



## Step by Step Blueprint For Setting Up Basic Small Lettering

Creating small lettering that will sew out great on all types of fabrics is very simple to do. If you will simply follow the following Blueprint for setting up your lettering, this will work! You want the edges of your lettering to be crisp and clean when you sew it out. Make sure that you are applying topping to your knit fabrics.

**Step 1- Select your lettering Font Style**

**Step 2 - Select the correct Font Size.** Your size is going to depend on your application. For Block, the basic size for most left chest designs is .20 to .50 inches. It all depends on the amount of and style of letters. Some block fonts are wider than others.

**Step 3 - Set your Parameters** the way that you want it. By that I mean changing the width, the alignment, the position and the baseline.

**Step 4 - Apply the Pull Compensation**

**Step 5 - Apply your Underlay Stitching** according to the width of the letter and the type of material that the design is going to be sewn on. - Measure to see what type of underlay your lettering will need.

**Step 6 - Reposition each letter** so that each one is almost touching the next letter. By that I mean when you zoom in and see where your stitch points are, they should be almost but not quite touching each other. If they are not correct, move them so that they in fact are almost touching each other. The outline or wireframe of the letter with the stitches turned off will be how the letter will be spaced when it is sewn.

**Step 7 - Check to make sure you have your basic lock** at the beginning of the word and at the end of the word.

**Step 8 - Apply a trim at the end of the word.**

**Step 9 - Convert your line into Segments.** The object here is to have it look like it is a digitized line of the design. It will no longer be text lettering. You will see your dots (anchors) all around each letter when you click on it.

**Step 10 - If you have lower case i's in the wording,** you will break these 2 pieces apart also.

If you only have the **Composer or Creator level** of the **Pulse Lettering** program, you will not be able to break the dot and the lower part of the i apart. You must select your i, go up to **Properties**, click on **Quality Control** and then select **Trim Between Islands**.

**Step 11 - Move the dot of the i to sew last in your word if you have Illustrator Extreme level or above.** You do not want these 2 pieces to sew at the same time if at all possible.

**Step 12 - Place a lock knot at the beginning of your dot and at the end of your dot** and a trim. Sometimes you will need to make the dot just a bit larger than it is in order for it to work and not sink into the garment.

**Step 13 - Move the start and stop on the stem of the eye** so that it is connecting in the right place to the letter in front of it and after it. You want an even flow going from the letter in front of it to the next letter at the closest point.

**Step 14 - Apply your lock knots or Start Locks** at the beginning of the word and the **End Lock** on the end of the word. Do not place the **End Lock** on the very end of the letter. Move the **End Lock** up by 2 stitches. One stitch will not work, it must be 2 stitches.

**Step 15 - Check the alignment of your lettering to make sure they will sew out straight and inline.** You will need to add guide lines under the letters and on top of the letters to make sure that they are all going to sew out straight and all on the same level when sewn out. Below are the measurements that you will need between your guidelines. This is important if you want great quality lettering.

1" Letter - .60 millimeters

½" Letter - .30 millimeters

¼" Letter - .20 millimeters

4 mm Letter - .10 millimeters

**Step 16 - Sew out your sample**

**Step 17 - If it sewed out great-save as your design name for future use. If not, adjust it, and sew it out again.**

**Step 18 -Save your design again.** If it is for a regular customer; save it in their own folder.

## **Basic Settings for Woven Fabrics**

**The minimum width for any Satin Stitch column is 1 millimeter.**

**Basic Standard Pull Compensation** - .2 mm -or 2 points.

If lettering or satin stitch line is too thin, you can increase it by adding more pull comp. Increase it by .1 millimeter or 1 point at a time and then sew it out and see if it is better.

**Basic Underlay Settings** - For lettering or satin stitch columns 1.5 millimeters in width, use a Contour underlay .50 millimeters or 5 points from the edge.

If it is less than 1.5 millimeters, use a Center run underlay. Change your stitch length to 1.5 millimeters or 15 points.

**Density**- For lettering or columns under 5 millimeters in height, use a density of approximately 56 stitches per inch, or 4.5 points or .45mm depending on the weight and bulk of the fabric. If fabric is bulky or heavy, you may have to increase your density. Test it out.

## **Basic Settings for Knit Fabrics**

**The minimum width for any Satin Stitch column is 1 millimeter.**

**Basic Standard Pull Compensation** - .3 mm -or 3 points.

If lettering or satin stitch line is too thin, you can increase it by adding more pull comp. Increase it by .1 millimeter or 1 point at a time and then sew it out and see if it is better.

**Basic Underlay Settings** - For lettering or satin stitch columns 1.5 millimeters in width, use a Contour underlay .50 millimeters or 5 points from the edge. If it is less than 1.5 millimeters, use a Center run underlay, 1 line. Change your stitch length to 1.5 millimeters or 15 points.

**Second Underlay - Zig Zag** - Applying Zig Zag does not always work is you are creating a very tiny letter. If your lettering is over .45 inches, the Zig Zag will work great. If it is under .20 inches, it usually does not work. It creates to many stitches and may give you a ragged look. This all depends on the fabric that you are working with. You must experiment to find the best results.

**Third Underlay** - If it is a letter .50 inches or over, you will first apply 1 line of center run, then apply Zig Zag underlay at .20 millimeters from the edge and then a Contour underlay in that order.

**Density**- For lettering or columns under 5 millimeters in height, use a density of approximately 56 to 60 stitches per inch, or .5 points depending on the weight and bulk of the fabric. If you are not using Zig Zag underlay, you will need to increase your density by at least 5 stitches per inch or .2 points.

## **Basic Settings for Terry Fabrics**

**Small to Medium Sized Lettering on Terry Use A Topping**  
**The minimum width for any Satin Stitch column is 1 millimeter.**

**Basic Standard Pull Compensation** - .3 mm -or 3 points.

If lettering or satin stitch line is too thin, you can increase it by adding more pull comp. Increase it by .1 millimeter or 1 point at a time and then sew it out and see if it is better.

**Basic Underlay Settings** - For lettering or satin stitch columns 1.5 millimeters in width, use a Contour underlay .50millimeters or 5 points from the edge. If it is less than 1.5 millimeters, use a Center run underlay, 1 line. Change your stitch length to 1.5 millimeters or 15 points.

**Second Underlay - Zig Zag** - Applying Zig Zag does not always work is you are creating a very tiny letter. If your lettering is over .45 inches, the Zig Zag will work great. If it is under .20 inches, it usually does not work. It creates to many stitches. This all depends on the fabric that you are working with. You must experiment to find the best results.

**Third Underlay** - If it is a letter .50 inches or over, you will first apply 1 line of center run or perpendicular underlay, Zig Zag underlay and then an Edgerun or contour underlay in that order.

**Density**- For lettering or columns under 5 millimeters in height, use a density of approximately 56 to 60 stitches per inch, or .5 points depending on the

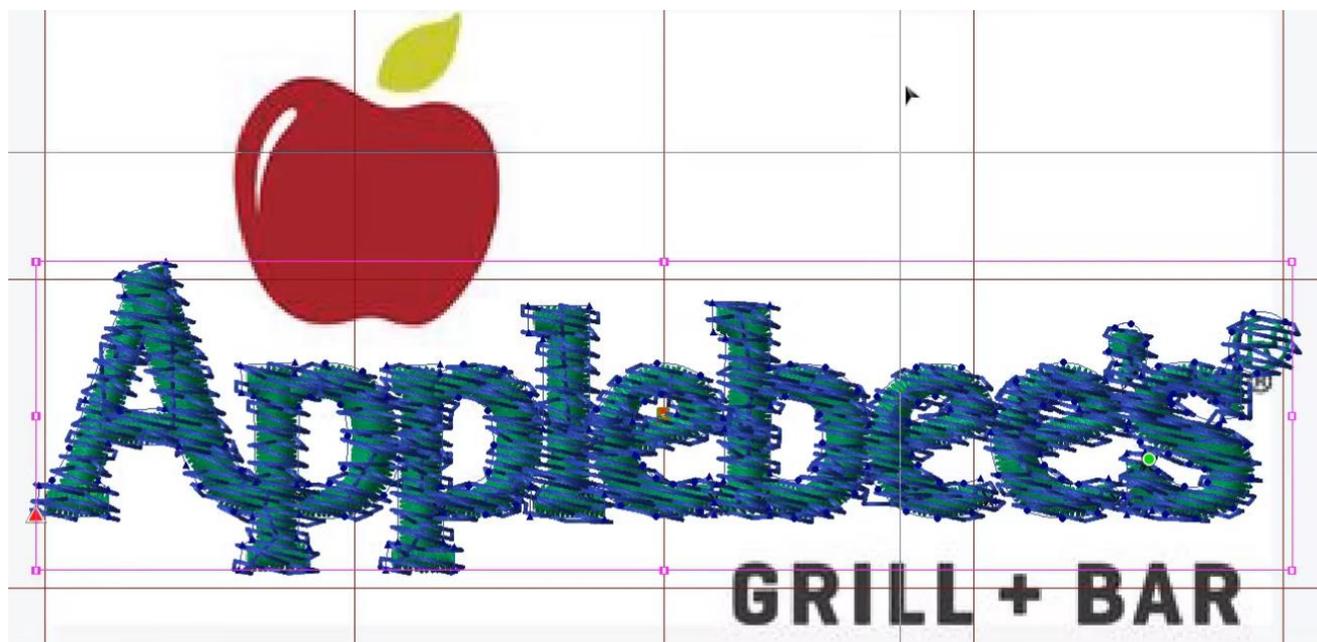
weight and bulk of the fabric. If you are not using Zig Zag underlay, you will need to increase your density by at least 5 stitches per inch or .2 points.

### Add A Topping When Sewing

Make sure you add a topping or solvy before sewing out the lettering or small monogram. This is a must if you want the lettering to stand out and not get lost in the terry loops.

### **Adding A Fill Background To Keep The Lettering From Sinking Into The Terry**

On terry fabrics, if you are creating small lettering to go on terry, you must lay down an area of light complex fill or tatami stitches that will sit under your lettering so that it does not sink into the terry. You want this fill stitch area to be the same shape as your line of lettering. I do not lay down a large square or rectangle fill area.



**(If in doubt as to how to do this, watch the video inside of “How To Embroider Small Lettering” where I add a background under the word Applebee’s. This will give you the exact technique.)**

This can also be done for a monogram on a towel if you do not want to use a topping or if it is an unusually thick terry. I have worked with terry cloth that was so thick and had loops so long that no matter how much underlay and

topping you used, the loops still covered the lettering when finished. If you run into this, it is best to use the fill stitches and also a topping.

**Step 1-Create your lettering**, and have it set exactly how you want it with the alignment, underlay and density.

**Step 2-Create a fill stitch** that is the same shape as your lettering but will extend out about .4 or .6 millimeters beyond your lettering. You will sew out the fill stitch the same color as the fabric and it will hardly show.

**Step 3-Decrease the density of your fill stitch** by about 15 to 20 stitches per inch. This is going to depend on the weight and length of loops on your terry.

**Step 4-Apply the Pull Comp** of about .6 or .8 millimeters on the fill stitch. (*If the loops are unusually long, you will need to increase the pull comp even more.*)

**Step 6-Change the angle of the fill stitch** so that it is sewing at about a 45 degree angle. If you are adding a fill stitch to the terry, you will use the same settings that you would use for a knit fabric.

## For Large Letters or Monograms on Terry-Use A Topping

**Basic Standard Pull Compensation** - .4 mm -or 4 points. - As the Monogram increases in size, so does the pull compensation setting. On large monograms the center letter will have a lower pull compensation setting than the small side letters. You want the columns to end up closer to the same width so you add more pull comp to the smaller letters to help widen out the column. In some software programs you have an additional column width setting that is separate from the Pull Compensation. If you do not have this option, just add more pull comp.

**Underlay** - You will need to adjust this according to the thickness of your terry. The thicker the terry, the more underlay you will need. For most of my monograms on terry, I use 3 layers of underlay.

**Layer 1-Center run or 2 or 3 lines of perpendicular.** It all depends on what your software will allow.

**Layer 2-Zig Zag.** - Increase the density on your underlay. You want a very heavy density. Increase it by 15 or 20 stitches per inch for the large letters and 5 to 10 stitches per inch on the small letters.

**Layer 3- Contour Underlay** - This will clean up the edges of the lettering and give you a sharp looking top stitching.

**Density** - Increase the density on your top stitching - For the smaller sized monograms increase your density about 5-10 stitches per inch. For the larger monograms, you will increase your density about 15-20 stitches per inch.

### **Another Option For Monograms on Terry**

If you do not have the capability to use and adjust all of these underlays, Use your basic underlay and do not add any pull comp. Duplicate your monogram so that you have 2 monograms.

On the second monogram, you are going to add pull comp so that the columns of your second monogram are wider than the columns of the first monogram. Sew out the first monogram and then immediately sew out the second monogram.

This will give you some height to your monogram and will give you the same effect as adding several layers of underlay and increasing the density of your underlay.