Oct. 3, 1950 H. F. GOLDSMITH 2,524,255

HAIR NET AND METHOD OF FORMING SAME

Filed June 22, 1950 3 Sheets-Sheet 1

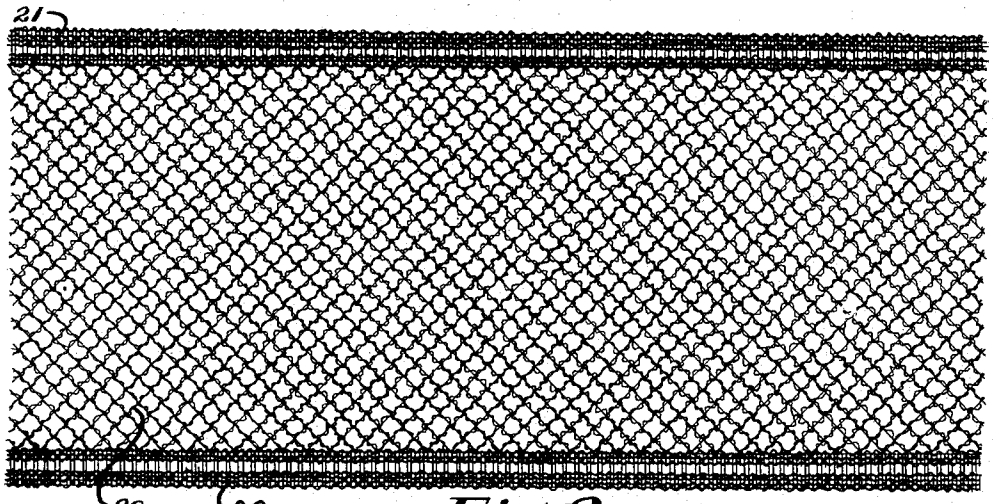


Fig. 2

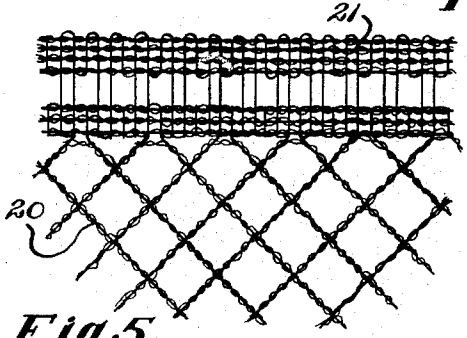


Fig. 5

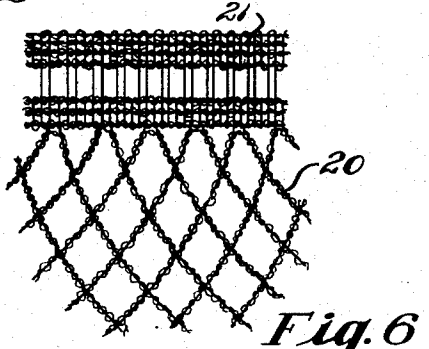


Fig. 6

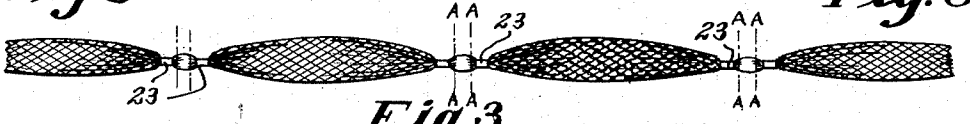


Fig. 3



Fig. 1

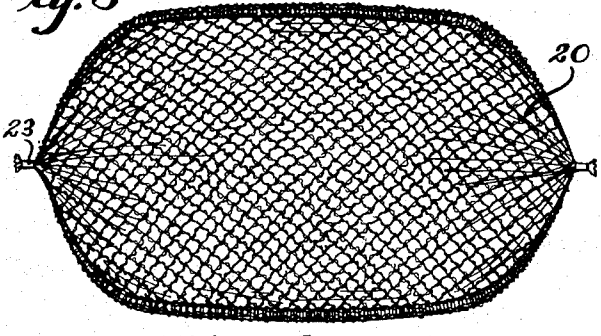


Fig. 4

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HAIR NET AND METHOD OF FORMING SAME

Filed June 22, 1950 3 Sheets-Sheet 2

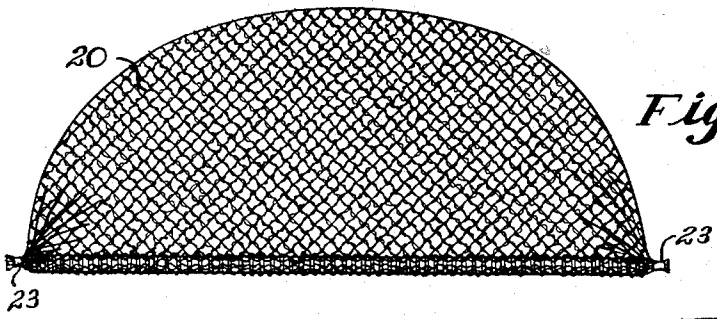


Fig. 7

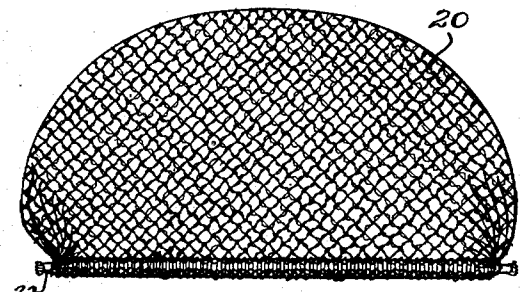


Fig. 8

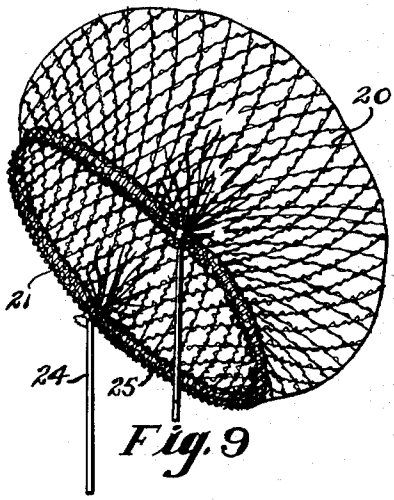


Fig. 9

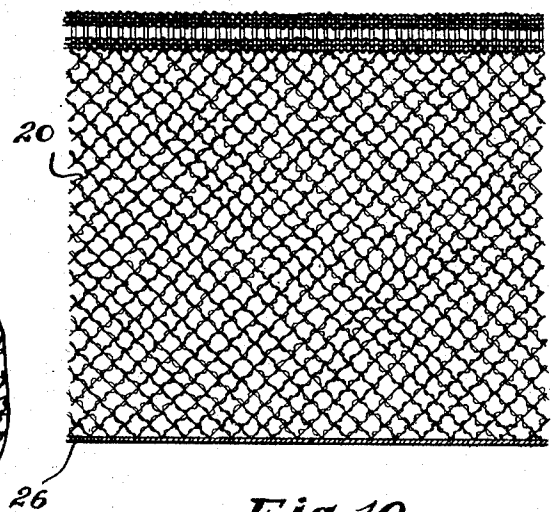


Fig. 10

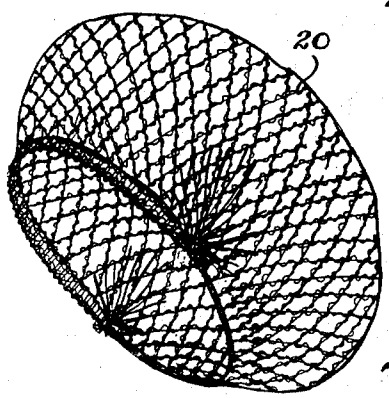


Fig. 11

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HAIR NET AND METHOD OF FORMING SAME

Filed June 22, 1950 3 Sheets-Sheet 3

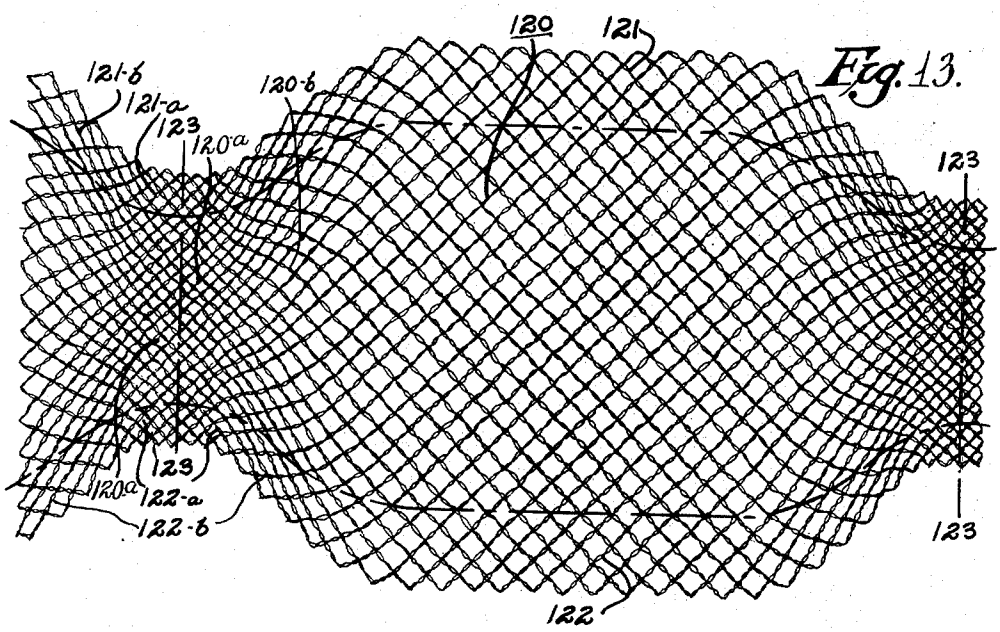


Fig. 13.

Fig. 14.

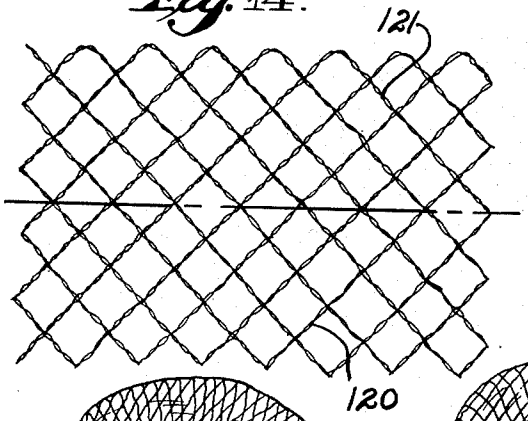
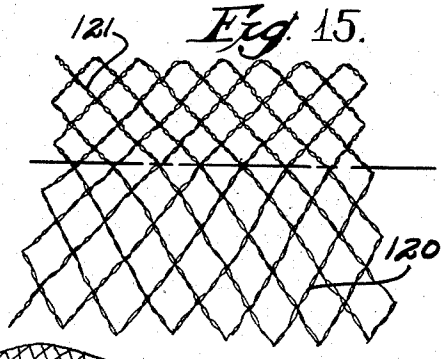


Fig. 15.



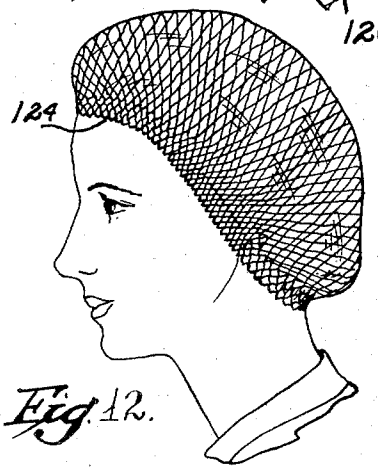


Fig. 12.

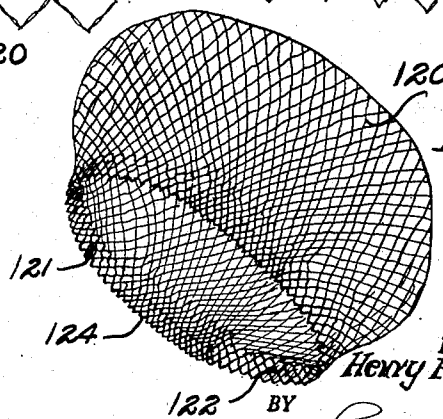


Fig. 16.

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UNITED STATES PATENT OFFICE

2,524,255

HAIR NET AND METHOD OF FORMING SAME

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Application June 22, 1950, Serial No. 169,566

16 Claims. (Cl. 132—49)

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The present invention relates generally to hair-nets or wave-nets or the like and it relates more particularly to hair-nets which are more or less cap-shaped with a mouth or opening constructed and arranged to fit snugly about the head of the wearer.

An object of the present invention is to provide a new and improved hair-net or wave-net construction. Another object of the present invention is to provide a hair-net having a contracted mouth or opening which holds its position on the head of the wearer and which does not bind or crease the forehead.

Still another object of the present invention is to provide a hair-net or wave-net wherein the contracted mouth or head-opening is formed without stitching or fastening-clips.

Other objects and advantages of the present invention are apparent in the following detailed description, appended claims and accompanying drawings.

The present application is a continuation-in-part of each of my co-pending applications Serial Nos. 78,263, now abandoned (filed February 25, 1949), and 94,300 (filed May 20, 1949).

Hair-nets of sheer open-mesh fabric or the like are customarily provided with a peripheral band of elastic or like resilient material which passes across the forehead of the wearer and which tends to contract the hair-net into a generally cap-shaped form with a mouth or opening which fits snugly about the head of the wearer and aids in retaining the hair-net snugly in place during use. This elastic band serves the additional function of keeping the hair-net from sliding back off the forehead when a draw-string is employed to shape the back or lower edge of the hair-net.

The use of rubber bands or the like for this purpose has proven objectionable due to the fact that the rubber band is uncomfortable and causes a line or welt where it passes across the forehead of the wearer.

According to the present invention, I have found that this reduced-diameter mouth or opening can be formed more effectively in a hair-net constructed of rayon or nylon or other suitable natural or synthetic yarn or thread by forming one or both of the selvage edges of a material which tends to shrink to an appreciably greater extent than the rayon or nylon (or other natural or synthetic yarn or thread of which the main body of the hair-net is constructed) under the influence of heat so that it tends to form a contracted mouth or opening which is more effective in holding its proper position on the head of the wearer without binding or creasing the forehead.

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Generally speaking, the present invention contemplates the formation of a hair-net wherein the main body is constructed of yarn or threads (of rayon or silk or cotton or nylon or other suitable material) formed into an open-mesh structure and wherein one or both of the selvage edges are formed of polyacrylonitrile resin (such as Vinyon, which is sold commercially by The American Viscose Company) or like material which has an appreciably greater tendency to shrink than the rayon (or silk or cotton or nylon), upon heating, so as to form a more or less contracted mouth or opening.

According to one embodiment of the present invention (as disclosed originally in my co-pending application Serial No. 78,263), the individual hair-nets are formed from an elongated strip of open-mesh material by tightly gathering the strip at spaced pairs of points (employing fastening-clips or the like), thereafter transversely cutting the strip intermediate each pair of clips, and then heating the individual length of open-mesh material so as to shrink the polyacrylonitrile selvage edge or edges.

According to another embodiment of the present invention (originally mentioned in my co-pending application Serial No. 78,263 and disclosed more fully in my co-pending application Serial No. 94,300), no fastening-clips are employed in the formation of the contracted mouth or head-opening. In this embodiment, the hair-net or wave-net is formed from an elongated strip of sheer open-mesh material having a main body-portion constructed of natural or synthetic textile threads (as for example rayon, nylon, silk, cotton or the like) and having upper and lower selvage edges formed of threads of polyacrylonitrile resin (i. e. Vinyon) or other suitable synthetic resin which is capable of contracting excessively under the action of heat; the elongated strip of material being knitted or otherwise formed so as to have zones of smaller-size openings at spaced intervals, thereby providing the elongated strip of open-mesh material with areas of relatively larger transverse dimension and contracted areas of relatively smaller transverse dimension, disposed in alternating relationship. The elongated strip of open-mesh material is then transversely cut across the center of the smaller contracted areas to form individual lengths of more or less oval contour. The individual lengths are then heat-treated so as to contract

the selvage edges and thereby to tighten the periphery of the strip (in a manner analogous to the action of a draw-string) to provide a hair-net or wave-net having a contracted mouth or head-opening which is defined in part by the smaller-opening cut edges and in part by the contracted selvage edges of the strip.

For the purpose of illustrating the invention, there are shown in the accompanying drawings forms thereof which are at present preferred, although it is to be understood that the various instrumentalities of which the invention consists can be variously arranged and organized and that the invention is not limited to the precise arrangements and organizations of the instrumentalities as herein shown and described.

Referring to the accompanying drawings in which like reference characters indicate like parts throughout:

Figure 1 represents an elevational view showing a hair-net embodying the present invention as it appears in use.

Figure 2 represents a plan view of a length of knitted material constituting an intermediate stage in the formation of the hair-nets of the present invention.

Figure 3 represents an elevational view, on a reduced scale, showing a subsequent stage in the formation of a number of hair-nets from the strip of Figure 2.

Figure 4 represents an elevational view, on an enlarged scale, showing one of the individual pieces cut from the strip of Figure 3, as it appears in spread-apart relationship.

Figure 5 represents a fragmentary elevational view, on a further enlarged scale, showing a portion of the upper selvage edge of the embodiment of Figure 4.

Figure 6 represents a view generally like that of Figure 5 but showing the appearance of the selvage edge after it has been shrunk by a heat-treatment.

Figure 7 represents a side elevational view of the embodiment of Figure 4 as it appears before the heat-treatment; the upper curve being somewhat exaggerated for clarity of illustration.

Figure 8 represents a view generally like that of Figure 7 but showing the appearance after the heat-treatment.

Figure 9 represents a perspective view of the embodiment of Figure 8.

Figure 10 represents a plan view generally like that of Figure 2 but showing a modified embodiment wherein Vinyon is used only for the upper selvage edge; the lower selvage edge being provided with an elastic thread or the like to give resilience.

Figure 11 represents a perspective view like that of Figure 9 but showing a hair-net constructed of the open-mesh material of Figure 10.

Figure 12 represents a side elevational view of a hair-net or wave-net embodying the present invention shown as it appears in use.

Figure 13 represents a plan view of a portion of an elongated strip of sheer open-mesh material having contracted areas of smaller-size openings at spaced intervals and having continuous upper and lower selvage edges formed of Vinyon or the like.

Figure 14 represents a more or less schematic fragmentary plan view on a further enlarged scale, showing the upper part of the body-portion and the upper selvage edge as they appear before the selvage edge is contracted under the action of heat.

Figure 15 represents a view generally like that of Figure 14 but showing the appearance of the upper portion of the strip after the selvage edge has been contracted under the influence of heat.

Figure 16 represents a perspective view of the final hair-net or wave-net indicating the manner in which the contracted mouth or head-opening is formed in part by the cut edges and in part by the heat-shrunk selvage edges of an individual length cut from the elongated strip of Figure 13.

Referring first to Figures 1–9 of the drawings, I have shown, in Figure 2, a strip of sheer open-mesh fabric consisting of a main body-portion 20 provided with a pair of opposite longitudinal selvage edges which, in the position in which the strip is shown in the drawings, appear as upper and lower selvage edges 21 and 22 respectively.

The main body-portion 20 is preferably a sheer open-mesh fabric of the type shown in my Patent 2,428,071 and is formed of courses of knitted loops which are fastened to adjoining courses at spaced intervals by floating inlay threads to give a series of generally diamond-shaped openings in what is commonly referred to as a Raschel construction. The main body-portion 20 may be formed of rayon or silk or cotton or nylon or any other suitable natural or synthetic yarn or thread.

The selvage edges 21 and 22 are of somewhat finer-mesh construction and are knitted into the main body-portion 20 at spaced itnervals in a manner well-known in the art; as for example in the manner disclosed in my Patent 2,104,538. The selvage edges 21 and 22 are formed of Vinyon which is a polyacrilonitrile resin sold commercially by The American Viscose Company.

The strip of open-mesh material is then formed into individual lengths by applying ribbon-like lengths of acetate Celluloid or other synthetic resin which are wrapped tightly around the length of open-mesh material at spaced intervals and are formed into encircling tubes or clips 23 as shown in Figure 3, the overlapping ends being interconnected by an appropriate solvent, employing heat and pressure (where the body of the hair-net is of nylon or the like, the clips 22 are also adhesively secured thereto by the action of the solvent in the manner disclosed more particularly in my co-epending application Serial No. 39,403, filed July 19, 1948), and by thereafter cutting along the lines A—A of Figure 3.

Instead of the fastening-clips 23, stitching can be employed to connect the ends of the selvage edges of the individual lengths in a manner well-known in the art.

Figures 4, 5 and 7 show the appearance of an individual piece of open-mesh material after the selvage edges have been interconnected by the fastening-clips but before there has been any heat-treating operation.

In Figure 7 the curve or bulge of the net has been somewhat exaggerated for clarity of illustration; the net being actually somewhat less cap-shaped (i. e. more nearly like the bunchy rope-like form of Figure 3).

The individual strips of Figures 4, 5 and 7 are then placed in a suitable heating oven and the strips are heated at about 150–200° F. for about 15–60 seconds to heat-set the threads of fibres of Vinyon.

During this heating operation, the Vinyon threads tend to contract to an appreciable extent. Thus, for example, where the original

length of each selvage edge is 18", the contracted length may be only 12". While there is some slight shrinkage of the nylon as well (where the body of the net is made of that material), it is so small with respect to the Vinyon shrinkage as to be unimportant.

The shrinkage of the Vinyon threads or yarn causes the selvage edges to contract in the manner indicated in Figure 6, thereby to form a smaller-diameter mouth or opening as indicated in Figures 8 and 9.

While I do not intend to be bound by this explanation, it appears that the excessive shrinking of the Vinyon is due to the fact that, when the polyacrylonitrile is formed into threads, it is spun from a bath (of tetramethylene sulfone or the like) under tension in order to orient the molecules and thereby to give a thread having satisfactory tensile strength. When the selvage edges are heated, the orientation is thus disturbed and the excessive shrinkage takes place.

After the hair-net is formed into its final structure as shown in Figure 9, a draw-string **24** is threaded through the lower selvage edge **22** so that it can be pulled tight and tied under the chin of the wearer, as indicated in Figure 1, so as further to assist in maintaining the hair-net in place.

The upper selvage edge **21** which passes across the forehead, as indicated in Figure 1, is comfortable and does not tend to bind or mark the forehead since it is not resilient.

In Figures 10 and 11 there is shown a modified embodiment wherein the lower selvage edge, instead of being constructed of Vinyon, as is the case with the upper selvage edge **21**, is formed in more or less conventional manner with an elastic thread **26**. The selvage edges **21** and **25** are fastened together at spaced intervals in a manner similar to that shown in Figure 3 after which individual strips are cut off as in Figure 4 and are heat-treated, in the manner described above, so as to shrink the upper selvage edge **21**; the final form being shown in Figure 11.

In this final form, the upper selvage edge is comfortable and does not tend to mark the forehead of the wearer since it is non-resilient whereas the lower selvage edge **25** gives the necessary resilience to maintain the hair-net in place without the need for a draw-string.

The main body-portion **20**, instead of being formed of knitted courses of loops, as shown in the drawings, may be formed of single or double yarns or threads twisted or knotted at spaced intervals to give diamond-shaped (or other polygonal-shaped) openings in a manner well-known in the art.

Referring now to Figures 12–16, I have shown, in Figure 13, a strip of sheer open-mesh fabric consisting of a main body-portion **120** provided with a pair of opposite longitudinal selvage edges which, in the position in which the strip is shown in the drawings, appear as upper and lower selvage edges **121** and **122** respectively.

The main body-portion **120** may be a sheer open-mesh fabric of the type shown in my Patent 2,428,071 and may be formed of courses of knitted loops which are fastened to adjoining courses at spaced intervals by floating inlay threads to give a series of generally diamond-shaped openings in what is commonly referred to as a Raschel construction. The main body-portion **120** may be formed of any suitable natural or synthetic textile yarn or thread, as for example rayon, nylon, silk, cotton, etc.

The selvage edges **121** and **122** are of generally the same construction as the main body-portion **120** and are knitted into the main body-portion at spaced intervals in a manner well-known in the art; as for example in the manner disclosed in my Patent 2,104,538. In the drawings, the construction of the selvage edges and the adjoining part of the body-portion are shown schematically with no attempt to show the actual configuration of the interconnecting loops and stitches, inasmuch as these are conventional and well-known in the art. The selvage edges, instead of having generally the same loop-formation as the main body-portion, may be formed with smaller openings giving a smaller mesh, as for example in the manner shown in my Patent 2,104,538.

The selvage edges **121** and **122** are formed of threads of polyacrylonitrile resin (as for example Vinyon as sold commercially by The American Viscose Company) or other appropriate synthetic resin which is capable of substantial contraction under the action of heat.

Instead of being formed of courses of knitted loops, the main body-portion **120** (and, optionally, also the selvage edges **121** and **122**) may be formed simply of double threads which are twisted and knotted together at appropriately spaced intervals so as to give diamond-shaped or hexagonal-shaped or other polygonal-shaped openings in a manner well known in the art. This double-thread construction is desirable in extremely lightweight hair-nets for daytime use (as distinguished from the stronger but relatively heavier and more conspicuous wave-nets or hair-nets for nighttime use).

At spaced intervals along the strip, the body-portion is formed with smaller-size openings to provide an appreciably contracted portion **120**—*a* having a considerably smaller transverse dimension than that of the main body-portion **120**. At either side of the portion **120**—*a*, it is possible to provide portions **120**—*b* which have openings of a size intermediate the small openings of portion **120**—*a* and the large openings of the portion **120**, thereby to give a more gradual transition intermediate the contracted portion **120**—*a* and the main portion **120**.

The upper and lower selvage edges **121** and **122** may similarly be provided with portions **121**—*a* and **122**—*a* having smaller-size openings and with portions **121**—*b* and **122**—*b* having intermediate-sized openings, as indicated particularly in Figure 13. The elongated strip is then formed into individual lengths by transversely cutting the contracted portions of the strip along the lines **123**; the individual lengths then having a more or less oval contour with the smaller ends formed by the contracted cut edges **124** and the larger top and bottom portions formed by the selvage edges **121** and **122**.

The individual lengths are then exposed to a live steam jet and heated at a temperature of about 150–212° F. for about 5–60 seconds, so as to heat-shrink the threads or fibres of the polyacrylonitrile resin in the selvage edges, in situ. While a live steam jet has been found particularly suitable in heat-shrinking the selvage edges as mentioned above, it is also possible to heat the individual lengths in other ways known in the art, as for example in any suitable heating oven or the like.

During this heating operation, the polyacrylonitrile resin threads tend to shrink to an appreciable extent, so as to contract the selvage edges from the confiiguration shown in Figure 14

to that shown in Figure 15. Thus, for example, where the original length of each selvage edge is 15", the contracted length may be 10" or less. While there may be some slight shrinkage of the body-portion as well (particularly where the body-portion is constructed of nylon or other like synthetic resin), this slight shrinkage is so small with respect to the shrinkage of the polyacrylonitrile resin as to be unimportant.

The shrinkage of the selvage edges causes them to contract in the manner indicated in Figure 16 so as to form a contracted mouth or head-opening defined in part by the contracted selvage edges and in part by the small-opening cut edges 124. It is obvious that the peripheral extent of the cut edges and the selvage edges can be varied in the zone of the head-opening. Thus, for example, by suitable changes in mesh-size, dimension, etc., the cut edges 124 can be made to define the major portion of the head-opening with the contracted selvage edges defining only relatively smaller portions, as distinguished from the embodiment shown in Figure 16 wherein the selvage edges define the larger portions of the head-opening.

The flexibility of the cut edges and the selvage edges and the deformability of the diamond-shaped (or other polygonal-shaped) structure defining the head-openings, provides a degree of stretchability which enables the hair-net to be slipped over the head of the wearer and thereafter to contract somewhat so as to fit snugly upon the head of the wearer and to resist any tendency to slip off or be displaced.

If desired, an elastic thread may be incorporated into the lower selvage edge to give increased stretchability, as in the embodiment of Figures 10–11. In such case, the elastic-containing selvage edge should not be positioned along the forehead of the wearer, to avoid binding or creasing of the forehead.

While four slight corners or projections are formed in the border of the final hair-net (corresponding to the juncture points of the cut edges and the selvage edges), this can be eliminated, if desired, by simply trimming or otherwise rounding them off.

The present invention may be embodied in other specific forms without departing from the spirit or essential attributes thereof, and it is therefore desired that the present embodiments be considered in all respects as illustrative and not restrictive, reference being had to the appended claims rather than to the foregoing description to indicate the scope of the invention.

Having thus described my invention, I claim as new and desire to protect by Letters Patent:

1. A hair-net having a sheer open-mesh body portion and having a pair of selvage edges connected at their ends to form a more or less continuous line defining a head-opening, at least one of said selvage edges being formed of polyacrylonitrile resin capable of shrinking appreciably under the action of heat which has been heat-shrunk to provide a reduced-size head opening, said heat-shrunk selvage edge being constructed and arranged to pass across the forehead of the wearer in a flexible but non-resilient manner so as to minimize discomfort and marking of the forehead.

2. A hair-net having a sheer open-mesh body portion and having a pair of selvage edges connected at their ends to form a more or less continuous line defining a head-opening, one of said selvage edges being formed of polyacrylonitrile resin capable of shrinking under the action of heat which has been heat-shrunk to provide a reduced-size head-opening, said heat-shrunk selvage edge being constructed and arranged to pass across the forehead of the wearer in a flexible but non-resilient manner so as to minimize discomfort and marking of the forehead, the other selvage edge being provided with a resilient thread of rubber or the like tending to contract the head-opening.

3. A hair-net having a sheer open-mesh body portion and having a pair of selvage edges connected at their ends to form a more or less continuous line defining a head-opening, one of said selvage edges being formed of polyacrylonitrile resin capable of shrinking under the action of heat which has been heat-shrunk to provide a reduced-size head-opening, said heat-shrunk selvage edge being constructed and arranged to pass across the forehead of the wearer in a flexible but non-resilient manner so as to minimize discomfort and marking of the forehead, the other selvage edge being provided with a draw-string constructed and arranged to be pulled tight and tied to fasten the hair-net in place.

4. A method of forming a hair-net which comprises the steps of forming a length of sheer open-mesh material with a pair of longitudinally extending selvage edges, at least one of said selvage edges being constructed of threads of polyacrylonitrile resin capable of shrinking appreciably under the action of heat, fastening the selvage edges at spaced intervals, cutting the strip into individual lengths wherein the selvage edges are connected at their ends to form a more or less continuous line defining a head-opening, and heat-treating said individual lengths to cause shrinkage of the polyacrylonitrile resin and thereby to contract the head-opening, said heat-shrunk polyacrylonitrile resin selvage edge being constructed and arranged to pass across the forehead of the wearer in a flexible but non-resilient manner so as to minimize discomfort and marking of the forehead.

5. A method of forming a hair-net which comprises the steps of forming a length of sheer open-mesh material with a pair of longitudinally extending selvage edges constructed of threads of polyacrylonitrile resin capable of shrinking appreciably under the action of heat, fastening the selvage edges at spaced intervals, cutting the strip into individual lengths wherein the selvage edges are connected at their ends to form a more or less continuous flexible but generally non-resilient line defining a head-opening, and heat-treating said individual lengths to cause shrinkage of the polyacrylonitrile resin and thereby to contract the head-opening, one of said polyacrylonitrile resin selvage edges being constructed and arranged to pass across the forehead of the wearer in a flexible but generally non-resilient manner so as to minimize discomfort and marking of the forehead.

6. A method of forming a hair-net which comprises the steps of forming a length of sheer open-mesh material with a pair of longitudinally extending selvage edges constructed of threads of polyacrylonitrile resin capable of shrinking appreciably under the action of heat, transversely cutting said length at spaced intervals to form individual strips, and heat-treating the individual strips to cause shrinkage and contraction of the polyacrylonitrile resin selvage edges and thereby to form a generally cap-shaped structure having a reduced-size head-opening.

7. A method of forming a hair-net which comprises the steps of forming a length of sheer open-mesh material with a pair of longitudinally extending selvage edges constructed of threads of polyacrylonitrile resin capable of shrinking appreciably under the action of heat, transversely cutting said length at spaced intervals to form individual strips, and heat-treating the polyacrylonitrile resin selvage edges of the strips thereby to cause them to shrink and contract so as to form a generally cap-shaped structure with a reduced-size head-opening.

8. A hair-net having a sheer open-mesh body portion and having a pair of selvage edges connected at their ends to form a more or less continuous line defining a head-opening, at least one of said selvage edges being formed of synthetic resin capable of shrinking under the action of heat to an appreciably greater extent than the remainder of said hair-net and which has been heat-shrunk to provide a reduced-size head-opening, said heat-shrunk selvage edge being constructed and arranged to pass across the forehead of the wearer in a flexible but non-resilient manner so as to minimize discomfort and marking of the forehead.

9. A hair-net having a sheer open-mesh body portion and having a pair of selvage edges connected at their ends to form a more or less continuous line defining a head-opening, one of said selvage edges being formed of synthetic resin capable of shrinking under the action of heat to an appreciably greater extent than the remainder of said hair-net and which has been heat-shrunk to provide a reduced-size head-opening, said heat-shrunk selvage edge being constructed and arranged to pass across the forehead of the wearer in a flexible but non-resilient manner so as to minimize discomfort and marking of the forehead, the other selvage edge being provided with a resilient thread of rubber or the like tending to contract the head-opening.

10. A method of forming a hair-net which comprises the steps of forming a length of sheer open-mesh material with a pair of selvage edges, at least one of said selvage edges being constructed of threads of synthetic resin capable of shrinking under the action of heat to an appreciably greater extent than the remainder of said open-mesh material, fastening the selvage edges at spaced intervals, cutting the strip into individual lengths wherein the selvage edges are connected at their ends to form a more or less continuous line defining a head-opening, and heat-treating said individual lengths to cause shrinkage of the aforesaid synthetic resin and thereby to contract the head-opening, said heat-shrunk synthetic resin selvage edge being constructed and arranged to pass across the forehead of the wearer in a flexible but non-resilient manner so as to minimize discomfort and marking of the forehead.

11. A method of forming a hair-net which comprises the steps of forming a length of sheer open-

mesh material with a pair of longitudinally extending selvage edges constructed of threads of synthetic resin capable of shrinking under the action of heat to an appreciably greater extent than the remainder of said open-mesh material, transversely cutting said length at spaced intervals to form individual strips, and heat-treating the individual strips to cause shrinkage and contraction of the synthetic resin selvage edges and thereby to form a generally cap-shaped structure having a reduced-size head-opening.

12. A hair-net having a sheer open-mesh body portion and having a contracted head-opening defined at least in part by a pair of selvage edges formed of polyacrylonitrile resin and having been heat-shrunk in-situ into a smaller-mesh than the body portion and being constructed and arranged to pass across the forehead of the wearer in a flexible but non-resilient manner so as to minimize discomfort and marking of the forehead.

13. A construction according to claim 12 wherein the head-opening is defined only in part by the selvage edges which are disposed in diametrically-opposed relationship to each other and wherein a substantial part of the head-opening is defined by a pair of cut-edges, each extending an appreciable distance intermediate the ends of the selvage edges, said cut-edges being of relatively contracted smaller-mesh construction than the remainder of the body-portion.

14. A construction according to claim 12 wherein the body-portion is formed from threads defining generally polygonal openings and wherein the head-opening is defined by a generally continuous and uninterrupted peripheral border of which the selvage edges form only part, the remainder of the border being formed by a pair of cut-edges disposed in alternating relationship to the selvage edges and extending an appreciable distance along said border, said cut-edges having a relatively contracted smaller-mesh construction than the remainder of the body-portion.

15. A method according to claim 11 wherein the length of open-mesh material is formed with relatively smaller-mesh laterally-contracted portions at longitudinally-spaced intervals, and wherein the length is transversely cut along said laterally-contracted portions to form the individual strips with smaller-mesh cut-edges, and wherein the heat-treating of the individual strips causes the head-opening to be formed by a generally continuous contracted peripheral border along which the selvage edges and the cut-edges extend an appreciable distance in alternating relationship to each other.

16. A method to claim 15 wherein intermediate-mesh areas formed on both sides of each smaller-mesh portion of said length.

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No references cited.