

I Hate Hats!



Presented by:
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4 Steps For Success

The Basics



- Is it a cap?

Digitizing



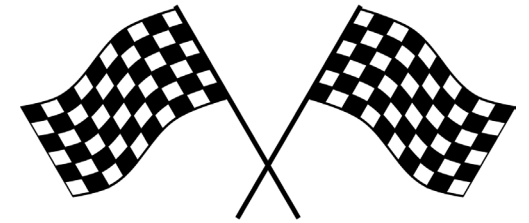
- Correctly digitize design

Hooing



- Correctly hoop cap

Speed



- Adjust sewing speed

The Basics – Caps/Hats

For best results:

- **Unstructured and low-profile caps:** Keep design under 1.8 inches tall
 - **Structured mid-profile caps:** Keep design under 2 inches tall
 - **Pro style and 5 panel caps:** Keep design under 2.25 inches tall
1. The taller the cap, the larger the design can be.
 2. All cap frames on embroidery machines, sew caps upside down.
(Turn design 180 degrees)



Variety is the spice of life but when sewing a cap/hat, don't sew too **BIG!**

The Basics – Beanie – Skull – Snow Caps

Simple...
It's not a hat...

Hoop it flat!



Pro Tip

Always use cut-away backing and Solvy™

Digitizing – The Most Important Step

Centered out – Bottom up



Digitizing – Design Placement

On Most Cap/Hat Embroidery Machine Systems

The lowest you can sew is 0.5 inches from the strap to the needle.

Allow room for the pressure foot.



Digitizing – Cap Seams



Plan ahead for seams on cap (6 panel cap)



Adding **pull compensation** can greatly improve the quality of the sew out.

This can be done on most machines by using the **SATIN** settings.

Digitizing – Back Of Caps



- Sewn with traditional hoop
- Plan for seams
- Curve to fit cap lines

Digitizing – Cap Front & Sides



Your Cap Frame – Most 270 degree frames have a 13" turning area left or right.

This gives you a 12.5" sewing area. (Includes 0.5" safety margin.)



Pro Tip

If you only need to sew on one side of the hat, use a GHOST stitch.

Digitizing – Puffy Foam™ On Cap



**Puffy Foam™ is
always sewn last**



**Tape Puffy Foam™
in place.**



**Finish cleanup of
Puffy Foam™ with a
heat gun.**

Hooping Cap Properly



**Always hoop as tight as possible
and as consistently as possible**

This is especially true for multi head machines

Hooing – Cap Driver

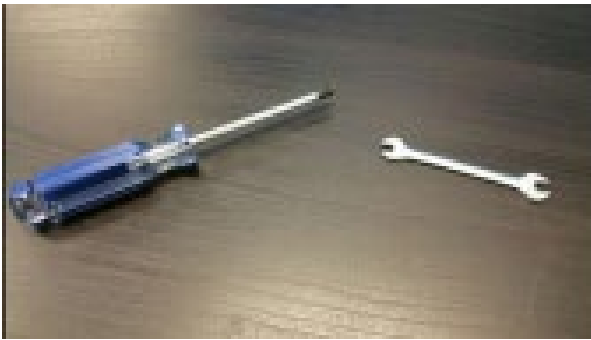


**There are different styles of cap drivers.
They all do the same thing.**

They rotate the cap during embroidery.

Hooing – Choosing The Right Tools

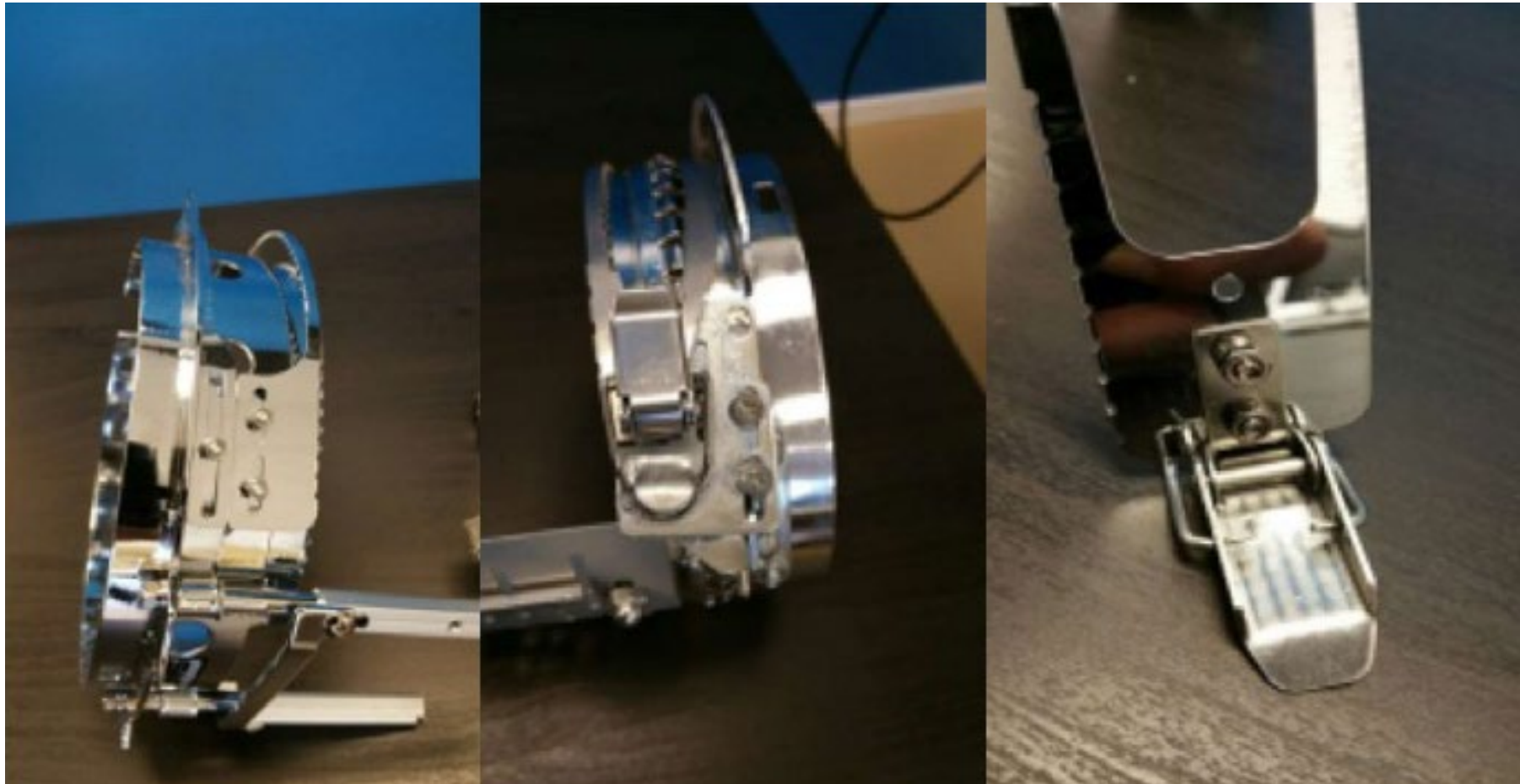
Some machines have a separate needle plate for caps



5.5 millimeter

Hooing – Cap Frame Adjustment

Adjustments can be made to the cap frame based on the thickness of the cap



Hooping – The Gauge

The Gauge: The hooping device for caps



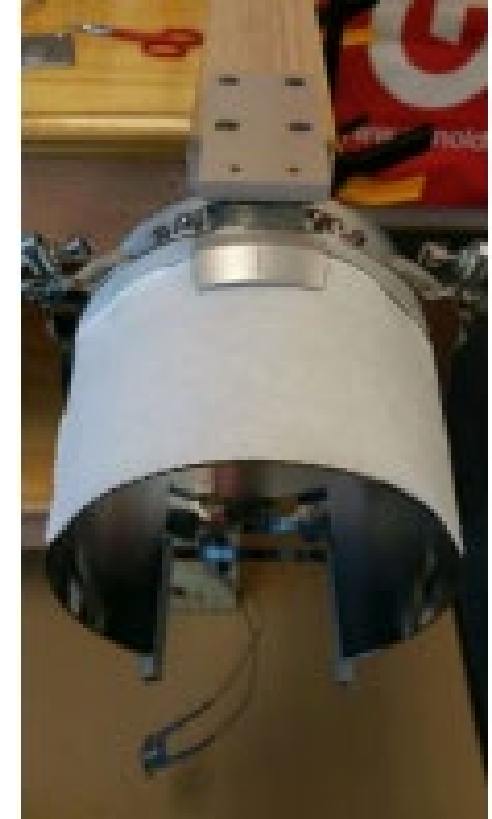
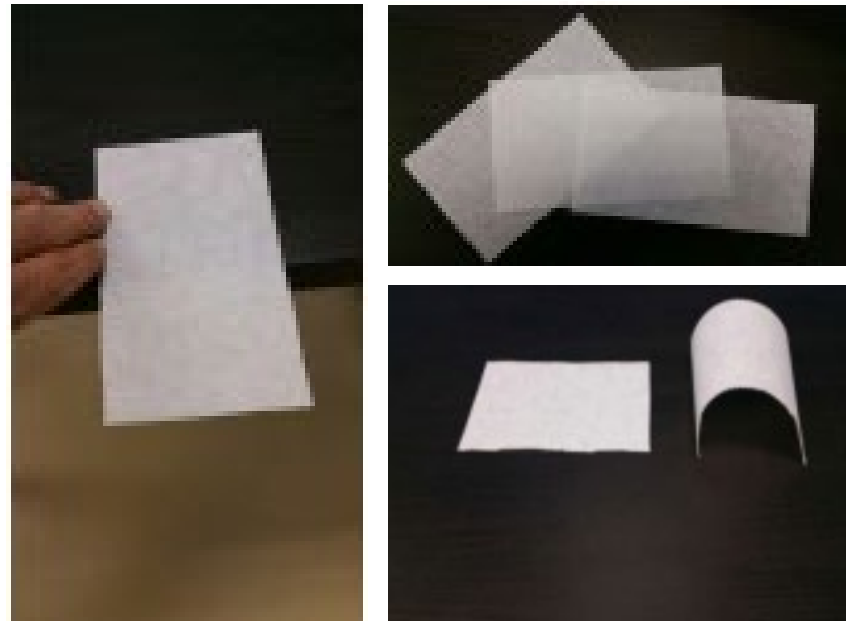
The drum on the hooping device (gauge) matches the drum of the cap driver.

Hooing – Cap Backing



From this...

Curve your cap backing!
The cap driver is round not flat!



To this...



Always use cap backing! 2 layers work best on unstructured caps.

Hooing – The Strap

**The Strap:
Holds the cap in place on the frame**



The strap **MUST** be in the seam of the bill from one side to the other.
This is what holds the cap in place.

Hooing – The Strap & The Side Of The Cap



- Keep the cap sides straight
- Keep the sides hooped in the strap

Hooing – The Clips



**Most all caps need to be clipped
to the bottom of the cap frame.**

The only exception: Any type of Flex or Otto Flex caps.

Speed – Setting Your Machine

Choosing the correct speed is key to good production.

For example: Good production speed on most machines is between 650 and 850 rpm.

Cap Speed: For caps, speed needs to be decreased.

Good production speed for caps is between 500 and 650 rpm.



Pro Tip

More complex designs, as well as thicker caps will require a lower speed.

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Questions And Answers





Thank you for attending!

Don't be a scaredy cat now that you have the facts about cap basics, digitizing for caps, hooping the cap and embroidering on caps!