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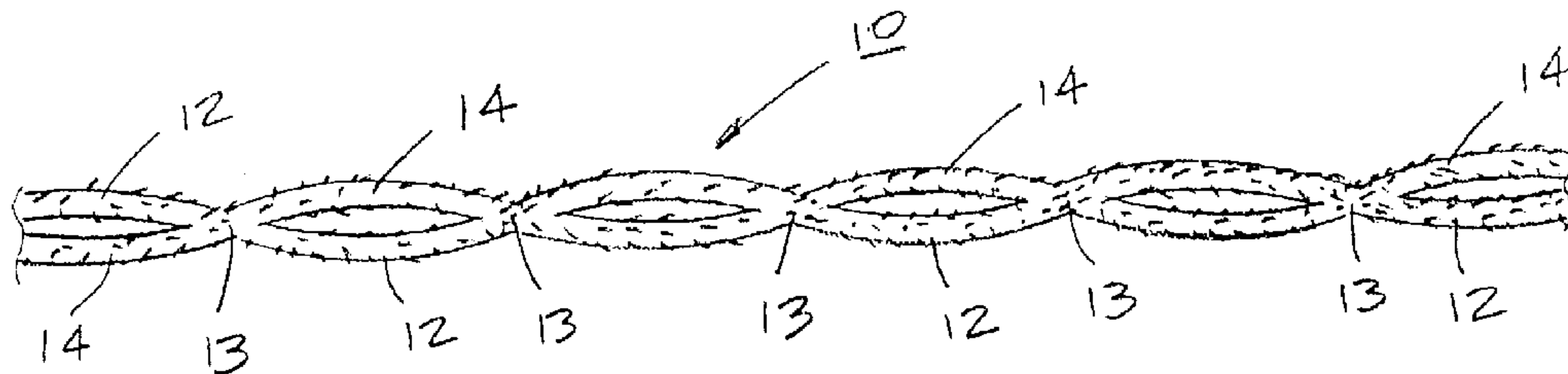
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(54) **FIL A PLUSIEURS ELEMENTS ET METHODE DE
FABRICATION**

(54) **MULTI-COMPONENT YARN AND METHOD OF MAKING THE
SAME**



(57) A non-metallic cut resistant combined yarn that can be combined with other yarns to form a composite yarn. The combined yarn includes at least one non-metallic strand of an inherently cut-resistant material and at least one non-metallic strand of a non-cut resistant material or fiberglass. The two strands are air interlaced with each other so as to form attachment points intermittently along the lengths of the strands. At least one or the other of the strands is a multi-filament strand. A composite yarn may be formed by wrapping at least one cover strand wrapped about the combined yarn in a first direction. A second cover strand may be wrapped about the combined yarn in a second direction opposite the first direction.

MULTI-COMPONENT YARN AND METHOD OF MAKING THE SAME**ABSTRACT**

A non-metallic cut resistant combined yarn that can be combined with other
5 yarns to form a composite yarn. The combined yarn includes at least one non-metallic
strand of an inherently cut-resistant material and at least one non-metallic strand of a
non-cut resistant material or fiberglass. The two strands are air interlaced with each
other so as to form attachment points intermittently along the lengths of the strands. At
least one or the other of the strands is a multi-filament strand. A composite yarn may be
10 formed by wrapping at least one cover strand wrapped about the combined yarn in a first
direction. A second cover strand may be wrapped about the combined yarn in a second
direction opposite the first direction.

MULTI-COMPONENT YARN AND METHOD OF MAKING THE SAME

1. Field of the Invention

The present invention relates to the field of non-metallic cut and abrasion resistant composite yarns and to more economically combine yarns for use in the manufacture of composite yarns, and more particularly to the application of air
10 intermingling technology to the manufacture of such combined yarns.

2. Background of the Invention

The present invention relates to composite yarns useful in the manufacture of various types of protective garments such as cut and puncture resistant gloves, aprons, and glove liners. It is well known in the art to manufacture such composite yarns by
15 combining yarns constructed of non-metallic, inherently cut-resistant materials using wrapping techniques. For example, these yarns may use a core construction comprising one or more strands that may be laid in parallel relationship or, alternatively, may include a first core strand that is overwrapped with one or more additional core strands. A representative sample of such yarns includes that disclosed in U.S. Patent Nos.
20 5,177,948; 5,628,172; 5,845,476; and 5,119,512. The composite yarns described above can be knit on standard glove-making machines with the choice of machine being dependent, in part, on the size of the yarn.

Wrapping techniques are expensive because they are relatively slow and often require that separate wrapping steps be made on separate machines with intermediate
25 wind up steps. Further, those techniques require an increased amount of yarn per unit length of finished product depending on the number of turns per inch used in the wrap.

Generally, the greater the number of turns per inch, the greater the expense associated with making the composite yarn. When the yarn being wrapped is high performance fiber, this cost may be high.

Knitted gloves constructed using a relatively high percentage of high performance fibers do not exhibit a soft hand and tend to be stiff. This characteristic is believed to result from the inherent stiffness of the high performance fibers. It follows that the tactile response and feedback for the wearer is reduced, which is highly undesirable, particularly since the gloves typically are used in meat-cutting operations around sharp blades.

It would be desirable to maximize these qualities in a cut-resistant and non-cut-resistant yarn strands using a different, less expensive and time consuming technique to create a single combined strand, while optimizing the properties of resultant yarns and products manufactured therefrom.

Summary of the Invention

The present invention provides novel cut-resistant combined yarns by intermittently air interlacing one or more strands of a cut resistant material with one or more strands of a non-cut resistant material or fiberglass. The resulting combined yarn is useful alone or with other yarns in manufacturing garments, such as gloves that have surprising softness, hand and tactile response.

The invention further relates to a method of making a non-metallic cut resistant combined yarn including the steps of feeding a plurality of yarn strands into a yarn air texturizing device strands to form attachment points intermittently along the lengths of the strands, wherein the plurality of strands includes:

- (i) at least one non-metallic strand comprised of an inherently cut resistant material;
- (ii) at least one non-metallic strand comprised of a non-cut resistant material or fiberglass; and
- 5 (iii) at least one of the strands being a multifilament strand.

The invention permits one of ordinary skill to take advantage of the ability of a non-cut resistant fiber strand and/or a fiberglass strand to provide support for a high performance, cut-resistant fiber without the need for expensive wrapping techniques. The air interlacing approach permits several strands of both cut resistant and non-cut resistant and/or fiberglass materials to be combined in a number of different combinations depending on the materials available and the desired characteristics of the finished product. This combination can be achieved using fewer manufacturing steps than would be required with the techniques applied thus far to the preparation composite, cut resistant yarns.

15 The two or more strands are air interlaced with each other to form a single combined strand or yarn having attachment points intermittently along the length of the single combined strand. The composite yarns of the invention can be used alone in the manufacture of items such as cut resistant garments, or can be combined with another parallel yarn during product manufacture. Alternatively, the combined yarns may be used as a core yarn in composite yarns, with a first cover strand wrapped about the combined strands in a first direction. A second cover strand may be provided wrapped about the first cover strand in a second direction opposite that of the first cover strand.

Processes involving treatment of yarns with air jets are well-known in the prior art. Some of these treatments are used to create textured yarns. The term "texturing" refers generally to a process of crimping, imparting random loops, or otherwise

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modifying continuous filament yarn to increase its cover, resilience, warmth, insulation, and/or moisture absorption. Further, texturing may provide a different surface texture to achieve decorative effects. Generally, this method involves leading yarn through a turbulent region of an air-jet at a rate faster than it is drawn off on the exit side of the jet, e.g., overfeeding. In one approach, the yarn structure is opened by the air-jet, loops are formed therein, and the structure is closed again on exiting the jet. Some loops may be locked inside the yarn and others may be locked on the surface of the yarn depending on a variety of process conditions and the structure of the air-jet texturizing equipment used. A typical air-jet texturizing devices and processes is disclosed in U.S. Patent 3,972,174.

Another type of air jet treatment has been used to compact multifilament yarns to improve their processibility. Flat multifilament yarns are subjected to a number of stresses during weaving operations. These stresses can destroy interfilament cohesion and can cause filament breakages. These breakages can lead to costly broken ends. Increasing interfilament cohesion has been addressed in the past by the use of adhesives such as sizes. However, air compaction has enabled textiles processors to avoid the cost and additional processing difficulties associated with the use of sizes. The use of air compaction for high strength and non-high strength yarns is disclosed in U.S. Patents 5,579,628 and 5,518,814. The end product of these processes typically exhibits some amount of twist.

Other prior art, such as U.S. Patents 3,824,776; 5,434,003 and 5,763,076, and earlier patents referenced therein, describe subjecting one or more moving multifilament yarns with minimal overfeed to a transverse air jet to form spaced, entangled sections or nodes that are separated by sections of substantially unentangled filaments. This intermittent entanglement imparts coherence to the yarn, avoiding the need for twisting

of the yarns. Yarns possessing these characteristics are sometimes referred to in the prior art as "entangled" yarns.

While intermittent air entanglement of multifilament yarns has been to impart yarn coherence, the application of this concept for interlacing dissimilar yarns including a cut resistant yarn component has not been recognized, nor has the resultant advantages and properties of combined yarns resulting from the application of this technology.

These and other aspects of the present invention will become apparent to those skilled in the art after a reading of the following description of the preferred embodiments when considered in conjunction with the drawings. It should be understood that both the foregoing general description and the following detailed description are exemplary and explanatory only and are not restrictive of the invention as claimed. The accompanying drawings, which are incorporated in and constitute a part of this specification, illustrate one embodiment of the invention and, together with the description, serve to explain the principles of the invention.

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Brief Description of the Drawings

The above and other objects, features, and advantages of the present invention will be more clearly understood from the following detailed description taken in conjunction with the accompanying drawings, in which:

FIGURE 1 is a schematic representation of the structure of the combined yarn of the present invention;

FIGURE 2 is an illustration of a preferred embodiment of a composite yarn in accordance with the principles of the present invention having a single core strand of a combined yarn and two cover strands;

FIGURE 3 is an illustration of an alternative embodiment of a composite yarn in accordance with the principles of the present invention having two core strands and two cover strands;

FIGURE 4 is an illustration of an alternative embodiment of a composite yarn in accordance with the principles of the present invention having a single core strand and a single cover strand; and

FIGURE 5 is an illustration of a protective garment, namely a glove, in accordance with the principles of the present invention.

10 **Detailed Description of the Preferred Embodiment**

The term “fiber” as used herein refers to a fundamental component used in the assembly of yarns and fabrics. Generally, a fiber is a component that has a length dimension that is much greater than its diameter or width. This term includes ribbon, strip, staple, and other forms of chopped, cut or discontinuous fiber and the like having a regular or irregular cross section. “Fiber” also includes a plurality of any one of the above or a combination of the above.

As used herein, the term “high performance fiber” means that class of fibers having high values of tenacity such that they lend themselves for applications where high abrasion and/or cut resistance is important. Typically, high performance fibers have a very high degree of molecular orientation and crystallinity in the final fiber structure.

The term “filament” as used herein refers to a fiber of indefinite or extreme length such as found naturally in silk. This term also refers to manufactured fibers produced by, among other things, extrusion processes. Individual filaments making up a fiber may have any one of a variety of cross sections to include round, serrated or crenular, bean-shaped or others.

The term "yarn" as used herein refers to a continuous strand of textile fibers, filaments or material in a form suitable for knitting, weaving, or otherwise intertwining to form a textile fabric. Yarn can occur in a variety of forms to include a spun yarn consisting of staple fibers usually bound together by twist; a multifilament yarn
5 consisting of many continuous filaments or strands; or a monofilament yarn that consists of a single strand.

The term "combined yarn" as used herein refers to a yarn that is comprised of a cut resistant strand combined with a non-cut resistant strand and/or a fiberglass strand at intermittent points by air entanglement of the strand components.

10 The term "composite yarn" as used herein refers to a yarn that is comprised of a core yarn wrapped with one or more cover yarns.

The term "air interlacing" as used herein refers to subjecting multiple strands of yarn to an air jet to combine the strands and thus form a single, intermittently commingled strand, i.e., a combined yarn. This treatment is sometimes referred to as
15 "air tacking." In "air interlacing" and the term is used herein, adjacent strands of a cut resistant yarn and a non-cut resistant yarn and/or fiberglass, at least one strand being a multifilament strand, are passed with minimal, i.e., less than 10% overfeed, through an entanglement zone in which a jet of air is intermittently directed across the zone, generally perpendicular to the path of the strands. As the air impinges on the adjacent
20 fiber strands, the strands are whipped about by the air jet and become intermingled or interlacing at spaced zones or nodes. The resulting combined yarn is characterized by spaced, air interlaced sections or nodes in which the fibers of the strands are interlaced or "tacked" together, separated by segments of non-interlaced adjacent fibers.

A combined yarn 10 according to the present invention is illustrated
25 schematically in Figure 1. The combined yarn can be used in combination with other

yarn strands to make a cut resistant composite yarn and includes at least one strand 12 comprised of an inherently cut resistant material and at least one strand 14 comprised of a non-cut resistant material or fiberglass. The cut resistant and non-cut resistant or fiberglass strands 12,14 are interlaced with each other to form attachment points 13
5 intermittently along the lengths of the single combined strand 10. Desirably, one or the other of the strands 12, 14 is a multi-filament strand. The strands 12, 14 may be air interlaced using well-known devices devised for that purpose. A suitable device includes the SlideJet –FT system with vortex chamber available from Heberlein Fiber Technology, Inc.

10 This device will accept multiple running yarn strands and expose the yarns to a plurality of air streams such that the filaments of the multifilament yarn(s) are uniformly intertwined with each other or with a twisted yarn over the length of the yarn. This treatment also causes intermittent interlacing of the yarn strands to form attachment
15 points between the yarn strands along their lengths. These attachment points, depending on the texturizing equipment and yarn strand combination used, are normally separated by length of non-interlaced strands having a length of between about 0.125 and about 1.00 inches. The number of yarn strands per unit length of a combined interlaced strand will vary depending on variables such as the number and composition of the yarn strands fed into the device. The practice of the present invention does not include the use of yarn
20 overfeed into the air interlacing device. The air pressure fed into the air-interlacing device should not be so high as to destroy the structure of any spun yarn used in the practice of the present invention.

The combined yarn illustrated in Figure 1 may be used alone or may be combined with other strands to create a variety of composite yarn structures. In the preferred
25 embodiment depicted in Figure 2, the composite yarn 20 includes combined yarn core

strand 22 formed as described above with respect to strand 10, overwrapped with a first cover strand 24. The cover strand 24 is wrapped in a first direction about the core strand 22. A second cover strand 26 is overwrapped about the first core strand 24 in a direction opposite to that of the first core strand 24. Either of the first cover strand 24 or second cover strand 26 may be wrapped at a rate between about 3 to 16 turns per inch with a rate between about 8 and 14 turns per inch being preferred. The number of turns per inch selected for a particular composite yarn will depend on a variety of factors including, but not limited to, the composition and denier of the strands, the type of winding equipment that will be used to make the composite yarn, and the end use of the articles made from the composite yarn.

Turning to Figure 3, an alternative composite yarn 30 includes a first combined yarn core strand 32 made in accordance with the description of yarn strand 10 in Figure 1, laid parallel with a second core strand 34. This two-strand core structure is overwrapped with a first cover strand 36 in a first direction, which may be clock-wise or counter clock-wise. Alternatively, the composite yarn 30 may include a second cover strand 38 overwrapped about the first cover strand 36 in a direction opposite to that of the first cover strand 36. The selection of the turns per inch for each of the first and second cover strands 36, 38 may be selected using the same criteria described for the composite yarn illustrated in Figure 2.

An alternative embodiment 40 is illustrated in Figure 4. This embodiment includes a composite yarn core strand 42 (like 22 or 32), that has been wrapped with a single cover strand 44. This cover strand is wrapped about the core at a rate between about 8 and 16 turns per inch. The rate will vary depending on the denier of the core and cover strands and the material from which they are constructed. It will be readily apparent that a large number of core cover combinations may be made depending on the

yarn available, the characteristics desired in the finished goods, and the processing equipment available. For example, more than two strands may be provided in the core construction and more than two cover strands can be provided.

The inherently cut resistant strand 12 illustrated in Figure 1 may be constructed
5 from any high performance fiber well known in the art. These fibers include, but are not limited to an extended-chain polyolefin, preferably an extended-chain polyethylene (sometimes referred to as "ultrahigh molecular weight polyethylene"), such as Spectra[®] fiber manufactured by Allied Signal; an aramid, such as Kevlar[®] fiber manufactured by DuPont De Nemours; and a liquid crystal polymer fiber such as Vectran[®] fiber
10 manufactured by Hoescht Celanese. Another suitable inherently cut resistant fiber includes Certran[®] M available from Hoescht Celanese. These and other cut resistant fibers may be supplied in either continuous multi-filament form or as a spun yarn. Generally, it is believed that these yarns may exhibit better cut resistance when used in continuous, multi-filament form.

15 The denier of the inherently cut resistant strand used to make the multi-part yarn component 10 may be any of the commercially available deniers within the range between about 70 and 1200, with a denier between about 200 and 700 being preferred.

The non-cut resistant strand 14 may be constructed from one of a variety of available natural and man made fibers. These include polyester, nylon, acetate, rayon,
20 cotton, polyester-cotton blends, and/or fiberglass. The manmade fibers in this group may be supplied in either continuous, multi-filament form or in spun form. The denier of these yarns may be any one of the commercially available sizes between about 70 and 1200 denier, with a denier between about 140 and 300 being preferred.

The cover strands in the embodiments depicted in Figs. 2 - 4 above may be
25 comprised of either an inherently cut resistant material along with a non-cut resistant

material, fiberglass, or combinations thereof depending on the particular application. For example in the embodiments having two cover strands, the first cover strand may be comprised of an inherently cut resistant material and the second cover strand may be comprised of a non-cut resistant material such as nylon or polyester. This arrangement
5 permits the yarn to be dyed or to make a yarn that will create particular hand characteristics in a finished article.

A fiberglass strand or strands may be included in the composite yarn. The fiberglass may be either E-glass or S-glass of either continuous filament or spun construction. Preferably the fiberglass strand has a denier of between about 200 and
10 about 2,000. Fiberglass fibers of this type are manufactured both by Corning and by PPG and are characterized by various properties such as relatively high tenacity of about 12 to about 20 grams per denier, and by resistance to most acids and alkalies, by being unaffected by bleaches and solvents, and by resistance to environmental conditions such as mildew and sunlight and highly resistant to abrasion and aging. The practice of the
15 present invention contemplates using several different sizes of commonly available fiberglass strands, as illustrated in Table 1 below:

Table 1

Standard Fiberglass Sizes

Fiberglass Size	Approximate Denier
G-450	99.21
D-225	198.0
G-150	297.6
G-75	595.27
G-50	892.90
G-37	1206.62

The size designations in the Table are well known in the art to specify fiberglass strands. These fiberglass strands may be used singly or in combination depending on the particular application for the finished article. By way of non-limiting example, if a total denier of about 200 is desired for the fiberglass component of the core, either a single D-225 or two G-450 strands may be used. Suitable fiberglass strands are available from Owens-Corning and from PPG Industries.

Thus, the product of the invention may be 1) combined yarn, 2) a composite yarn formed by overwrapping the combined yarn, or 3) a composite yarn formed by joining adjacent strands of a combined yarn with another yarn. In either instance the overall denier of the yarn will normally be from about 215 to about 2400 denier, and preferably will be about 1200 denier or less, if the yarn is to be used as a knitting yarn on conventional glove knitting machines.

Table 2 below illustrates exemplary combinations of cut resistant and non-cut resistant yarns joined by an air intermingling process. Each of the examples in Table 2 was prepared using the Heberlein SlideJet-FT 15 using a P312 head. The SlideJet unit is supplied air at a pressure between about 30 and 80 psi, with an air pressure between about 40 and 50 psi being preferred. Preferably, the air supply has an oil content less than 2 ppm, and desirably, is oil-free. The terminology “__X” in the description of the

yarn components refers to the number of strands of a particular component used to create a particular example. The "Comments" column shows the approximate size knitting machine on which a particular example may be knitted. It will be readily understood that two smaller sized yarn strands from Table 2 below may be feed in tandem to a knitting machine in place of a larger yarn.

Table 2

Interlaced Yarn Embodiments

Exp	No. Strands	Yarn Components	Comments
1	5	225 Fiberglass 375 denier Spectra fiber 3X 36/1 Spun Polyester (148 denier)	7 gauge knitting machine
2	4	225 Fiberglass 375 denier Spectra fiber 2X 36/1 Polyester (148 denier)	7 gauge knitting machine
3	3	225 Fiberglass 375 denier Spectra fiber 1X 36/1 Polyester (148 denier)	7 gauge knitting machine
4	3	450 Fiberglass 200 denier Spectra fiber 1X 70/1 Textured Polyester (148 denier)	10-13 gauge knitting machine
5	3	225 Fiberglass 375 denier Spectra fiber 1X Textured Polyester (150 denier)	10-13 gauge knitting machine
6	4	225 Fiberglass 375 denier Spectra fiber 2X Textured Polyester (150 denier)	13 gauge knitting machine
7	4	225 Fiberglass 650 denier Spectra fiber 2X Textured Polyester (150 denier)	10-13 gauge knitting machine
8	4	225 Fiberglass 200 denier Kevlar fiber __X Textured Polyester (150 denier)	10-13 gauge knitting machine
9	4	225 Fiberglass 400 denier Kevlar fiber __X Textured Polyester (150 denier)	7-10 gauge knitting machine

Each of the embodiments illustrated above includes at least one cut-resistant strand, at least one fiberglass strand and at least one non-cut resistant strand. The

fiberglass strand provides a cushioning effect that enhances the cut resistance of the high performance fiber. Advantageously, this effect is achieved without the time and expense of wrapping the high performance fiber around the fiberglass strands.

5 It has been observed that the air stream used to interlace the individual composite
yarn components do not damage the fiberglass strands in the examples above. The
fiberglass strands break under the force of the impinging air stream without the presence
of the additional non-fiberglass strand or strands which promote the interlacing action.
Typically, the brittle fiberglass strands have been used in parallel with other strands but
without any engagement between the fiberglass strands and the other strand. It should
10 also be noted that fiberglass has not been used successfully as a wrap strand. This is
because the brittle glass fibers cannot undergo the bending experienced in known glove
making equipment without first being wrapped or somehow protected with another yarn.
The present invention offers a cost saving method for incorporating a fiberglass strand
into a composite yarn structure without the need for such protection.

15 The following examples demonstrate the variety of the composite yarns that may
be constructed using the combined yarn components of Table 2. The combined yarn is
used as a core strand in each example. The specific composite yarn components
illustrate the invention in an exemplary fashion and should not be construed as limiting
the scope of the invention.

Table 3

Composite Yarn Examples

Exp	Interlaced Strand Core	First Cover	Second Cover
10	Exp 4	Poly 150 den	Poly 150 den
10A	Exp 4	Poly 70 den	Poly 150 den
11	Exp 5	Poly 70 den	Poly 70 den
11A	Exp 5	Spectra 200 den	Nylon 840 den
12	Exp 6	Spectra 200 den	Spectra 200 den
12A	Exp 6	Spectra 375 den	Nylon 500 den
13	Exp 7	Spectra 650 den	Spectra 650 den
13A	Exp 7	Spectra 375 den	Spectra 1000 den
14	Exp 5	Spectra 375 den	Cotton 5/1 den
14A	Exp 5	Spectra 200 den	Spectra 200 den
15	Exp 2	Poly 36/1 spun	Poly 36/1 spun
15A	Exp 2	Poly 150 den	Poly 150 den
16	Exp 3	Nylon 70 den	Nylon 70 den
16A	Exp 3	Nylon 840 den	Nylon 840 den

5 In each of examples 10-16A an additional core strand may be incorporated into the yarn structure. The selection of the material and size of the second core strand will

vary depending on the characteristics desired in the finished composite yarn. Suitable strands include, but are not limited to any strand known for use in the core of a cut-resistant composite yarn.

The combined yarns of the present invention may be created without using a fiberglass strand. Table 4 below illustrates additional embodiments of the air interlaced yarn that have been created using this approach:

Table 4
Interlaced Yarn Embodiments

Exp	No. Strands	Yarn Components	Comments
17	3	375 denier Spectra fiber 2X 28/1 Acrylic (189.9 denier)	7 gauge knitting machine
18	3	650 denier Spectra fiber 2X 20/1 Spun Polyester (265.7 denier)	7 gauge knitting machine
19	3	650 denier Spectra fiber 2X 150 Textured Polyester (150 denier)	7 gauge knitting machine
20	3	200 denier Kevlar fiber 2X 150 Textured Polyester (150 denier)	10 gauge knitting machine
21	3	400 denier Kevlar fiber 2X 150 Textured Polyester (150 denier)	7 or to gauge knitting machine

10 In example 17 the acrylic strands perform the same function as that of the fiberglass strand in the examples in Table 2. Like the fiberglass, the acrylic provides a soft support surface for the high performance fiber thus making it more difficult to cut the high performance fiber. However, unlike the fiberglass, the acrylic and polyester components are not brittle and stand up to the interlacing air stream without damage.

15 Each of the Table 4 examples may be provided with a single strand or multiple-strand cover in similar fashion to the examples given in Table 3. In a preferred embodiment the multiple strand cover includes a bottom or first cover strand comprised of a 650 denier Spectra fiber and a top or second cover strand comprised of a 1000 denier

polyester strand. Other cover strand arrangements may be used depending on the end use application of the yarn and the desired characteristics for the completed yarn.

Combined yarns of the present invention may also be created by interlacing a cut-resistant strand with a fiberglass strand. The resultant combined yarn can then be joined
5 with one or more additional yarn ends, e.g., non-cut resistant polyester yarns, during knitting. Table 5 below, illustrates additional embodiments of combined yarns that have been created using this approach, all of which can be run on a seven gauge knitting machine:

Table 5

Interlaced Yarn Embodiments

Exp	No. Strands	Yarn Components
22	2	650 denier Spectra fiber 75 Fiberglass
23	2	375 denier Spectra fiber 225 Fiberglass
24	2	215 denier Spectra fiber 450 Fiberglass
25	2	600 denier Kevlar fiber 75 Fiberglass
26	2	375 denier Spectra fiber 150 Fiberglass
27	2	650 denier Spectra fiber 150 Fiberglass
28	2	650 denier Spectra fiber 50 Fiberglass
29	2	650 denier Spectra fiber 37 Fiberglass
30	2	1200 denier Spectra fiber 75 Fiberglass
31	2	1200 denier Spectra fiber 50 Fiberglass
32	2	1200 denier Spectra fiber 37 Fiberglass
33	2	215 denier Spectra fiber 450 Fiberglass
34	2	600 denier Spectra fiber 75 Fiberglass

5 Turning now to Fig. 5, a glove 60 constructed according to the present invention is illustrated. Surprisingly, it has been found that knit gloves incorporating the interlaced yarn of the present are more flexible and provide better tactile response to the wearer while providing similar levels of cut resistance performance. This unexpected performance is believed to stem from the fact that the air interlacing approach eliminates

10 a wrapping step that may add stiffness to the finished composite yarn. Tables 6 and 7

below compare to a glove made using the overwrapping technique (Glove I) with gloves made with the yarn of the present invention (Glove II).

Table 6 describes the composite yarn construction used in each glove. The core of the yarn in Glove I was made using three substantially parallel strands. These core strands were wrapped with a first cover strand and a second cover strand. The core of Glove II was made using a composite yarn component air tacked according to the present invention. Table 7 compares the gloves based on softness, hand, and tactile response. The term "tactile response" refers to the feedback provided to the wearer when grasping and manipulating small objects. Each characteristic has been assigned a ranking of 1-5 with 1 being unacceptable and 5 being excellent.

Table 6

Glove Construction

	Core	Bottom Cover	Top Cover
Glove I	650 den Spectra Fiber 150 den textured polyester 225 Fiberglass	150/36 Polyester	36/1 Spun Polyester
Glove II	450 FG 650 den Spectra Fiber	150/1 Polyester	36/1 Polyester

15

Table 7

Glove Comparison

	Softness	Hand	Tactile Response
Glove I	2	2	2
Glove II	5	5	4

20

It can be seen that the interlaced yarn of the present invention provides improved performance compared to prior art gloves. This result is obtained even though the interlaced yarn is used only in the core of a composite construction and is wrapped with additional yarn strands.

In an alternative embodiment, the combined yarn may be used alone to fabricate a cut resistant garment. A glove was knitted on a Shima knitting machine using a yarn constructed according to the present invention. The knitability of the yarn was acceptable and it is believed that the yarn will provide acceptable cut resistance performance. However, the resulting glove had a "hairy" exterior appearance. It is believed that this result was caused by the exposed fiberglass content of the yarn. While this glove is believed to provide acceptable cut-resistance performance, customers may find the exterior appearance less than desirable. The addition of at least one cover strand will address this appearance. It is expected that embodiments such as those in Examples 17-21 will provide more acceptable results from an appearance standpoint without the need for a cover strand.

In yet another alternative embodiment, the combined yarn of the present invention may be used as a wrapping strand in a composite yarn construction. These results are unexpected for those examples containing fiberglass, as yarn strands made from fiberglass are believed to be unsuitable for wrapping. Use of the air interlacing technique permits the incorporation of fiberglass in a wrapping strand. Desirably, wrapping strands including fiberglass according to the present invention will be covered with an additional strand.

Although the present invention has been described with preferred embodiments, it is to be understood that modifications and variations may be utilized without departing from the spirit and scope of this invention, as those skilled in the art will readily understand. Such modifications and variations are considered to be within the purview and scope of the appended claims and their equivalents.

What is claimed is:

1. A combined yarn comprised of:
 - a) a first non-metallic strand of a cut resistant material; and
 - b) a second non-metallic strand of a non-cut resistant material,
- 5 said first and second strands being air interlaced with each other at intermittent points along the lengths of said strands, at least one of said strands being a multifilament strand.
2. The yarn of claim 1, further including a third strand of a fiberglass air interlaced with said first and second strands.
3. The yarn of claim 1, wherein said first strand is of a material selected
 - 10 from the group consisting of ultrahigh molecular weight polyethylene, aramids, and high strength liquid crystal polymers.
4. The yarn of claim 1, wherein said second strand is of a material selected from the group consisting of polyester, nylon, acetate, rayon, and cotton.
5. The yarn of claim 1, wherein said intermittent points are spaced from
 - 15 between about 0.125 to about 1.000 inch apart.
6. The yarn of claim 1, wherein each of said first and second strands have a denier of from about 70 to about 1200.
7. The yarn of claim 2, wherein said fiberglass has a denier of from about
 - 200 to about 2,000.
8. A combined yarn comprised of:
 - a) a first non-metallic strand of a cut resistant material; and
 - b) a second non-metallic strand of fiberglass,

said first and second strands being air interlaced with each other at intermittent points along the lengths of said strands, at least one of said strands being a multifilament strand.

9. The yarn of claim 8, wherein said first strand is of a material selected from the group consisting of ultrahigh molecular weight polyethylene, aramids, and high strength liquid crystal polymers.

10. The yarn of claim 8, wherein said intermittent points are spaced from
5 between about 0.125 to about 1.000 inch apart.

11. The yarn of claim 8, wherein each of said first strand has a denier of from about 70 to about 1200.

12. The yarn of claim 8, wherein said fiberglass has a denier of from about
200 to about 2,000.

10 13. A cut resistant composite yarn comprised of:

a) a core yarn including

i. first non-metallic strand of a cut resistant material; and

ii) a second non-metallic strand of a non-cut resistant material,

said first and second strands being air interlaced with each other at

15 intermittent points along the lengths of said strands, at least one of said strands being a multifilament strand; and

b) a first cover yarn wrapped around said core yarn in a given direction.

14. The composite yarn of claim 13, wherein said core yarn further including
a third strand of a fiberglass air interlaced with said first and second strands.

20 15. The yarn of claim 13, wherein said first strand is of a material selected from the group consisting of ultrahigh molecular weight polyethylene, aramids, and high strength liquid crystal polymers.

16. The yarn of claim 13, wherein said second strand is of a material selected from the group consisting of polyester, nylon, acetate, rayon, and cotton.

17. The yarn of claim 13, wherein each of said first and second strands have a denier of from about 70 to about 1200.

18. The yarn of claim 13, wherein said fiberglass has a denier of from about 200 to about 2,000.

5 19. The yarn of claim 13, wherein said first cover yarn is of a material selected from the group consisting of ultrahigh molecular weight polyethylene, aramids, high strength liquid crystal polymers, polyesters, nylon, acetate, rayon, cotton, polyolefins, and fiberglass.

10 20. The yarn of claim 13, further including a second cover yarn wrapped around said core yarn in the opposite direction from said first cover yarn.

21. The yarn of claim 13, wherein said second cover yarn is of a material selected from the group consisting of ultrahigh molecular weight polyethylene, aramids, high strength liquid crystal polymers, polyesters, nylon, acetate, rayon, cotton, polyolefins, and fiberglass.

15 22. A cut resistant composite yarn comprised of:

a) a core yarn including

i.) first non-metallic strand of a cut resistant material; and

ii) a second non-metallic strand of fiberglass,

20 said first and second strands being air interlaced with each other at intermittent points along the lengths of said strands, at least one of said strands being a multifilament strand; and

b) a first cover yarn wrapped around said core yarn in a given direction.

25 23. The yarn of claim 22, wherein said first strand is of a material selected from the group consisting of ultrahigh molecular weight polyethylene, aramids, and high strength liquid crystal polymers.

24. The yarn of claim 22, wherein said cover yarn is of a material selected from the group consisting of ultrahigh molecular weight polyethylene, aramids, high strength liquid crystal polymers, polyesters, nylon, acetate, rayon, cotton, polyolefins, and fiberglass.

5 25. The yarn of claim 22, further including a second cover yarn wrapped around said core yarn in the opposite direction from said first cover yarn.

26. The yarn of claim 22, wherein said second cover yarn is of a material selected from the group consisting of ultrahigh molecular weight polyethylene, aramids, high strength liquid crystal polymers, polyester, nylon, acetate, rayon, cotton,
10 polyolefins, and fiberglass.

27. A method of manufacturing a cut resistant yarn comprising:

- a) positioning a first non-metallic strand of a cut resistant material adjacent a second non-metallic strand of a non-cut resistant material or fiberglass, at least one of said strands being of a multi-filament material; and
15 b) impinging an air jet against said strands at intermittent points to interlace said strands, forming a combined yarn.

28. The method of claim 27, wherein said first strand is of a material selected from the group consisting of ultrahigh molecular weight polyethylene, aramids, and high strength liquid crystal polymers.

20 29. The method of claim 27, wherein said second strand is of a material selected from the group consisting of polyester, nylon, acetate, rayon, cotton, and polyolefins.

30. The method of claim 27, wherein said intermittent points are spaced from between about 0.125 to about 1.000 inch apart.

31. The method of claim 27, further including the step of wrapping a first cover yarn in a first direction around said combined yarn.

32. The method of claim 27, wherein said first cover yarn is of a material selected from the group consisting of ultrahigh molecular weight polyethylene, aramids, high strength liquid crystal polymers, polyester, nylon, acetate, rayon, cotton, polyolefins, and fiberglass.

33. The method of claim 31, further including the step of wrapping a second cover yarn around said combined yarn in a direction opposite from said first cover yarn.

34. The method of claim 33, wherein said second cover yarn is of a material selected from the group consisting of ultrahigh molecular weight polyethylene, aramids, high strength liquid crystal polymers, polyester, nylon, acetate, rayon, cotton, polyolefins, and fiberglass.

35. A cut resistant garment constructed of a combined yarn comprised of:

- a) a first non-metallic strand of a cut resistant material; and
- b) a second non-metallic strand of a non-cut resistant material or fiberglass, said first and second strands being air interlaced with each other at intermittent points along the lengths of said strands, at least one of said strands being a multifilament strand.

36. The garment of claim 35, wherein said second strand is fiberglass, and said yarn further including a third strand of fiberglass air interlaced with said first and second strands.

37. The garment of claim 35, wherein said first strand is of a material selected from the group consisting of ultrahigh molecular weight polyethylene, aramids, and high strength liquid crystal polymers.

38. The garment of claim 35, wherein said second strand is of a material selected from the group consisting of polyester, nylon, acetate, rayon, and cotton.

39. The garment of claim 35, wherein said intermittent points are spaced from between about 0.125 to about 1.000 inch apart.

40. The garment of claim 35, wherein each of said first and second strands have a denier of from about 70 to about 1200.

5 41. The garment of claim 35, wherein said garment is a glove.

42. A non-metallic multipart yarn component for use in combination with other yarn strands to make a cut resistant composite yarn comprising:

a. at least one strand comprised of a cut resistant material;

5 b. at least one fiberglass strand;

c. an least one additional non-fiberglass strand

d. wherein said at least one cut resistant strand said at least one fiberglass strand and said at least one additional fiberglass strand are air interlaced with each other to form a single combined strand and

10 e. wherein one or the other of said cut resistant or fiberglass strands is a multifilament strand.

43. The yarn component of claim 42 further comprising a first cover strand wrapped about said single combined strand in a first direction.

15 44. The yarn component of claim 43 further comprising a second cover strand wrapped about said single combined strand in a second direction opposite the first direction.

20 45. The yarn component of claim 42 wherein said at least one additional non-fiberglass strand is comprised of a spun yarn.

46. The yarn component of claim 42 wherein said at least one additional non-fiberglass strand is comprised of a textured multifilament yarn.

25 47. The yarn component of claim 42 wherein said cut resistant strand has a denier between about 70 and about 1200.

48. The yarn component of claim 42 wherein said cut resistant strand has a denier between about 200 and about 700.

30 49. The yarn component of claim 42 wherein said fiberglass strand has a denier between about 100 and about 1200.

50. The yarn component of claim 42 wherein said fiberglass strand has a denier between about 100 and 300.

51. The yarn component of claim 42 wherein said non-cut resistant material is comprised of a material selected from the group consisting of polyester, nylon, acetate, rayon, cotton, and polyester-cotton blend.

52. The yarn component of claim 42 wherein said cut resistant material is comprised of a material selected from the group consisting of ultra high molecular weight polyethylene, aramid, and liquid crystal polymer.

53. A non-metallic multipart yarn component for use in combination with other yarn strands to make a cut resistant composite yarn comprising:

- a. at least one strand comprised of a cut resistant material;
- b. at least one non-fiberglass strand;
- c. wherein said at least one cut resistant strand and said at least one non-fiberglass strand are air interlaced with each other to form a single combined strand and
- d. wherein one or the other of said cut resistant or non-fiberglass strands is a multifilament strand.

54. The yarn component of claim 53 further comprising a first cover strand wrapped about said single combined strand in a first direction.

55. The yarn component of claim 54 further comprising a second cover strand wrapped about said single combined strand in a second direction opposite the first direction.

56. The yarn component of claim 42 wherein said at least one non-fiberglass strand is comprised of a spun yarn.

57. The yarn component of claim 53 wherein said cut resistant strand has a denier between about 70 and about 1200.

58. The yarn component of claim 53 wherein said cut resistant strand has a denier between about 200 and about 700.

59. The yarn component of claim 53 wherein said non-cut resistant strand has a denier between about 70 and about 1200.

5 60. The yarn component of claim 53 wherein said non-cut resistant strand has a denier between about 140 and 300.

61. The yarn component of claim 53 wherein said non-cut resistant material is comprised of a material selected from the group consisting of polyester, nylon, acetate, rayon, 10 cotton, and polyester-cotton blend.

62. The yarn component of claim 53 wherein said cut resistant material is comprised of a material selected from the group consisting of ultra high molecular weight polyethylene, aramid, and liquid crystal polymer.

15

63. A non-metallic, cut resistant, composite yarn comprising:

a. a multi-part first core strand including

i. a strand comprised of a cut resistant material and having a denier between about 70 and 1200; and

20 ii. a strand comprised of a non-cut resistant material and having a denier between about 70 and 1200;

iii. wherein said cut resistant and non-cut resistant strands are air interlaced with each other so as to form attachment points intermittently along the lengths of said strands and wherein at least one of said strands is a multifilament strand; and

25

b. at least one cover strand wrapped about said multi-part first core strand in a first direction.

64. The composite yarn of claim 63 further comprising a second core strand 30 alongside said multipart first core strand.

65. The composite yarn of claim 63 wherein said cut resistant strand has a denier between about 200 and 700.

66. The composite yarn of claim 63 wherein said non-cut resistant strand has a denier between about 140 and 300.

67. The composite yarn of claim 63 wherein said strand comprised of a cut resistant material is comprised of a material selected from the group consisting of ultra high molecular weight polyethylene, aramids, and high strength liquid crystal polymers.

68. The composite yarn of claim 63 wherein said non-cut resistant strand is comprised of a material selected from the group consisting of polyester, cotton, polyester-cotton blend, nylon, acetate, and rayon.

69. The composite yarn of claim 63 wherein said at least one cover strand is comprised of a material selected from the group consisting of high molecular weight polyethylene, aramids, liquid crystal polymers, polyester, cotton, polyester-cotton blend, nylon, acetate, and rayon.

70. The composite yarn of claim 63 wherein said at least one cover strand is wrapped about said air interlaced cut resistant and non-cut resistant strands at between about 3 and 16 turns per inch.

71. The composite yarn of claim 63 wherein said at least one cover strand is wrapped about said air interlaced cut resistant and non-cut resistant strands at between about 8 and 14 turns per inch.

72. The composite yarn of claim 63 further comprising a second cover strand wrapped about said first cover strand in a second direction opposite that of the first cover strand.

73. The composite yarn of claim 72 wherein said second cover strand is comprised of a material selected from the group consisting of extended chain polyethylene, aramids, liquid crystal polymers, polyester, cotton, polyester-cotton blend, nylon, acetate, and rayon.

74. The composite yarn of claim 72 wherein said second cover strand is wrapped about said at least one cover strand at between about 3 and 16 turns per inch.

75. The composite of claim 72 wherein said second cover strand is wrapped about said at least one cover strand at between about 8 and 14 turns per inch.

5 76. A method of making a non-metallic cut resistant composite yarn comprising:

a. feeding a plurality of yarn strands into a yarn air interlacing device

wherein said plurality of strands includes

(i) at least one non-metallic strand comprised of an inherently cut resistant material,

10 (ii) at least one fiberglass strand,

(iii) at least one non-fiberglass strand comprised of a non-cut resistant material; and

b. air interlacing said plurality of yarn strands so as to form attachment points intermittently along the lengths of said strands; and

15 c. wherein at least one of said plurality of yarn strands is a multi filament strand.

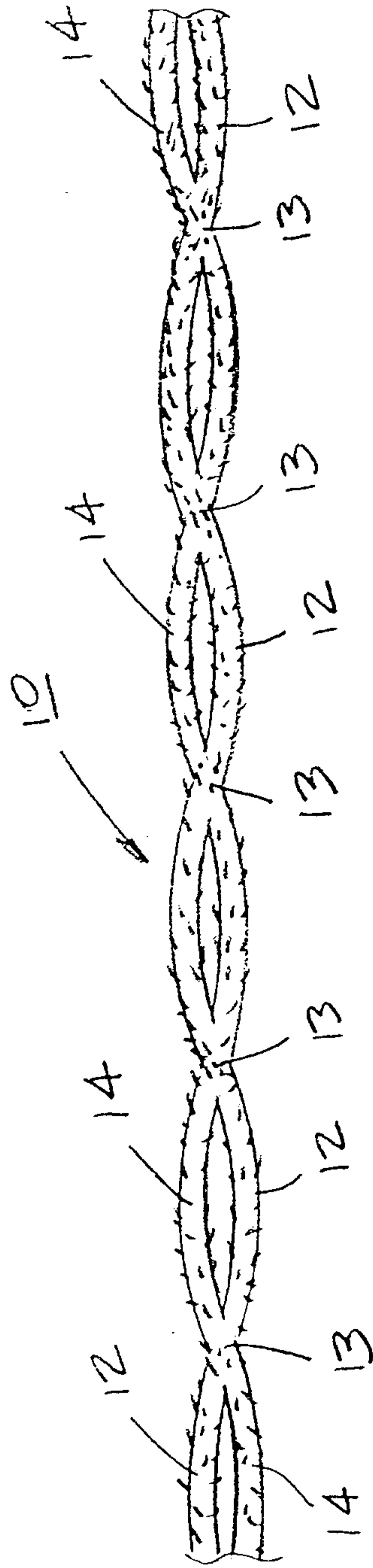


FIG.1

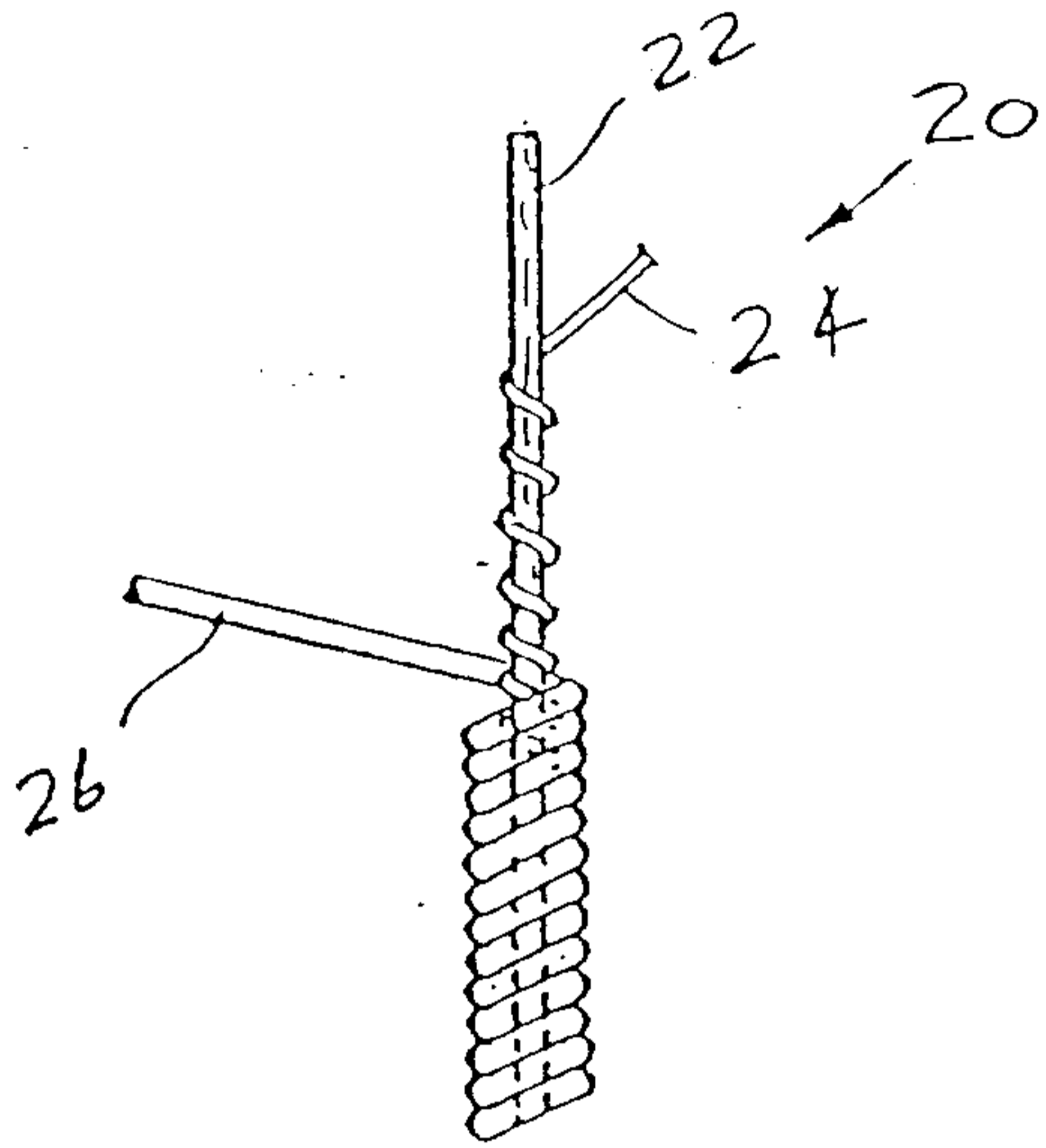


FIG. 2

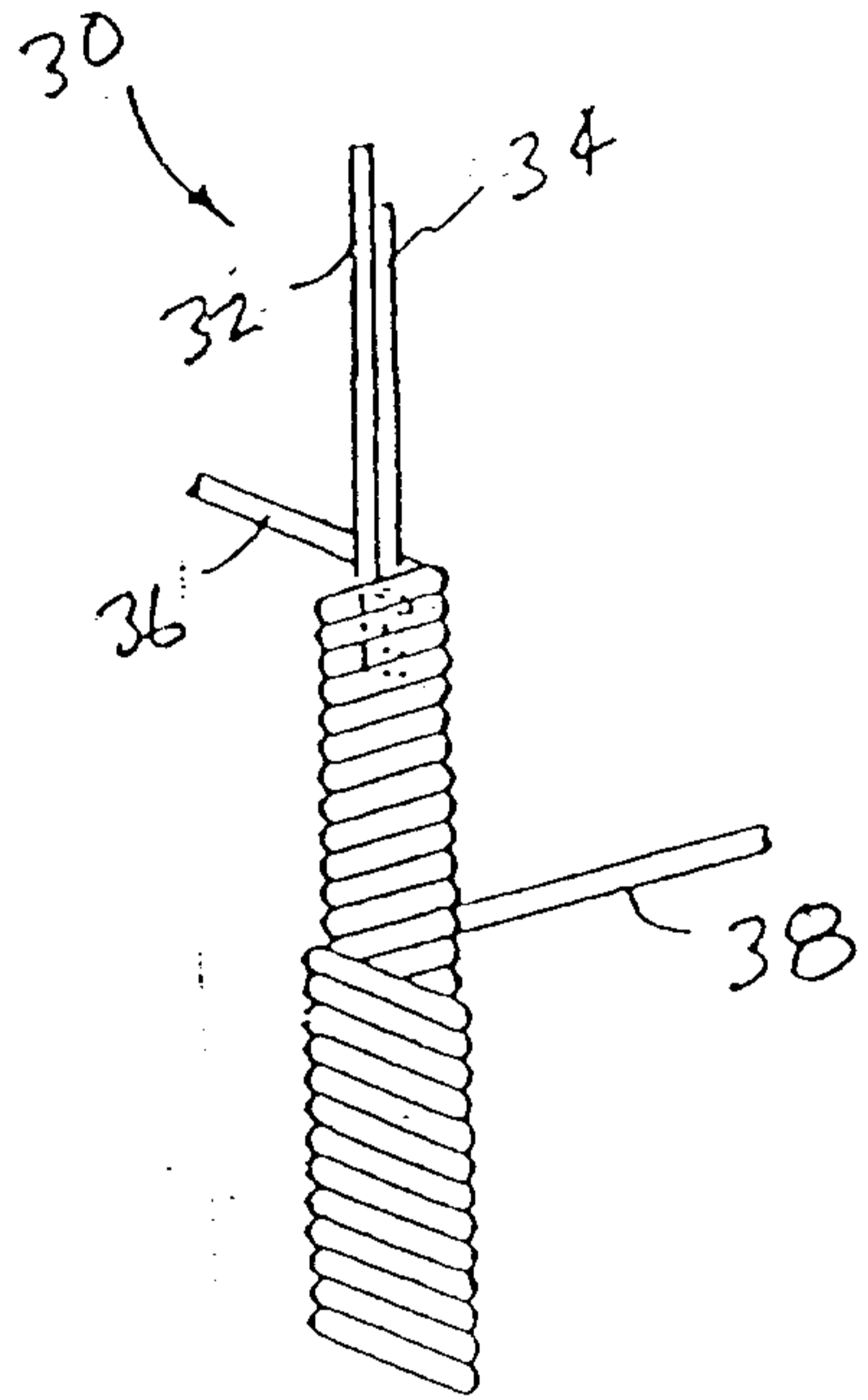


FIG. 3

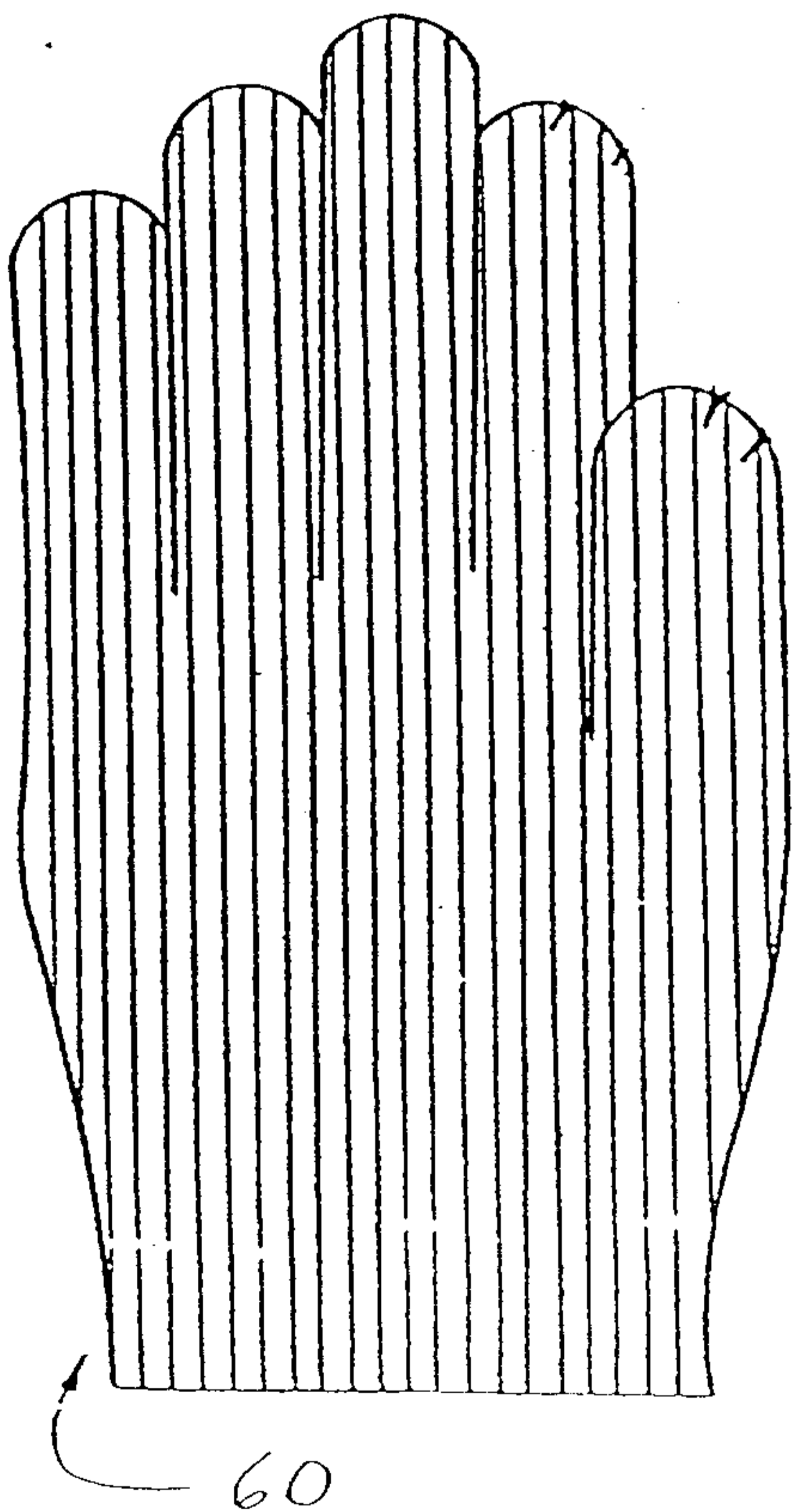


FIG. 5

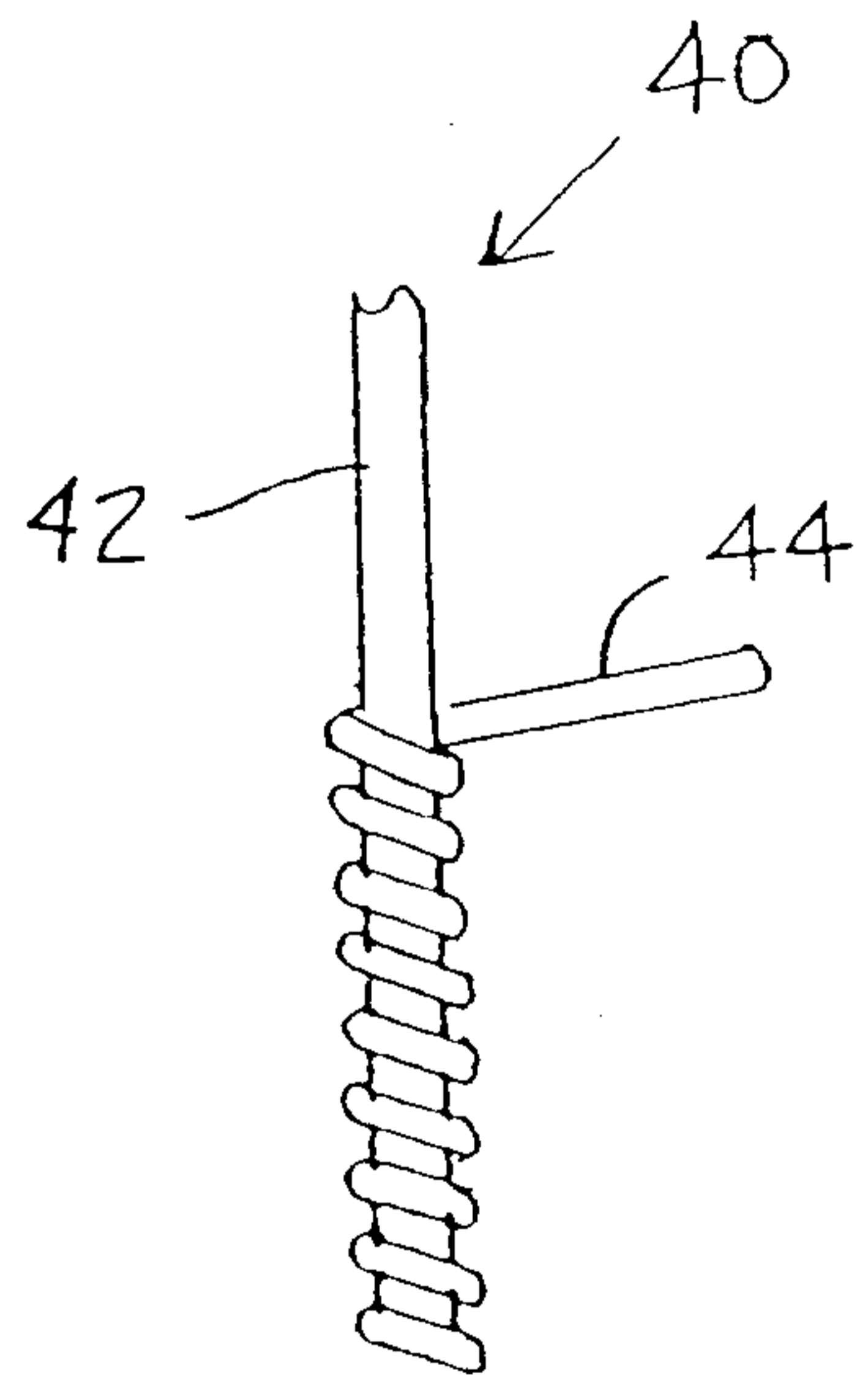


FIG. 4

