

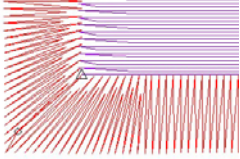
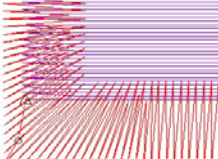



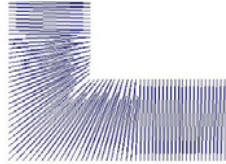

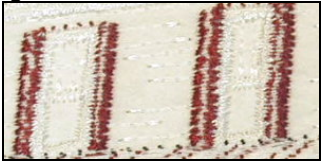






## EMBROIDERY UNQUALITY MATRIX

SEAM UNQUALITY PHOTO OR DRAWING	DESCRIPTION	EXAMPLES
 <p style="text-align: center;"><b>POOR REGISTRATION</b></p>	<p><b>POOR REGISTRATION</b> - where the stitches and design elements do NOT line up correctly. The embroidery sewing process sews different colors at different times. If the fabric shifts while one color is being sewn, then poor registration will occur when the next color is sewn. Sometimes it is difficult to tell the difference between poor registration, poor digitizing, and fabric "grin-through" or "gapping" due to thread "pull".</p>	<p><b>SUGGESTED SOLUTIONS-</b> Generally can be corrected by:</p> <ul style="list-style-type: none"> <li>- Digitized properly</li> <li>- Use appropriate underlay stitches</li> <li>- Hooped properly using correct backing to prevent excessive material flagging</li> </ul>
 <p style="text-align: center;"><b>FABRIC GRIN THROUGH OR GAPPING</b></p>	<p><b>FABRIC GRIN THROUGH OR GAPPING</b> – where the fabric is seen through the embroidery design either in the middle of the pattern or on the edge.</p> <div style="display: flex; justify-content: space-around;"> <div data-bbox="571 849 974 1149">  <p style="text-align: center;">Not digitized to compensate for "Pull" of thread</p> </div> <div data-bbox="974 849 1375 1149">  <p style="text-align: center;">Digitized to compensate for "Pull" of thread</p> </div> </div>	<p><b>SUGGESTED SOLUTIONS-</b> Generally can be corrected by:</p> <ul style="list-style-type: none"> <li>- Digitized properly</li> <li>- Use appropriate underlay stitches</li> <li>- Increase stitch density</li> <li>- Use different fill stitch pattern or direction</li> <li>- Compensate for "Pull" of thread by overlapping fill and satin border stitches</li> <li>- Using appropriate Topping</li> </ul>
 <p style="text-align: center;"><b>POOR HOOPING</b></p>	<p><b>POOR HOOPING</b> – where the fabric around the embroidery looks distorted and does not lay flat.</p>	<p><b>SUGGESTED SOLUTIONS-</b> Generally can be corrected by:</p> <ul style="list-style-type: none"> <li>- Use appropriate Backing &amp; Topping</li> <li>- Make sure sewing operators hoop the garment properly without stretching the fabric too much prior to putting it in the hoop.</li> <li>- Many hoop marks can be steamed or pressed out.</li> </ul>

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 <p><b>POOR QUALITY LETTERING</b></p>	<p><b>POOR QUALITY LETTERING</b> – where the lettering is not sharp and crisp and has jagged edges, etc.</p>	<p><b>SUGGESTED SOLUTIONS-</b> Generally can be corrected by:</p> <ul style="list-style-type: none"> <li>- Digitized properly</li> <li>- Use appropriate stitch selection               <ul style="list-style-type: none"> <li>- outline letter w running stitch</li> <li>- use underlay stitches</li> <li>- fill in with satin stitches</li> </ul> </li> <li>- Use proper stitch density</li> <li>- Use short stitches at corners</li> <li>- Use Topping</li> </ul>
 <p><b>BUNCHING AT CORNERS</b></p>	<p><b>BUNCHING AT CORNERS</b> – where the corners of lettering or shapes are not sharp and crisp but are bunched up or distorted. Usually caused by too much thread in the corners due to poor digitizing. This includes:</p> <ul style="list-style-type: none"> <li>- Not using appropriate stitch selection</li> <li>- Not using “Short” stitches in corners</li> <li>- Poor stitch balance – thread too loose</li> </ul>	<p><b>SUGGESTED SOLUTIONS-</b> Generally can be corrected by:</p> <ul style="list-style-type: none"> <li>- Digitized properly</li> <li>- Use appropriate stitch selection</li> <li>- Use “Short” stitch cornering</li> <li>- Correct Stitch Balance</li> </ul> 
 <p><b>POOR STITCH BALANCE</b></p>	<p><b>POOR STITCH BALANCE</b> – where white bobbin thread shows on the top side of the embroidery. Ideally, the needle thread should be held on the underside of the seam, and not ever be pulled up to the topside. Proper stitch balance can be checked on the underneath or backing side of the embroidery by looking for 2/3 needle thread to 1/3 bobbin thread on Satin stitches.</p>	<p><b>SUGGESTED SOLUTIONS-</b> Generally can be corrected by:</p> <ul style="list-style-type: none"> <li>- Using quality embroidery needle thread</li> <li>- Using quality prewound bobbins</li> <li>- Setting machine thread tensions correctly</li> </ul>  <p><b>2/3 Red Needle Thread to 1/3 Bobbin Thread</b></p>

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 <p style="text-align: center;"><b>VISIBLE CONNECTORS BETWEEN LETTERS</b></p>	<p><b>VISIBLE CONNECTORS BETWEEN LETTERS</b> – where there is visible stitches between letters that detracts from the quality of the image.</p>	<p><b>SUGGESTED SOLUTIONS-</b> Generally can be corrected by:</p> <ul style="list-style-type: none"> <li>- Digitized properly</li> <li>- Use appropriate number of trims between letters</li> </ul>
 <p style="text-align: center;"><b>EMBROIDERY TOO THICK</b></p>	<p><b>EMBROIDERY TOO THICK</b>– where the embroidery is too thick and uncomfortable. Can be caused by too high of stitch density or not using the correct backing for the application.</p>	<p><b>SUGGESTED SOLUTIONS-</b> Generally can be corrected by:</p> <ul style="list-style-type: none"> <li>- Digitized properly</li> <li>- Use appropriate stitch selection</li> <li>- Use fewer stitches</li> <li>- Use “Short” stitches on corners</li> <li>- Make sure stitch is balanced properly</li> <li>- Use smaller thread size</li> <li>- Use the correct backing</li> <li>- Correct type &amp; Weight</li> </ul>
 <p style="text-align: center;"><b>MISSED TRIMS</b></p>	<p><b>MISSED TRIMS</b> – where threads are left on the embroidery pattern between images or lettering. Thread trims are digitized when changing colors and when moving from one location to another using “jump” stitches.</p> 	<p><b>SUGGESTED SOLUTIONS-</b> Generally can be corrected by:</p> <ul style="list-style-type: none"> <li>- Digitizing properly</li> <li>- Use appropriate number of trims</li> <li>- Use appropriate Tie-Off stitches</li> <li>- Trimming knives replaced when necessary</li> <li>- Missed trims should be hand trimmed using snips.</li> </ul>

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<p style="text-align: center;">(Picture Not Available)</p> <p style="text-align: center;"><b>FABRIC DAMAGE – NEEDLE HOLES</b></p>	<p><b>FABRIC DAMAGE – NEEDLE HOLES</b> – where the fabric is damaged around the corners of the embroidery. Caused by 1) not using the correct type and size of needle; 2) putting too many stitches in the same location; 3) tearaway backing not tearing properly allowing the fabric to be damaged as the stitches are pulled out.</p>	<p><b>SUGGESTED SOLUTIONS-</b> Generally can be corrected by:</p> <ul style="list-style-type: none"> <li>- Digitizing properly</li> <li>- Reduce the stitch count in the corners</li> <li>- Use the correct type and size of needle</li> <li>- Use a ball point needle as small as possible</li> </ul>
<p style="text-align: center;">(Picture Not Available)</p> <p style="text-align: center;"><b>EXCESSIVE SEAM PUCKERING</b></p>	<p><b>EXCESSIVE SEAM PUCKERING</b> – where the fabric is puckered at the embroidery.</p>	<p><b>SUGGESTED SOLUTIONS-</b> Generally can be corrected by:</p> <ul style="list-style-type: none"> <li>- Use quality embroidery thread</li> <li>- Use correct backing</li> <li>- Use minimum thread tensions</li> <li>- Make sure fabric is hooped properly</li> <li>- Use minimum number of stitches to achieve a quality embroidery</li> <li>- Use as small of a needle as possible</li> </ul>