Nov. 25, 1969 A. H. SILVAIN 3,479,844

FORM-FITTING SEAMLESS GARMENT AND METHOD

Filed July 6, 1967 3 Sheets-Sheet 1

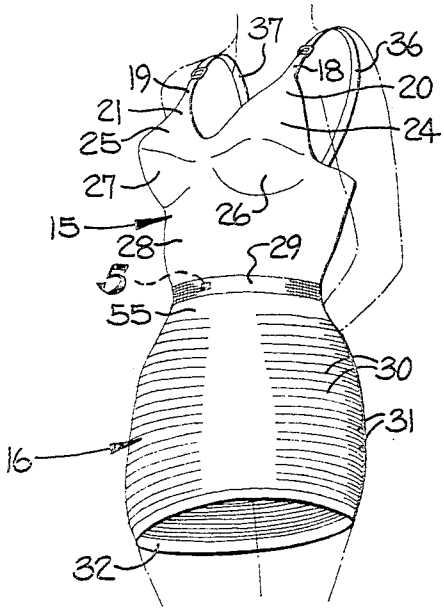

Fig-1

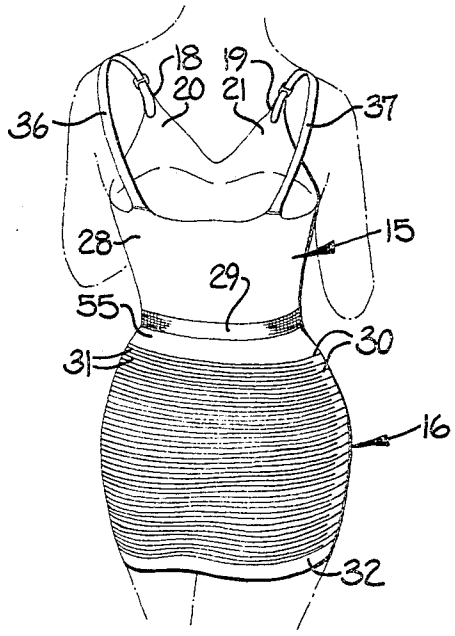

Fig-2

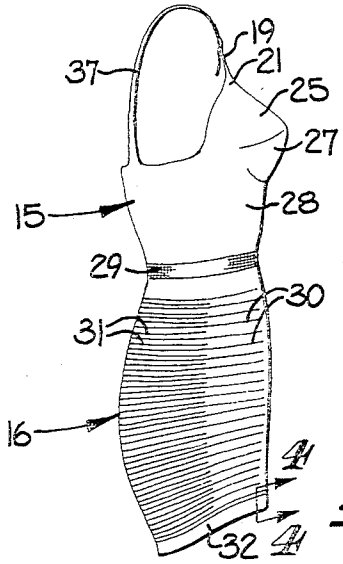

Fig-3

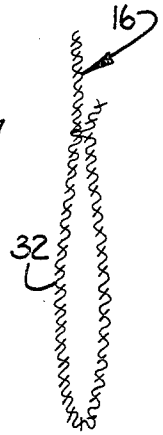

Fig-4

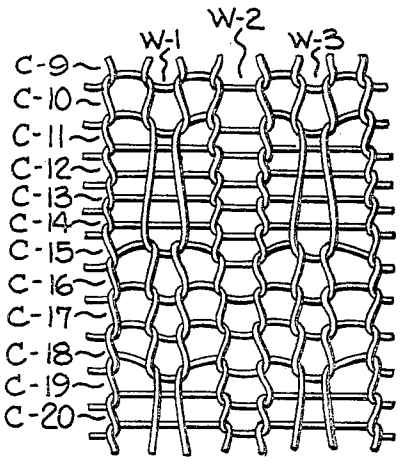

Fig-5

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Filed July 6, 1967 3 Sheets-Sheet 2

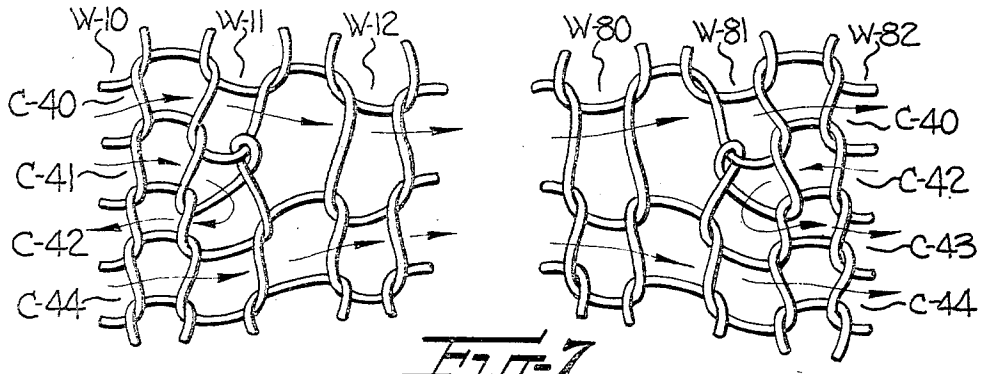

Fig-7

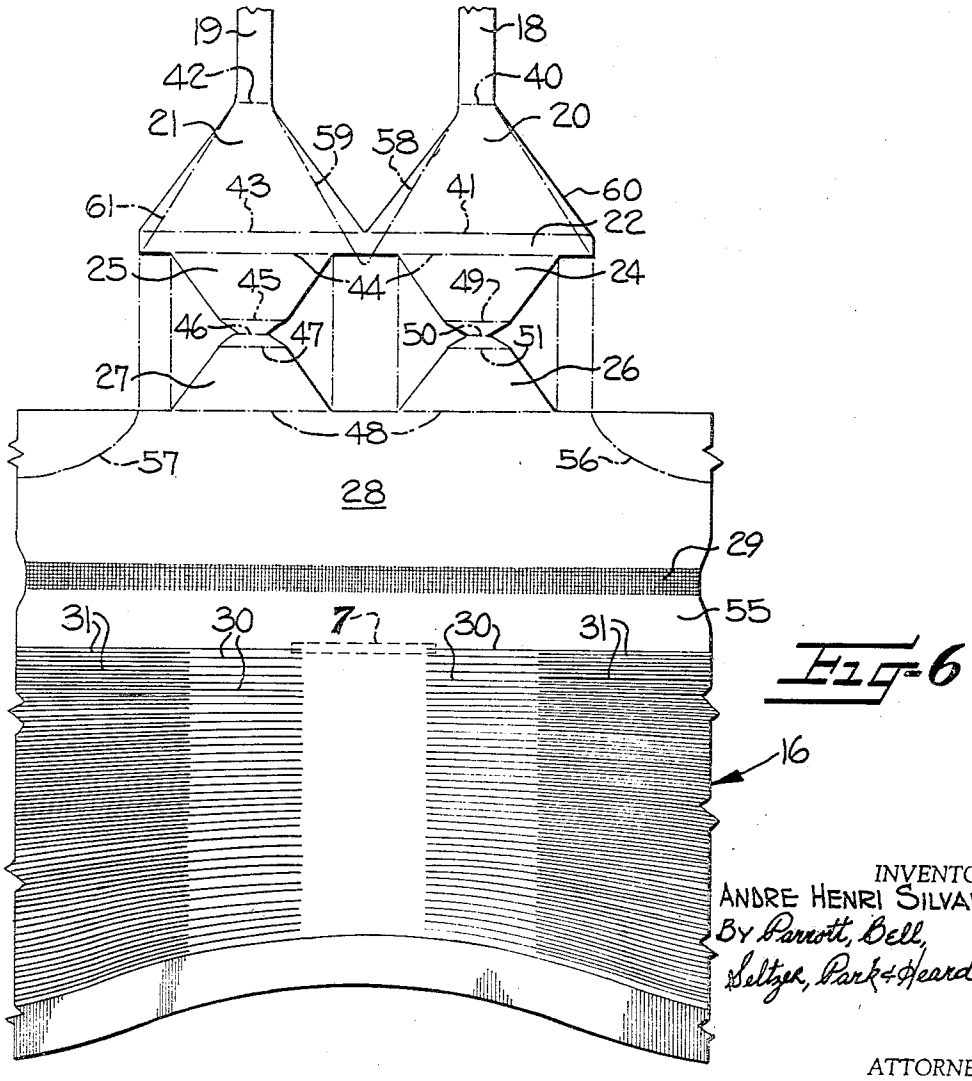

Fig-6

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FORM-FITTING SEAMLESS GARMENT AND METHOD

Filed July 6, 1967 3 Sheets-Sheet 3

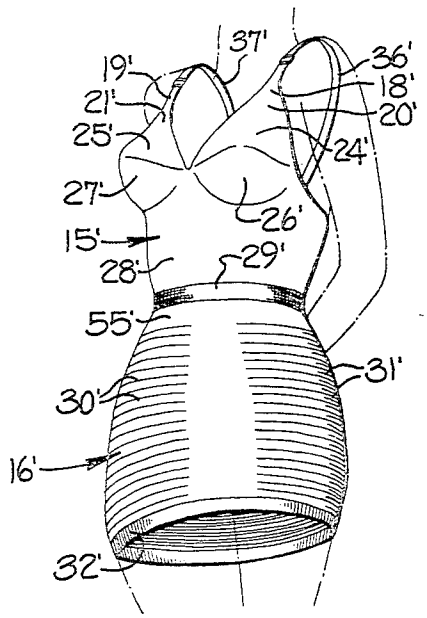

Fig-8

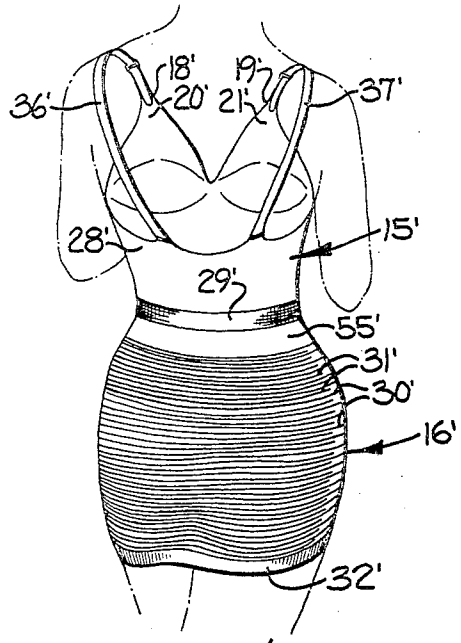

Fig-9

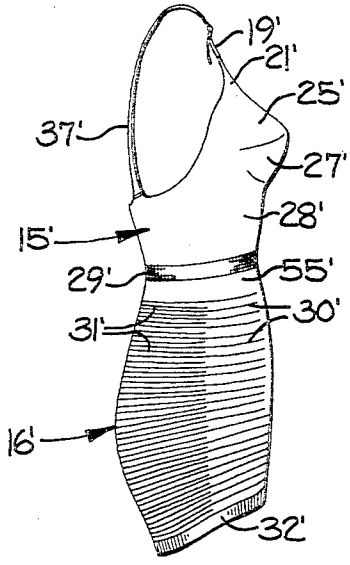

Fig-10

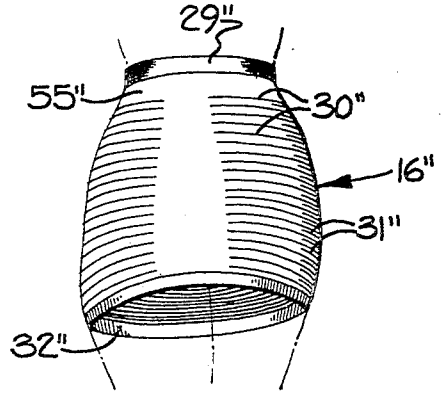

Fig-11

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3,479,844

FORM-FITTING SEAMLESS GARMENT AND METHOD

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Filed July 6, 1967, Ser. No. 651,487
Int. Cl. A41b 9/06; D04b 9/42
U.S. Cl. 66—176 8 Claims

ABSTRACT OF THE DISCLOSURE

One form of the garment is adapted to cover substantially the complete torso and includes an upper portion having fashioned breast-receiving pockets, and an integrally knit lower portion having a greater amount of fabric in the rear portion. Another form of garment is adapted to cover only the lower trunk of the wearer. The garment is formed on a circular knitting machine with reciprocation and rotation of the needle cylinder.

This invention relates generally to a form-fitting seamless garment and the method of knitting the same. More particularly, this invention relates to a one-piece form-fitting garment which is shaped or fashioned as it is being knit to substantially conform to the configuration of that portion of the body on which it is to be worn.

The garment is particularly adapted for wear by ladies and may be of the type adapted to fit and cover only the lower trunk portion of the wearer, or it may cover substantially the complete torso and include an upper portion having fashioned breast-receiving pockets. The garment of the present invention is preferably knit on a circular knitting machine and may be knit of any suitable yarn. Depending upon the type yarn used and the manner in which the seamless blank is knit, it may be used as a foundation garment, such as a girdle or corset, or it may be used as a non-support undergarment, swimsuit, or the like.

It is the usual practice to manufacture form-fitting women's garments by cutting textile material to form separate panels of the desired shape and then sewing the panels together so that the garments substantially conform to the configuration of the wearer. This "cut and sew" method is expensive and time-consuming, and produces seams throughout various portions of the garment which can be uncomfortable.

It is also known to form women's form-fitting garments by knitting shape front and rear panels on a full-fashioned knitting machine and then sewing the front and rear panels together along opposite sides to complete the garment. This type of garment does not have seams extending across the front and rear panels, but does have seams extending up each side.

With the foregoing in mind, it is an object of the present invention to provide a form-fitting seamless garment which may be economically knit on a circular knitting machine and fashioned during the knitting operation to substantially conform to the configuration of corresponding portions of the body of the wearer.

It is another object of the present invention to provide a seamless form-fitting garment which may include an upper breast covering portion and an integrally knit lower trunk covering portion. The upper portion is provided with fashioned breast-receiving pockets and the lower trunk covering portion is shaped or fashioned to provide a more comfortable fit. This lower portion is shaped by forming groups of complete successive courses which extend completely around the trunk portion and by forming partial courses between the groups of complete courses, which partial courses extend across the rear portion and thereby provide a greater amount of knit fabric in the rear portion of the garment. In order to make the lower trunk covering portion more nearly conform to the shape of the corresponding portion of the body of the wearer, certain of the partial courses extend substantially one-half the distance around the trunk covering portion and other partial courses extend substantially three-fourths of the distance around the trunk covering portion.

It is a further object of the present invention to provide a waistband portion positioned between and connecting the upper and lower portions of the garment, the waistband portion including a repeating pattern of the special stitches which provide a contrast in appearance with the remainder of the garment and also provides a better fit around the waist.

It is another object of the present invention to provide a seamless form-fitting garment which conforms to and is adapted to be worn on the lower trunk portion of the body of the wearer and which is fashioned or shaped in a smoothly contoured manner during the knitting operation to provide a greater amount of knit fabric across the rear portion of the garment.

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

FIGURE 1 is a front perspective view of one form of the seamless form-fitting garment of the present invention, illustrating its appearance when worn;

FIGURE 2 is a rear perspective view of the garment shown in FIGURE 1;

FIGURE 3 is a side view of the garment shown in FIGURE 1;

FIGURE 4 is an enlarged vertical sectional view through the lower turned hem of the garment shown in FIGURE 3, being taken substantially along line 4—4 therein;

FIGURE 5 is an enlarged fragmentary view of that area enclosed by the rectangle 5 in FIGURE 1 and illustrating the special stitches utilized in the waistband;

FIGURE 6 is a somewhat schematic layout diagram to illustrate the manner in which the garment shown in FIGURES 1–3 is knit on a circular knitting machine;

FIGURE 7 is a greatly enlarged fragmentary view of that portion of the fabric enclosed by the dash-dot rectangle 7 in FIGURE 6, with the central portion broken away and illustrating the manner in which the partial courses are knit between the complete courses;

FIGURE 8 is a front perspective view of a modified form of seamless form-fitting garment, illustrating its appearance when worn;

FIGURE 9 is a rear perspective view of the garment shown in FIGURE 8;

FIGURE 10 is a side view of the garment shown in FIGURE 8; and

FIGURE 11 is a front perspective view of another modified form of the seamless form-fitting garment, this modification being of the type adapted to cover only the lower trunk portion of the body of the wearer.

Each form of garment (FIGURES 1–3, FIGURES 8–10 and FIGURE 11) is of a one-piece seamless construction and is preferably knit on a circular knitting machine which is adapted to selectively knit in a rotary or a reciprocatory manner. The knitting machine may be of any desired type having means for selecting certain groups of needles to knit while maintaing other groups of needles in an inactive position, and having means for increasing and decreasing the number of needles knitting to form widened and narrowed partial courses while the needle

cylinder is being reciprocated. For example, the garments of the present invention may be knit on a circular knitting machine of the type disclosed in U.S. Patent No. 3,292,392.

In the drawings, the garments have been lined to indicate the direction in which the courses extend, it being understood that the wales of the knit fabric extend in the transverse direction. Generally, the forms of garment shown in FIGURES 1–3 and 8-10 each include upper breast covering portions, broadly indicated, respectively, at **15** and **15'** and lower trunk covering portions **16**, **16'** which are integrally formed during the knitting operation and which are adapted to cover substantially the complete torso of the wearer. These two forms of garment may be utilized as bathing suits, girdles, corsets or the like. When the garment is to be used as a bathing suit, the lower open end may be completed by connecting opposite ends of a crotch piece to the front and rear portions, or by sewing a panty type liner inside of the lower open end.

The garment shown in FIGURE 11 is substantially identical to the lower trunk covering portions **16**, **16'** of the first two forms of garment and may be utilized as a tube type girdle, a panty girdle, or as the lower portion of a two-piece type bathing suit. Any suitable brassiere or halter type upper portion may be worn with the garment **16''** (FIGURE 11). For example, the brassiere type garment disclosed in the Preston C. Epley application Ser. No. 649,564 filed June 28, 1967 concurrently herewith and entitled Knit Seamless Brassiere and Method of Forming Same may be worn with the lower trunk covering garment **16''**.

The first form of garment shown in FIGURES 1–7 is adapted to cover substantially the complete torso and includes the integrally knit upper breast covering portion **15** and the lower trunk covering portion **16**. The upper breast covering portion includes strap portions **18**, **19**, fashioned suport panels **20**, **21**, an upper connector or body strip **22** (FIGURE 6) which joins together fashioned breast-receiving pockets each including respective upper gussets **24**, **25** and lower gussets **26**, **27** which are formed of narrowed and widened partial courses joined together at opposite ends to form suture lines during the knitting of the pockets. A lower connector strip or body panel **28** extends downwardly to the waist band portion **29** which is preferably knit of a special stitch, to be presently described, and which connects together the upper breast covering portion **15** and the lower trunk covering portion **16**.

The lower trunk covering portion **16** is tubular and includes groups of successive complete or full courses extending completely around the lower portion and a first series of partial courses, indicated at **30** in FIGURES 1–3 and 6, which extend substantially three-fourths of the distance around the lower trunk covering portion **16** and are formed between certain of the complete courses. A second series of partial courses, indicated at **31**, are formed between certain of the complete courses and between the longer partial courses **30** and extend substantially one-half the distance around the lower trunk covering portion **16**.

The partial courses **30**, **31** increase the length of the wales in the rear half of the lower trunk covering portion **16**, as best shown in FIGURE 3, to provide a greater amount of knit fabric therein and provide a comfortable fit across the rear portion of the garment; particularly across the buttocks of the wearer. The longer partial courses **30** also increase the length of the wales at each side of the front half of the lower trunk covering portion **16** to provide a better fit around the hips of the wearer. The lower terminal edge portion of the lower trunk covering portion **16** is provided with a turned hem **32** (FIGURE 4) which is preferably formed on the knitting machine, in a manner to be later described. It is preferred that the garment be knit of some type of stretchable yarn and it may be desirable to knit portions of the garment of inelastic yarn or of different types of stretchable yarn to vary the amount of support which may be provided by the garment, depending upon its intended use.

The garment blank, as it comes from the knitting machine, is of a single one-piece construction and the various sections are integrally joined together during the knitting operation. The strap portions **18**, **19** may be knit of sufficient length that their free ends may be directly connected to the back portion of the garment to complete the garment; however, it is preferred that these strap portions **18**, **19** be knit relatively short and shoulder straps **36**, **37** may be adjustably secured at one end to the upper end portions of the strap portions **18**, **19** and their other ends may be suitably connected to the back portion of the garment, as shown in FIGURES 2 and 3.

METHOD OF KNITTING

The preferred method of knitting the first form of garment shown in FIGURES 1–3 will be described with particular reference to FIGURE 6. FIGURE 6 is a somewhat schematic diagrammatic layout view of the garment blank, as it would appear if the tubular garment blank were cut along a wale line extending upwardly through the center of the back of the garment and then laid out flat and with the blank also being cut in a coursewise direction along the suture lines joining the narrowed and widened gussets of the breast pockets and along the course connecting the upper and lower strips **22**, **28**.

Initially, a group of successive needles at one position in the needle cylinder is positioned to move along an active or knitting path while the remaining needles move along an inactive or non-knitting path. The yarn is fed to this group of active needles while the needle cylinder is reciprocated to form a plurality of successive partial courses of the same length and form the relatively narrow support strap portion **18** of the desired length, down to the dash-dot line **40** (FIGURE 6).

With continued reciprocation of the needle cylinder, the widening picks are rendered active to gradually increase the length of successive partial courses; for example, one additional needle may be moved to the active path with each swing of the needle cylinder during the knitting of the support panel **20** and to thereby provide outwardly diverging selvage edge portions at opposite sides thereof. Upon completion of the support panel **20**, along the dash-dot line **41**, the active needles are positioned to move along an inactive path and a group of successive needles spaced around the needle cylinder is positioned to move along an active path and the yarn is fed thereto to begin knitting of the relatively narrow support strap portion **19**. During the knitting of the strap portion **19**, the widening picks are inoperative so that successive partial courses of the same length are knit with each swing of the needle cylinder in each direction, down to the dash-dot line **42**. Then, the widening picks are again activated to gradually increase the length of successive partial courses during the knitting of support panel **21** and to form outwardly diverging selvage edges at opposite sides thereof, down to the dash-dot line **43**.

At this point, the widening picks are rendered inoperative and the needles which have been holding the stitch loops of the last partial course of the support panel **20** (along dash-dot line **41**) are positioned to move along the active path so that with the next swing of the needle cylinder, the first partial course of the upper connector panel or body strip **22** is knit. This first or upper partial course of the connector strip **22** extends substantially half-way around the garment, along the dash-dot lines **41**, **43**, and is joined to the terminal or lower partial courses of each support panel **20**, **21**. Any desired number of partial courses may be knit to complete the required length of the upper connector strip **22**.

Upon completion of the terminal or lower partial course of the connector strip **22**, along the dash-dot line **44**, all active needles, except that group of successive

needles required to knit the first partial course of the narrowed upper gusset **25**, are positioned to move along an inactive path and the narrowing picks of the machine are rendered operative. With continued reciprocation of the needle cylinder, partial courses will then be knit on the active group of needles to form the upper or narrowed gusset **25** of the first breast pocket. During the knitting of this first portion of the upper gusset **25**, the narrowing picks gradually reduce the number of active needles knitting successive partial courses by raising the endmost needles to an inoperative position so that the fabric is gradually narrowed and the stitch loops at opposite selvage edges are held on the needles which are moved to the inactive position.

It is preferred that one needle be moved to inactive position with each stroke of the needle cylinder throughout the knitting of the first portion of the gusset **25** and down to the dash-dot line **45**. At this point, it is preferred that the fabric be narrowed at a faster rate; for example, two-needles with each stroke of the needle cylinder, to complete the knitting of the first upper gusset **25**, down to the dash-dot line **46**.

The widening picks are then rendered operative to begin widening the fabric, preferably by two needles with each swing of the needle cylinder, to form the first portion of the widened lower gusset **27**, down to the dash-dot line **47**. As the endmost needles are gradually brought back into active position in this widening operation, the stitch loops at opposite sides of the gusset **27** are drawn through the stitch loops which had been held on the inactive needles to form suture lines connecting opposite side edges of the narrowed gusset **25** to the opposite side edges of the widened gusset **27**.

Below the dash-dot line **47**, the fabric is widened at a decreased rate; for example, one needle is brought to the active position with each swing of the needle cylinder and the ends of these widened partial courses are joined to the ends of the narrowed partial courses of the upper gusset **25** to complete the knitting of the first breast pocket, along the dash-dot line **48**.

The active needles which knit the last partial course of the widened gusset **27** are then moved to an inactive position and the group of successive needles required to knit the narrowed gusset **24** are moved to the active position to form the first partial course in the narrowed gusset **24**, along the right-hand portion of the dash-dot line **44**. The narrowing picks are moved to the operative position and with continued reciprocation of the needle cylinder, the number of needles knitting the successive partial courses is reduced as the narrowed gusset **24** is knit.

During the knitting of the first portion of the narrowed gusset **24**, down to the dash-dot line **49**, the narrowing picks preferably move one needle to inactive position with each swing of the needle cylinder and the stitch loops are held on the needles as they are moved to inactive position at opposite sides of the gusset **24**. Below the dash-dot line **49**, and down to the dash-dot line **50**, the fabric is narrowed at a faster rate; for example, two needles with each swing of the needle cylinder.

After completion of the kitting of the narrowed gusset **24**, along the dash-dot line **50**, the widening picks are activated so that the fabric is then widened, two needles with each swing of the needle cylinder. These widened partial courses of the widened gusset **26** are connected to the endmost stitch loops at opposite sides of the narrowed gusset **24** to form suture lies connecting the opposite sides of the narrowed gusset **24** to the opposite sides of the widened gusset **26**.

Below the dash-dot line **51**, the fabric is widened at a decreased rate; for example, one additional needle with each swing of the needle cylinder, until completion of the widened gusset **26**, along the right-hand portion of the dash-dot line **48**. Then, all of the inactive needles are moved completely around the cylinder to the active level so that the lower connector or body portion **28** is knit with continuous rotation of the needle cylinder in one direction to form a tubular portion of full courses extending completely around the garment and beneath the breast pockets. As the previously inactive needles are brought into action, those portions of the partial course formed between the widened gussets **26**, **27** and on opposite sides thereof are connected to the stitch loops of the corresponding portions of the terminal or lower partial course of the upper connector strip **22**, which had been held on inactive needles. Any desired number of complete courses may be knit in the body portion **28** to provide a sufficient length to extend substantially to the waist of the wearer.

During the knitting of the waistband portion **29**, the cylinder is rotated while the needles selectively knit and float the yarn to form a repeated pattern, such as that illustrated in FIGURE 5. In FIGURE 5, the wales and courses have been numbered to aid in explaining the manner in which the special stitch is formed in this waistband portion **29**. During the knitting of course **C–11**, stitch loops are formed in every wale and on all needles. As the next four courses C–12—C–15 are formed, the stitch loops on alternate needles, such as those shown in wales **W–1** and **W–3**, are held in the hooks of the needles since these needles are not raised high enough to pick up yarn. During these courses, stitch loops are formed on the intervening needles, such as in wale **W–2**, and the yarn floats behind the elongated held stitch loops in wales **W–1** and **W–3**. In courses **C–16**—**C–19**, the yarn is fed to every needle and forms stitch loops in every wale.

This pattern, as shown in courses **C–11**—**C–19** may be repeated any desired number of times, such as eight times, to complete the knitting of the waistband portion **29**. The knitting of this type of pattern, when using a stretchable type yarn, causes the fabric to take on a somewhat waffle appearance and the elongated stitch loops contract to form depressions in the fabric. The floated portions also tend to contract and draw in the fabric in this area of the waistband portion **29** to thereby provide a better fit around the middle of the garment so that it snugly engages the waist of the wearer and provides an attractive reference line around the center of the garment.

Below the waistband portion **29**, any desired number of complete circular courses may be knit in the upper portion of the lower trunk covering portion **16**, before the fashioning or shaping of the lower trunk portion begins, to form what may be termed a plain portion **55** (FIGURE 6). The lower portion of the lower trunk covering portion **16** is shaped or fashioned by the formation of partial courses which extend around at least the rear portion of the garment and less than the complete distance therearound. The partial courses may be of varying lengths and opposite ends of the partial courses terminate substantially equidistant from the middle or center wale of the front portion of the garment.

For ease of description, the first series of partial courses **30** will be referred to as "long" partial courses, since they extend substantially three-fourths of the distance around the garment while the second series of partial courses **31** will be referred to as the "short" partial courses, since they extend substantially one-half the distance around the garment. It is preferred that the formation of the longer partial courses **30** alternate with the formation of the shorter partial courses **31** and that a pair of successive partial courses be formed at each position. It is also preferred that groups of successive full courses be knit between the partial courses. For example, a satisfactory garment has been knit by knitting a pair of long partial courses, eight successive complete courses, a pair of short partial courses, eight complete courses, and then repeating this cycle throughout the knitting of the lower portion of the lower trunk covering portion **16**.

Opposite ends of the adjacent pairs of long partial courses are shown in FIGURE 7 to illustrate the manner in which they are knit between complete courses to increase the walewise length of the fabric. With the needle

cylinder rotating in the normal counterclockwise direction, the complete courses are knit, down to and including the course indicated at C–40 in FIGURE 7. As the needles successively pass through the stitch cams and form stitch loops, the partial course indicated at C–41 is knit while the needle cylinder is moving in counterclockwise direction, and the last stitch loop to be formed in this partial course is knit in wale W–11.

The needle cylinder then swings in the clockwise direction and the first needle to knit forms the stitch loop in wale W–11 of partial course C–42. The last needle to knit in the formation of the partial course C–42 is formed in wale W–81. The needle cylinder then swings in the counterclockwise direction and the first needle to knit forms the first stitch loop of partial course C–43 in wale W–81. With continued rotation of the needle cylinder in the counterclockwise direction, the full course C–44 and the subsequent complete courses are formed.

While the partial courses C–41—C–43 are being formed, the stitch loops in the wales W–12—W–80 of full course C–40 are held on the needles which have been moved to the inactive position. As the full course C–44 is formed, all needles are again active so that the stitch loops in wales W–12—W–80 of course C–44 are joined to the corresponding stitch loops in course C–40. The short partial courses 31 are formed in the same manner just described for the formation of the long partial courses 30, except that different groups of needles are involved.

Any desired number of full courses may be knit between the pairs of long and short partial courses 30, 31. It has been found that satisfactory shaping of the lower portion 16 may be provided by knitting eight full courses between each pair of partial courses.

After the desired length of tubular fabric is knit to complete the lower trunk covering portion 16, a turned welt 32 may be formed on the knitting machine by knitting on alternate needles only while holding the stitch loops on the intervening needles until a length of fabric two times the desired width of the hem is formed. Then, all needles knit for one or more courses to form the turned welt 32, as shown in FIGURE 4. If desired, the fabric may be knit plain at the lower end and the welt may be formed by turning up a portion of the lower edge and sewing the same together.

While the knitting of the various sections of the garment shown in FIGURES 1–3 has been described as proceeding in a particular manner, it is to be understood that this particular procedure need not necessarily be followed. For example, this garment has been described as being knit from the top to the bottom wherein the breast pockets are knit prior to knitting the lower trunk portion 16. However, it is possible to knit the garment in the reverse order; i.e., starting at the lower end of the lower trunk covering portion 16 and knitting the breast covering portion 15 last. Also, the strap portions 18, 19, support panels 20, 21, and breast pockets may be knit in a different order than that described and it may be desirable to simultaneously knit the strap portion 18, 19, the support panels 20, 21, and the breast pockets. This may be accomplished by use of a knitting machine having knitting stations at opposite sides of the needle cylinder.

The knitting of the strap portions 18, 19 and the support panels 20, 21 may be eliminated when the blank is to be used to form a strapless type garment. Also, the upper part of the blank may be cut along a curved line to remove portions of the support panels 20, 21, if desired.

The modified form of garment shown in FIGURES 8–10 is very similar to the first form of garment shown in FIGURES 1–3 and the corresponding parts of the second form of garment will bear the same reference characters with the prime notation added. The lower trunk covering portion 16′ is knit in an identical manner to that described in connection with the first form of garment and the upper breast covering portion 15′ may be knit in the same manner and then cut so that the upper back portion of the garment extends across the back of the wearer at a lower level. For example, the blank shown in FIGURE 6 may be cut along curved dash-dot lines 56, 57 to remove a portion at the upper edge of the body panel 28 and lower the upper edge of the back portion of the garment. The cut selvage edge may be sewn with an overedge seam or suitable binding material may be connected therealong to prevent raveling.

The V-shaped upper front opening of the garment of FIGURES 8 and 9 extends further down and between the breasts pockets. This may be accomplished by cutting the garment blank of FIGURE 6 along the dash-dot lines 58, 59. The outer portions of the support panels may also be cut along the dash-dot lines 60, 61 (FIGURE 6) so that the edges blend into the curved lower back portion. These cut edges may be provided with an overedge seam or suitable binding tape or the like to prevent raveling. The complete upper edge of the garment shown in FIGURES 8–10 may be provided with a binding edge, if desired.

The third form of garment (FIGURE 11) is adapted to cover only the lower trunk portion of the body of the wearer and is shaped during the knitting process in an identical manner to that described for the lower trunk portion 16 of the first form of garment. The corresponding parts of this garment will bear like reference characters with the double prime notation added. If desired, knitting of the garment 16″ may begin with the formation of the waistband 29″ of special stitches, such as that shown in FIGURE 5. Also, this garment of FIGURE 11 may be knit with a turned hem or welt at the upper edge.

Below the waistband portion 29″, complete courses are knit with continuous rotation of the needle cylinder and long partial courses 30″ and short partial courses 31″ are alternately formed at spaced intervals during the knitting of the complete courses to shape or fashion the garment so that the wales in the rear portion are longer than the wales in the front portion. This garment of FIGURE 11 may be worn as a tubular girdle, or it may be modified to form leg openings by adding a crotch piece or a panty-type liner may be attached up inside of the lower end. In this case, this garment of FIGURE 11 may be used as the lower portion of a two-piece bathing suit or the like.

Thus, in each modification of the garment of the present invention, the various portions of the garment are shaped during the knitting process to substantially conform to the configuration of the corresponding portions of the body of the wearer. A one-piece seamless garment is provided which may be formed to cover substantially the complete torso of the wearer, including breast covering fashioned pockets in the upper portion thereof and a fashioned lower trunk covering portion or which may be formed to cover only the lower part of the trunk.

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

I claim:

1. A form-fitting seamless knit garment including integrally knit upper breast covering and lower trunk covering portions, said upper and lower portions being fashioned to conform to the shape of the corresponding portions of the body of the wearer, said upper portion including a pair of fashioned breast-receiving pockets, said lower portion being tubular and comprising groups of successive complete courses extending completely around said lower portion, a first series of partial courses formed between the groups of complete courses and extending less than the complete distance around said lower portion, each of said partial courses of said first series being the same length, a second series of partial courses formed between the groups of complete courses, said partial courses of said second series being the same length and

being of less length than said partial courses of said first series, said partial courses being reciprocatorily knit and being spaced throughout substantially the complete length of the garment, said partial courses increasing the length of the wales in at least the rear half of the lower portion to provide a greater amount of knit fabric therein and to provide a comfortable fit across the rear portion of the garment.

2. A garment according to claim 1 including a waistband portion connecting said upper and lower portions, said waistband portion comprising spaced groups of successive courses including elongated held loops in alternate wales with floats therebehind and plain stitch loops in the intervening wales, and groups of successive courses consisting of plain stitch loops and being positioned between said spaced groups of courses.

3. A form-fitting seamless knit garment adapted to cover the lower trunk and being fashioned to conform to the shape of that portion of the body of the wearer, said garment being tubular and comprising groups of successive complete courses extending completely therearound, and a first series of partial courses formed between the groups of complete courses and extending less than the complete distance therearound, each of said material courses of said first series being the same length, a second series of partial courses formed between the groups of complete courses, said partial courses of said second series being the same length and being of less length than said partial courses of said first series, said partial courses being reciprocatorily knit and being spaced throughout substantially the complete length of the garment, said partial courses increasing the length of the wales in at least the rear half of the garment to provide a greater amount of knit fabric therein and to provide a comfortable fit across the rear portion of the garment.

4. A garment according to claim 3 wherein said partial courses of said second series extend substantially half the distance around said garment, and said partial courses of said first series extend substantially three-fourths of the distance around said garment.

5. A garment according to claim 4 wherein said partial courses of said first and said second series alternate in said lower portion.

6. A garment according to claim 5 wherein said partial courses of said first series are equally spaced between adjacent pairs of said partial courses of said second series.

7. A garment according to claim 6 wherein said partial courses of each series consist of a pair of partial courses.

8. A method of knitting a form-fitting seamless garment adapted to cover substantially the complete torso of the wearer and including integrally knit upper breast covering and lower trunk covering portions, said method including the steps of successively knitting groups of narrowed and widened partial courses joined at opposite ends to form one breast-receiving fashioned pocket, successively knitting groups of narrowed and widened partial courses spaced from the first group and joining the partial courses at opposite ends to form a second breast-receiving pocket spaced from the first breast-receiving pocket, knitting a plurality of full courses below and connected to the breast pockets to complete the upper portion of the garment, continuing to knit full courses in the formation of the lower trunk covering portion, and while knitting first and second series of partial courses between certain of the full courses and throughout substantially the complete length of said lower trunk covering portion, knitting said partial courses of said first series of the same length and of a sufficient length to extend around at least the rear half of the lower portion, knitting said partial courses of said second series of the same length but of less length than said partial courses of said first series, said partial courses providing a greater amount of knit fabric and a comfortable fit across the rear portion of the lower trunk covering portion of the garment.

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