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(71) Applicant: **MATEC S.r.l.**
50018 Scandicci (Firenze) (IT)

(72) Inventors:
• **Lonati, Francesco**
25100 Brescia (IT)

- **Lonati, Tiberio**
25100 Brescia (IT)
- **Lonati, Ettore**
25100 Brescia (IT)
- **Lonati, Fausto**
25100 Brescia (IT)

(74) Representative:
Modiano, Guido, Dr.-Ing. et al
Modiano & Associati SpA
Via Meravigli, 16
20123 Milano (IT)

(54) **Method for forming hosiery items or tubular knitted items having a closed end with a circular hosiery knitting machine**

(57) A method for producing hosiery items or tubular knitted items having a closed end with a circular hosiery knitting machine provided, proximate to the needle work area, with a transfer element which faces one half of the needle cylinder and is provided with thread takeup elements (1) which can be actuated radially to the needle cylinder and are suitable to engage the thread or threads fed by at least one feed of the machine, in the region between two contiguous needles. The transfer element is able to turn over about a diametrical axis (7) of the needle cylinder. The method consists in performing a first step, during which the needle cylinder is actuated with n oscillations about its own axis (5) with an oscillation angle of substantially 180° , in order to cause the passage, in front of a thread feed of the machine, of a first half (3a) of the needle cylinder which is faced by the transfer element. During this first step, the corresponding thread takeup elements (1) that are arranged in a sector that is less than 180° wide are extracted from the transfer element and $1/n$ of the needles (2a) of the first half (3a) of the needle cylinder are lifted into the active position at each oscillation and are then lowered after taking up the thread or threads, which rests or rest on the takeup elements (1) extracted from the transfer element. A second step is then performed during which the previously extracted takeup

elements are retracted into the transfer element so as to retain the thread that is rested on them. Then a third step, during which heel knitting is performed with the needles of the first half (2a) of the needle cylinder (3a), and a fourth step, during which the transfer element is turned over about the diametrical axis (7) and made to face the second half (3b) of the needle cylinder, are performed. During a fifth step, the thread or threads retained by the takeup elements (1) and the knitted loops are transferred from the needles (2a) of the first half (3a) of the needle cylinder that are arranged laterally to the sector of the transfer element to the needles (2b) of the second half (3b) of the needle cylinder. Finally, the machine is actuated so as to complete the item as a continuation of the previous processes.

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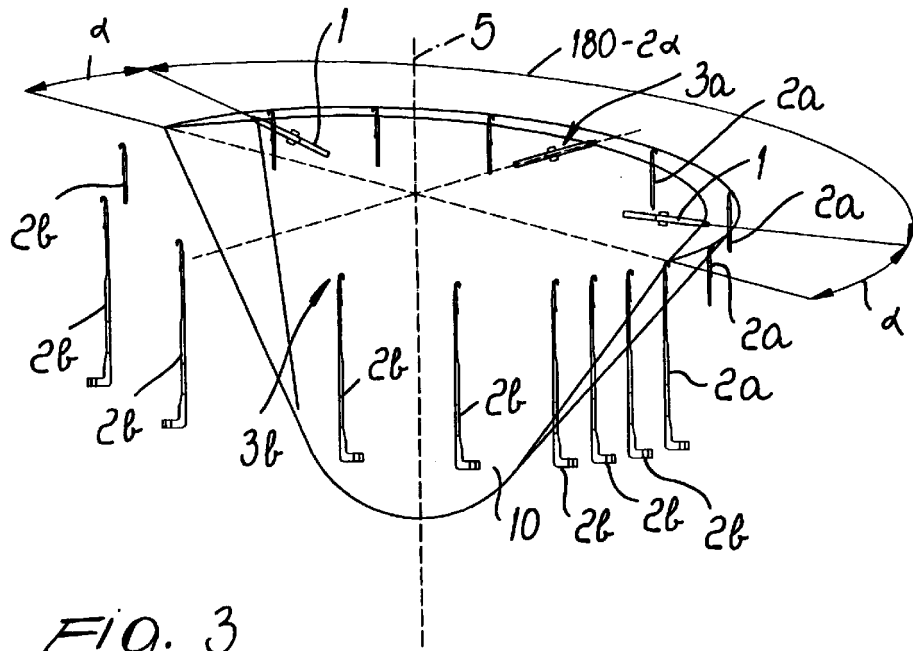


Fig. 3



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EUROPEAN SEARCH REPORT

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			D04B
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 30 August 1999	Examiner Van Gelder, P
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			

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