least a portion of the base, and projecting the pile formed of said one type of yarns from the opposite face of the base in at least one other portion of the base, and while projecting the pile of the other type of yarns from the opposite face of certain areas of the base complementing the pile formed of said one of the types of yarn, then subjecting the fabric to a shrinking treatment to cause the pile of one of the types of yarns to shrink relative to the pile of the other of the types of yarns so the pile formed from yarns having the greater shrinkability are recessed relative to the adjacent areas on the same side of the fabric from which project the pile formed of the other type of yarns.

8. A terry pile fabric made in accordance with claim 7.

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