Jan. 6, 1948. V. LOMBARDI 2,434,045

KNITTED FABRIC AND METHOD

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Fig. 1.

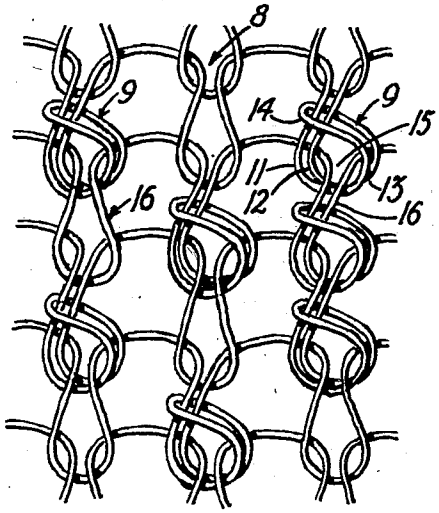


Fig. 2.



Fig. 3.

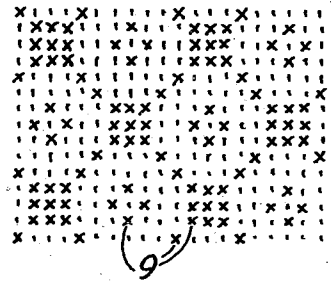


Fig. 4.

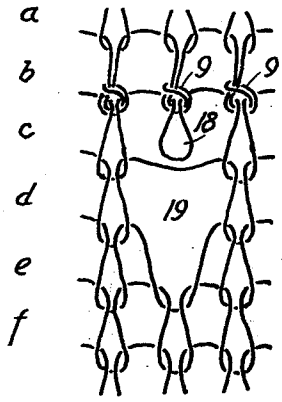


Fig. 5.

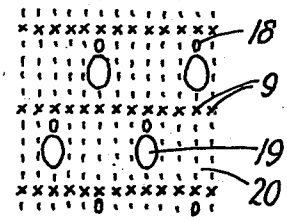
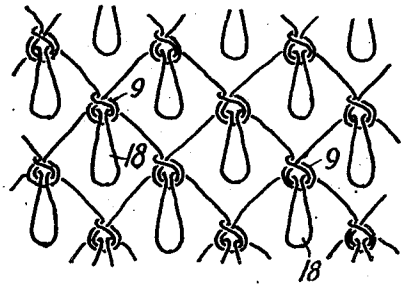


Fig. 6.



Inventor:
Vincent Lombardi
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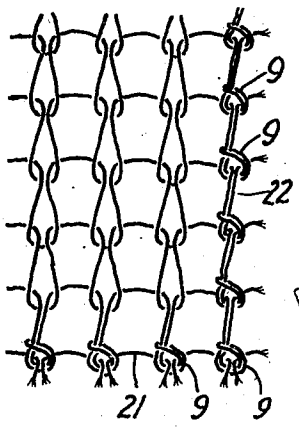
Jan. 6, 1948. V. LOMBARDI 2,434,045

KNITTED FABRIC AND METHOD

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Fig. 8.

Fig. 7.



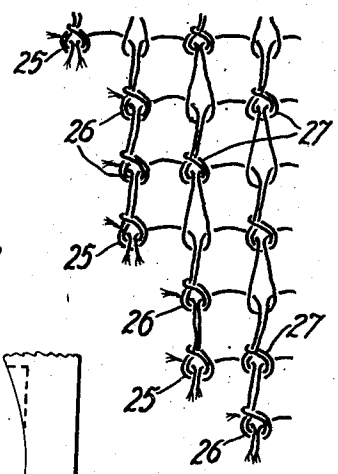
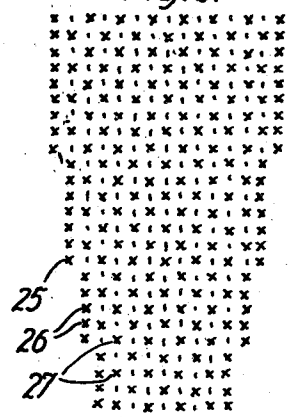


Fig. 9.



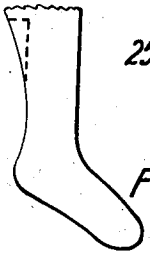


Fig. 8-A.

Fig. 10.

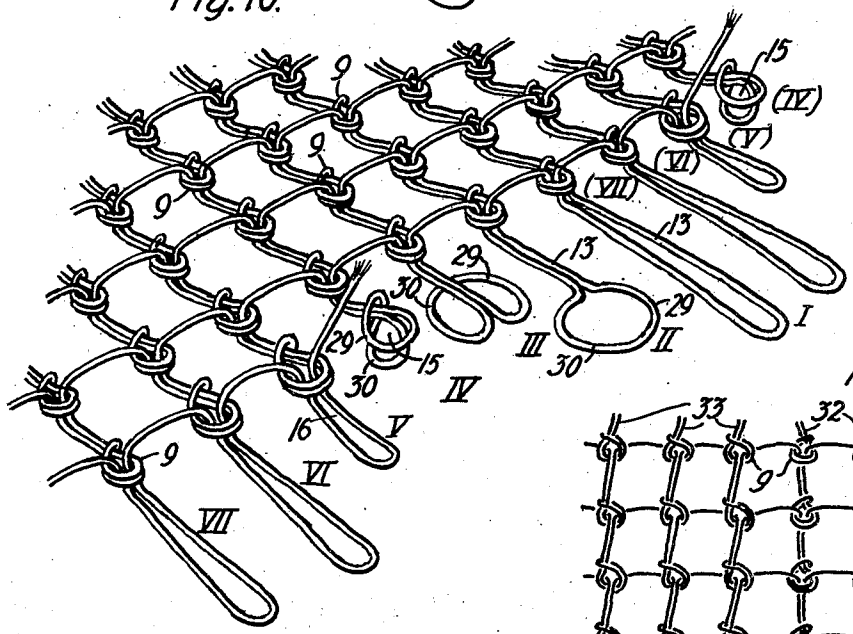


Fig. 11.

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KNITTED FABRIC AND METHOD

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Fig. 12.

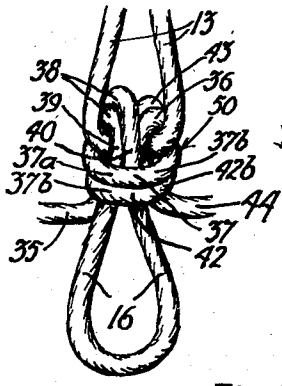


Fig. 13.

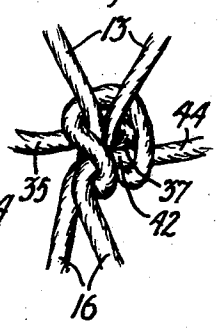


Fig. 14.

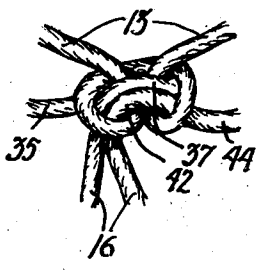


Fig. 15.

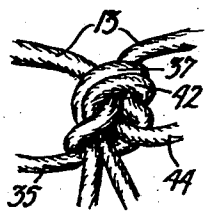


Fig. 16.

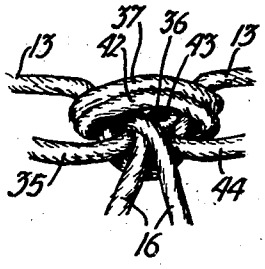


Fig. 17.

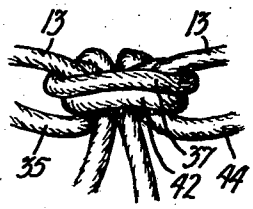


Fig. 18

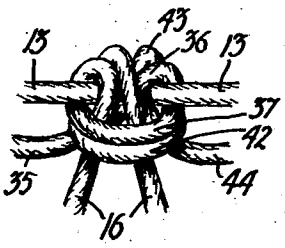


Fig. 19.

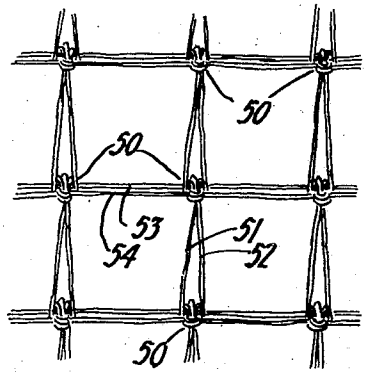


Fig. 20.

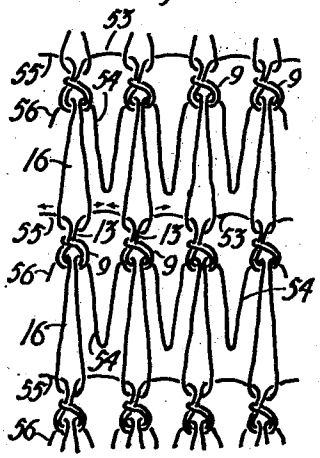
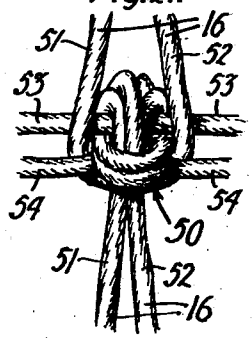


Fig. 21.



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Patented Jan. 6, 1948

2,434,045

UNITED STATES PATENT OFFICE

2,434,045

KNITTED FABRIC AND METHOD

Vincent Lombardi, Miami, Fla., assignor to Lombardi Knitting Machine Co., Inc., Miami, Fla., a corporation of New York

Application November 9, 1944, Serial No. 562,622

40 Claims. (Cl. 66—169)

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This invention relates to knitted fabric and to methods of producing the same. More particularly it concerns knitted fabric having knots therein.

For many years the art has sought fabrics having various qualities not possessed by ordinary knitted fabrics. Among these are combinations of firmness and yieldability not at present possessed by either knitted or woven fabrics; non-run and non-ravel tendencies, the presence of firmly secured bunches of yarn; simple and effective terry-like structures; well secured and relatively inelastic lace work, and good design qualities.

Among the objects of the present invention is the provision of fabrics having one or more of the foregoing and other qualities.

The invention finds highly effective application in a wide variety of types of fabrics including toweling, hosiery, sportswear, nether garments, outer wear, and plush fabrics. It enables the production of highly effective run-resistant fabrics such as non-run hosiery, girdles and brassières; the employment of the invention being of particular importance when an elastic yarn is included.

In accordance with the invention knots are provided in knitted fabrics throughout the same or preferably at selected portions thereof. A form of knot contemplated by the invention in certain of its aspects is one wherein one extent of yarn passes through the bight of a loop thereof to form an eyelet through which another extent of yarn passes. More specifically, the shank portion of a loop comprising the two sides or legs of the loop extends through the bight of said loop and around a portion of the other extent of yarn, which portion is itself preferably in the form of a loop. Such knots may be formed by doubling the legs of a loop back toward the bight and then passing them through the bight, or by bending back the bight half of the loop and folding it over the shank half, or otherwise bringing the two sides of the loop together with the bight end lying against them so that there is formed an eyelet portion in which the two sides of the loop form a double eye extending from the end of the bight back to and through the bight. The eyelet thus formed may receive the other extent of yarn—more specifically, a loop thereof—and when the first extent of yarn is tightened as by pulling the legs of the first mentioned loop through the bight, the eyelet is tightened against the legs of the loop of the "other" extent of yarn to form a strong and effective knot. The loop of the

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"other" extent of yarn extends from this knot as a succeeding loop in the same wale as the loop which forms the eyelet.

Another form of knot is one which is formed by spreading the legs of a knotted loop such as the loop first mentioned in the preceding paragraph so as to turn that knot inside out as it were, or which is otherwise formed, and wherein one extent of yarn extends through a loop of another extent of yarn then around the yarn of said loop, through said loop, and past itself, and continues, preferably after forming a new loop back through the first mentioned loop, around the yarn thereof, and again through it. In this case, the preceding loop rather than the succeeding one appears as the loop caught in the knot.

The invention accordingly comprises the article possessing the features, properties, and the relation of elements, and the several steps and the relation and order of one or more of such steps with respect to each of the others, which are exemplified in the following detailed disclosure and the scope of the application of which will be indicated in the claims.

For a fuller understanding of the nature and objects of the invention, reference should be had to the following detailed description taken in connection with the accompanying drawings, in which:

Figure 1 is a somewhat diagrammatic view of a form of knitted fabric having knots formed at certain points therein in accordance with the invention;

Fig. 2 is an enlarged view of one of the knots of Fig. 1;

Fig. 3 is a small scale schematic view of a fabric such as shown in Fig. 1;

Fig. 4 is a diagrammatic view showing a form of fabric having drop stitches;

Fig. 5 is a view similar to Fig. 3 showing a fabric such as shown in Fig. 4;

Fig. 6 is a view similar to Fig. 4 showing a terry-type fabric;

Fig. 7 is a similar view of a type of fabric wherein a selvage edge is provided by knots in accordance with the invention;

Fig. 8 is a similar view of a portion of a full-fashioned stocking;

Fig. 8A is a reduced scale view of a stocking showing the section of Fig. 8 in dotted lines;

Fig. 9 is a view thereof like Fig. 3;

Fig. 10 shows a form of fabric wherein knots are formed at each point of interknitting; and also exemplifies a method which forms a part of the invention;

Fig. 11 is a view similar to Fig. 4 showing a rib-stitch fabric;

Fig. 12 shows another form of knot such as contemplated by the invention;

Figs. 13–18 show successive stages in the transformation of the form of knot of Fig. 2 into the form of knot of Fig. 12;

Fig. 19 is a view similar to Fig. 1 showing a lace-like fabric;

Fig. 20 shows diagrammatically a manner of formation of the fabric of Fig. 19; and

Fig. 21 is a view like Figs. 2 and 12 showing further the contour of the various yarns in the fabric of Fig. 19.

Shown in Fig. 1 is a fabric wherein the knitting is generally of the jersey type, plain loops being knitted to plain loops at some points, as for example at **8**. At other points, however, a knot **9** is formed as by first passing the sides **11** and **12** of a loop **13** through the bight **14** thereof, or otherwise, to form an eyelet **15** and passing the new loop **16** through the eyelet instead of through the loop. In this manner there is formed a knot which not only adds to the firmness and body of a fabric in which it is incorporated, but tends to prevent pulling out of yarn and to prevent those runs which are so greatly to be avoided in knitted fabrics. In Fig. 1 the knots are, for sake of clearness, shown in a very loose condition. A normal tightened knot is shown in Fig. 2.

In addition the invention finds advantageous application in the production of design fabrics. Commonly the knots will be arranged to outline or otherwise mark the design, though if desired the main body of the fabric may be knotted throughout except at the design portions; or the knotted and unknotted points may be substantially equal as in Figs. 1 and 3. In Fig. 3 the knots **9** are indicated by crosses, and ordinary jersey loops are shown by dashes.

Another feature of the invention is that dangling loops can be readily provided by knotting the fabric in the second course prior to the one in which a stitch is dropped. Strong and effective terry-like fabrics, and fabrics which will brush to form a very effective plush, may be thus provided. Various design fabrics can likewise be provided by dropping stitches after knotting. The design effects thus formed may be employed alone or may be coupled with the feature of intermingled normal loops and knotted knitting.

In Figs. 4 and 5 there is shown a design fabric embodying both a knotted design and a dangling loop design. In course *a* of Fig. 4 there is jersey knitting in all three wales shown. In course *b* the fabric is knotted in each wale. In course *c* there is jersey knitting in each wale, the loops being caught in the knots. In course *d* there is jersey knitting in wales **1** and **3**, while in wale **2** a stitch has been dropped to leave a dangling loop **18** in course *c*. Jersey knitting follows; the yarn of course *e* being again caught in in wale **2**, and jersey loops being present in all three wales in course *f*. In Fig. 5, there is shown a fabric of this type wherein the knots are indicated at **9**, the terry-like loops at **18** and the dropped stitches at **19**. Jersey loops are shown at **20**. As will be understood knots may be formed at all points where loops are interknitted if desired.

A very strong, simple and effective terry-type fabric may be provided by dropping stitches in alternate wales in alternate courses, and in intermediate wales in intermediate courses. A fabric of this type is shown in Fig. 6. From each knot **9** there extends a dangling loop **18** which

is firmly secured and which can readily be formed of any desired size. Such fabrics can be used for towelings; and similar fabrics, when brushed, can provide very effective plush goods.

In Fig. 7 there is shown a portion of a selvage edge fabric embodying the invention. The fabric is a plain jersey knit except at its edges, one of which is shown at **21** and another at **22**. Each loop in the last course at the edge **21** and each loop in the last wale at the edge **22** is, as will be seen, knotted at **9** to provide an effective non-ravel edge. The cut ends of yarn along the selvage edges is shown frayed to distinguish from the yarn ends along the broken edges of the diagrammatic view of the fabric.

Similarly a feature of the invention is the provision of a knot at the point where a wale terminates when the fabric is removed as in the formation of a full fashioned stocking. In Figs. 8 and 9 this is exemplified by the knots at **25**. Selvage edge knots at **26** and non-run knots at **27** are also provided, these being formed in alternation in both directions with unknotted interknitted loops.

In instances where a heavy, firm, and/or non-run fabric is desired, the invention is highly advantageous, even when no design features are present. In such cases knots may be provided at all or at alternate points of interknitting in the wales and/or courses. Fabrics of this type, whether or not small unknotted design portions are included, have the firmness and strength of woven fabrics while retaining a sufficient degree of yieldability to provide sportswear and other clothing which has a closer fit and a more comfortable hang than if made of woven cloth. Towels, wash cloths, and like fabrics are effectively provided by the presence of relatively bulky knots. Many other advantageous uses will be apparent. One very effective use is in non-run hose wherein the knots prevent the spreading of a break in the yarn. Such a fabric is shown in Fig. 10, a **9** knot being provided in this instance at each point where the loops are interknitted.

In Fig. 10 there is also exemplified a manner of formation of knots of the character shown therein and in the preceding figures. There is shown in stage I a loop **13** ready to be knotted. At stage II, the bight end of the loop **13** is shown spread outwardly at **29** and **30**. This step is not essential but is a convenient first step of formation of the eyelet **15**. In stage III, the bulged out bight portion is shown bent under the shank portion of the loop. In stage IV, the portion **29** is shown as bent over alongside the portion **30** so as to provide the double-eye construction forming the eyelet **15**. Another extent of yarn, such as a loop **16**, is then inserted in stage V. In stage VI, this loop **16** is drawn out. In stage VII, the eyelet is tightened to complete a highly effective knot **9** as by pushing the bight end toward the newly inserted loop **16**. It will be appreciated that it is the formation of the eyelet and the passing therethrough of another extent of yarn that is of major significance in the present method rather than any special manipulation of portions of the yarn to provide the eyelet.

As will be appreciated, the invention is adapted for embodiment in any of a wide variety of types of knited fabric; since knots may be provided in accordance with the invention at any point where two extents of yarn, specifically two loops, are united. In Fig. 11 for example, there is shown a rib stitch construction wherein knots **9** are pro-

vided at certain points both in the depressed ribs 32 and the projecting ribs 33.

Another and more resistant form of knot contemplated by the invention is shown in Fig. 12. While knots of this general character may be formed in a variety of ways, the knots specifically illustrated may readily be formed by exerting a lateral (coursewise) pull on the legs of the loop of an eyelet knot such as the loop 13 of the knot 9 as shown in Fig. 2, causing the eyelet at the bight end of this loop to straighten out and consequently causing the yarn at the feet of a caught loop such as the loop 16 to wrap itself around the bight of the loop 13 to form in its turn the knot 50. As will be seen the extent of yarn embodying the loop 16 runs from 35 through the loop 13 as at 36, around the loop 16 as at 37, through the loop 13 as at 38, and past itself (over the portion 35—36 as exemplified) as at 39. After forming a loop 16 it again runs past itself (over the portion 35—36) at 40, around the loop 13 at 42, and through the loop 13 at 43 and out at 44. As exemplified the portions 37 and 42 of the yarn run over the portion 35 thereof at 37*a* and 42*a*, and over the portion 44 thereof at 37*b* and 42*b*. Even if the extent 13 is not in the form of a loop, the knot is effectively formed around the extent. In either case the extent 16 extends twice about the yarn of the extent 13 (e. g. at the right) in one direction (e. g. clockwise as viewed from the right) and thence laterally (e. g. to the left at 37 and 42) and twice about the yarn of the extent 13 in the opposite direction (e. g. counterclockwise as viewed from the right) and (preferably and as exemplified in a loop) between the yarn of the extent 13 and the laterally extending portions (37 and 42) of itself.

In Figs. 13–18 are shown successive stages in the transformation of the knot 9 of Fig. 2 into the knot 50 of Fig. 12. In this method, the legs of a knot-forming loop 13 are spread and are pulled strongly in opposite lateral (coursewise) directions, causing the eyelet to tend to unwrap itself and in so doing to twist the yarn at the feet of the loop 16 to form the knot 50. In Fig. 13, the initial pull has caused the eyelet to begin to straighten out as shown. The leg portions 37 and 42 of the loop 16 begin to appear through the bight of the loop 13. In Fig. 14, the bight of the loop 13 is shown in the process of being pushed down by the spread of the legs of the loop 13. In Fig. 15, the tension on the bight of the loop 13 is shown as having pushed the bight still further downwardly. In Fig. 16, the loop 13 is shown as having straightened itself out but the foot portions 37 and 42 of the loop 16 remains substantially in the same relative positions of Fig. 13 although they extend further laterally. In Fig. 17 the legs of the loop 13 are shown exerting pressure on the leg portion 37 and 42 to press them down over the leg portion of loop 16 and over connector portions 35 and 44. In Fig. 18 portions 37 and 42 have been pushed down to their final position by the complete straightening out of loop 13. The condition shown in Fig. 18 is substantially the same as that of Fig. 12, the only difference being that the knot 50 of Fig. 12 is tightened and loop 13 is reformed with its legs substantially parallel.

The type of knot exemplified in Fig. 12, however formed, and whether or not the legs of the knot-forming loop are arranged in exactly the manner shown, lends itself to the formation of a wide variety of desirable types of fabric. One such fabric embodying the invention in certain of its aspects is shown in Fig. 19. This is a lace-

like fabric embodying in the present instance at each juncture of the strands a knot 50. A pair of strands 51 and 52 extend vertically (walewise) between the knots of each vertically disposed pair of knots 50, and a pair of strands 53 and 54 extend between each horizontally disposed pair of knots 50. This provides not only an attractive but a firm and run-resistant lace fabric, which may be formed with the utmost ease by a simple type of knitting procedure. One procedure of this character is exemplified in Fig. 20 which indicates the knitting operation on two strands 55 and 56 in the formation of such a fabric. The strand 55 comprises knots 9 similar to the knots hereinbefore exemplified which are formed from loops 13. The extent 56 comprises loops 16 which extend through the knots 9. As will be noted, the portions of the extent 54 which is between the knots 9 has a very considerable amount of slack in it. Now, if the portions of the extent 55 which are at each side of the knots 9 are pulled in the directions indicated by the arrows, as by catching them at a central point or otherwise and drawing the yarn laterally, the knots 9 will convert themselves in knots 50. The formation of these knots 50 will require additional yarn at the feet of the loop 16, which additional yarn will be supplied by the slack in the portions of the extent 56 between the loops. These portions are numbered 54 since, when the slack is taken up, they will correspond to the portions 54 in Fig. 19.

After the knots 9 have been converted into knots 50, the fabric of Fig. 20 will have automatically transformed itself into the fabric of Fig. 19. The slack having been taken up, the portions 54 in Fig. 19 will appear as the portions 54 in Fig. 18; and the remaining portions of the extent 56—the sides of the loops 16—will appear as the portions 51 and 52. The portions of the extent 55 between the knots will appear as portions 53.

As will be seen at 53 in Fig. 21, the extent 13 is substantially straight laterally, the lateral pull having entirely straightened out the loop. The contour of the extent 16 nevertheless corresponds to that shown in Figs. 12 and 18. As to the extent 13, variations from the looped contour of Fig. 12 to the straight contour of Fig. 18 depend on the type of pulls applied in the transformation of the knot and thereafter, and the manner in which they are applied. Fig. 21 also shows how a preceding loop 51—52 is caught between the extents 13 (53—53) and 16 (54—54).

Since certain changes in the above article and in carrying out the above method and in the constructions set forth, which embody the invention, may be made without departing from its scope, it is intended that all matter contained in the above description or shown in the accompanying drawing shall be interpreted as illustrative and not in a limiting sense.

I claim:

1. A knitted fabric comprising a plurality of extents of yarn united by means of a knot wherein one extent of yarn passes through the bight of a loop thereof to form a double eyelet through which another extent of yarn passes.

2. A knitted fabric comprising a plurality of extents of yarn united by means of a knot wherein the sides of a loop of one extent of yarn pass through the bight of a loop thereof to form an eyelet through which a loop of another extent of yarn passes.

3. A knitted fabric having a multiplicity of

knots wherein the sides of a loop of one extent of yarn pass through the bight of a loop thereof to form an eyelet through which a loop of another extent of yarn passes.

4. A knitted fabric the loops of which are united at certain points in a normal fashion and at certain other points by a knot in which the sides of a loop of one extent of yarn pass through the bight of a loop thereof to form an eyelet through which a loop of another extent of yarn passes.

5. A knitted fabric the loops of which are united at certain points in a jersey fashion and at certain other points by a knot in which the sides of a loop of one extent of yarn pass through the bight of a loop thereof to form an eyelet through which a loop of another extent of yarn passes.

6. A rib stitch knitted fabric the loops of which are united at certain points in a normal fashion and at certain other points by a knot in which the sides of a loop of one extent of yarn pass through the bight of a loop thereof to form an eyelet through which a loop of another extent of yarn passes.

7. A knitted fabric at least one loop of which has its bight portion bent back and over to enclose both sides of its shank portion to provide an eyelet encompassing a succeeding loop.

8. A knitted design fabric wherein a design is formed by knots each uniting one loop with another loop by means of an eyelet formed by one of the loops which it unites, said one of said loops extending thru said eyelet, the loops of the fabric being united normally throughout substantially the remainder of the fabric.

9. A knitted design fabric embodying a plurality of knots each comprising a loop forming a double-strand knot about another loop, said knots being arranged in design formation and the loops being united in a different fashion in the remainder of the fabric.

10. A knitted design fabric wherein a design is formed by knots each comprising a loop in one course having its two side yarns bent in parallel relation to form a closed double eye with the bight locked about the shank portion and with the double eye locked about the shank of a loop in the same wale in a succeeding course to prevent said eye from opening, the loops of the fabric being normally united throughout substantially the remainder of the fabric.

11. A knitted fabric having a multiplicity of knots from which loops hang free to provide a terry-type fabric.

12. A knitted fabric comprising a plurality of extents of yarn united by means of a knot wherein the sides of a loop of one extent of yarn pass through the bight of a loop thereof to form an eyelet through which a loop of another extent of yarn passes, the latter loop hanging free from at least some of said knots.

13. A knitted fabric formed at a multiplicity of points thereon with knots in each of which the sides of a loop of one extent of yarn pass through the bight of a loop thereof to form an eyelet through which a loop of another extent of yarn passes, a latter loop being unknitted and hanging free from each of said knots.

14. A knitted fabric wherein the number of wales decreases from one course to another, wherein a knot is provided at each point of decrease, and wherein normal unkotted knitting is provided at other points.

15. A piece of knitted fabric having an edge whereat ravelling is prevented by means of a knot wherein the sides of a loop of one extent of yarn pass through the bight of a loop thereof to form an eyelet through which a loop of another extent of yarn passes.

16. A knitted fabric comprising an extent of yarn forming a knot about another extent of yarn and extending about said other extent in one direction and thence laterally and about said other extent in the other direction and between said other extent and the laterally extending part of itself.

17. A knitted fabric comprising an extent of yarn forming a knot about another extent of yarn and extending twice about said other extent in one direction and thence laterally in two strands and then twice about said other extent in the opposite direction and in a loop between said other extent and the portions of itself which extend laterally as specified.

18. A knitted fabric comprising a plurality of extents of yarn united by means of a knot wherein one extent of yarn extends through a loop of another extent of yarn, then around said loop, through said loop, and past itself, and then back through said loop, around said loop, and through said loop.

19. A lace fabric comprising a multiplicity of knots from each of which double substantially straight strands extend in four directions, a multiplicity of the strands from one knot being portions of a continuous yarn.

20. A lace fabric comprising a multiplicity of knots wherein one extent of yarn forms a knot about another extent, said one extent extending twice about said other extent in one direction and thence laterally in two strands and then twice about said other extent in the opposite direction and in a loop between said other extent and the portions of itself which extend laterally as specified, said knots being interconnected vertically and horizontally by the extents of yarn of which said knots are composed.

21. Run-resistant knitted hosiery having knots formed from the loops at regularly spaced intervals walewise and coursewise thereof, each of at least certain of said knots comprising a loop extending thru an eyelet formed of said loop.

22. A knitted fabric the loops of which are united in a normal fashion at certain points and by means of knots at regularly spaced intervals walewise and coursewise thereof to resist the formation of runs, each of at least certain of said knots comprising a loop extending thru an eyelet formed of said loop.

23. The method of forming a fabric which comprises forming a loop, passing the sides of said loop through the bight of the loop to form an eyelet in which the doubled loop defines the opening, passing a loop of another extent of yarn through said eyelet, and closing said eyelet to form a knot about the sides of the last mentioned loop.

24. The method of forming a fabric which comprises forming a loop, passing the sides of said loop through the bight of the loop to form an eyelet in which the doubled loop defines the opening, passing a loop of another extent of yarn through said eyelet and spreading the legs of the first mentioned loop to cause said eyelet to undo itself and to pull the second mentioned loop into a knot about the first mentioned loop.

25. The method of forming a knitted fabric which comprises interknitting loops, and, prior to interknitting certain of said loops, passing the

sides of the respective loops through the bight thereof to form an eyelet in which the doubled loop defines the opening, passing a loop of another extent of yarn through said eyelet, and closing said eyelet to form a knot about the sides of the last mentioned loop.

26. The method of forming a knitted fabric which comprises interknitting loops, and, prior to interknitting only certain of said loops, passing the sides of the respective loops through the bight thereof to form an eyelet in which the doubled loop defines the opening, passing a loop of another extent of yarn through said eyelet, and closing said eyelet to form a knot about the sides of the last mentioned loop.

27. The method of forming a fabric which comprises forming a loop, bending the bight thereof about the shank to form a double eye, forming another loop and passing it through said eye to lock it, and performing succeeding knitting steps at least certain of which include operations similar to the foregoing.

28. The method of forming a lace fabric which comprises forming knots in alternate wales and dropping stitches in the intervening wales.

29. The method of forming a lace fabric which comprises forming knots in spaced vertical lines in alternate courses and in courses other than said alternate courses knitting only in said spaced lines without knitting in said intervening lines, and drawing out the yarn without knitting in intervening vertical lines certain courses.

30. Knitted fabric comprising a plurality of extents of yarn united by means of a knot wherein a doubled portion of one extent of yarn is wrapped around another extent of yarn and caught under itself.

31. Knitted fabric comprising a plurality of extents of yarn united by means of a knot wherein a doubled portion of one extent of yarn is wrapped around two portions of another extent of yarn and caught under itself.

32. A lace fabric comprising a multiplicity of knots connected in one direction by double strands constituting the sides of loops of knitted yarn and in the other direction at least in part by yarn other than that forming said loops.

33. A lace fabric comprising a multiplicity of knots connected in one direction by double strands constituting the sides of loops of knitted yarn and in the other direction by double strands one of which constitutes a dropped stitch.

34. A knitted fabric comprising a plurality of extents of yarn united by means of a knot wherein the sides of a loop of one extent of yarn pass through the bight of the loop to form an eyelet through which a loop of another extent of yarn passes.

35. A knitted design fabric wherein a design is formed by knots wherein one extent of yarn

passes through the bight of a loop thereof to form a double eyelet through which another extent of yarn passes.

36. A knitted design fabric wherein a design is formed by knots wherein the sides of a loop of one extent of yarn pass through the bight of the loop to form an eyelet through which a loop of another extent of yarn passes.

37. A knitted fabric the loops of which are united in a normal fashion in certain succession of loops coursewise and walewise of the fabric and by means of individual knots at regularly spaced intervals walewise and coursewise thereof to resist the formation of runs.

38. Run resistant knitted hosiery having individual knots formed from the loops at closely but regularly spaced intervals both walewise and coursewise thereof, substantially all of the remainder of the fabric being normally knitted.

39. A knitted fabric including elastic yarn the loops of which are united in a normal fashion at certain points and by means of knots at regularly spaced intervals walewise and coursewise thereof to resist the formation of runs, each of at least certain of said knots comprising a loop extending thru an eyelet formed of said loop.

40. A knitted fabric including elastic yarn at least one loop of which has its bight portion bent back and over to enclose both sides of its shank portion to provide an eyelet encompassing a succeeding loop.

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