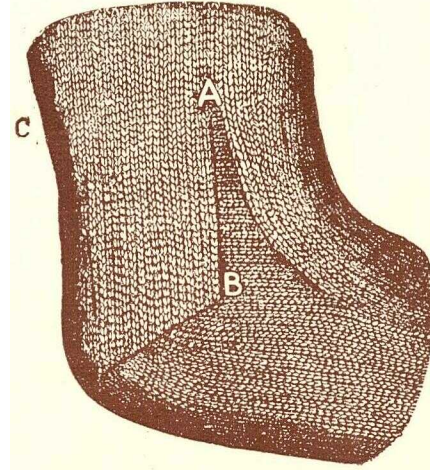


67. Gored or gusset-heel :

1. After knitting leg and ankle the usual length,
2. Stop the yarn-carrier on the back or at A.
3. Raise out of action half the needles on front or C ;
4. That is all needles on front of cylinder-line BD.
5. Knit instep flat-web, on back half, about 22, 24, 28 or 30 rows according to cylinder.
7. Stop the yarn-carrier at front or at C.
8. Lift entirely out of cylinder with stitches on
9. All needles on the back of the machine.
10. Place them within the needle-cylinder.
11. Put down the needles on the front of machine.
12. Knit flat-web-heel on front needles, exactly
13. The same number of rows as knit on instep flat-web.
14. Raise half the heel needles on opposite side to yarn,
15. Less three in the centre of flat-web-heel.
10. Knit across and raise half the needles



17. On the other side of the flat-web-heel.
18. Three needles will now remain down in centre.
19. Put down two needles on the side opposite yarn.
20. Knit one row and put down two needles
21. On the other side of heel opposite yarn ;
22. And so on, each row knit, put down two needles,
23. Until the heel needles are all put down, thereby
24. Forming bottom part of heel, like bottom of round-heel.
25. Put a new set of needles in, on back of machine.
20. Place stitches on half of back needles from left selvedge.
27. Place stitches on the other half from the right selvedge.
28. That is, lift heel stitches of selvedge A to B as shown in cut.
29. All needles should now be in the cylinder.
30. The gusset is now formed flat-web as follows :

68. Forming Gusset :

1. Narrow in the middle of web at back or at A,
2. Twice, once on each side of gusset at A.
3. Make the narrowings, one needle from the edge of web.
4. Knit two rows backward and forward, and
5. Raise the needles on each side of web to allow cams to pass.
6. Make one narrowing on each side of gusset.
7. Again knit two rows flat-web and raise needles each row.
8. Continue knitting two rows and making the
9. Narrowings on each side, until all the needles
10. On back half of cylinder are again removed.
11. Now place in the cylinder the needles lying on
12. The inside of cylinder with their stitches on.



13. All needles will again be in the machine.
14. Knit foot the usual length from 0 to 10 inches.
15. Join the instep selvedge to gusset selvedge
16. With the flat web stitches described page 29.



Bottom of heel. The bottom part of heel may be knit by removing all needles entirely out of cylinder with their stitches on, except three needles in the middle of flat-web-heel. Then widen out, by placing the stitch of the first needle on the inside of cylinder, on each side, on each of the side needles of the three. Then place an extra needle in the grooves on each side of the three needles. After placing stitches thereon, knit two rows, back and forward on the five needles, and so on. Narrow one needle on each side, and place an extra needle in on each side until all the needles lifted out of each side of heel are again back in cylinder, Then proceed with gusset as described.