

Stitchy Business

DECEMBER 2002 ISSUE 3

A NEWSLETTER FOR EMBROIDERY PROFESSIONALS

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BROTHER UNIVERSITY NOW OPEN!!!

**Commercial Embroiderer, Haley Newton
says Brother courses are a huge success!**

"This course has given me so much more confidence and motivation to help my business succeed!", said Haley Newton of *You Name it Sports* in Ft. Smith, Arkansas.

Haley attended the first ever Brother University course on October 23-25, 2002 held at the Hyatt Regency in Anaheim, California. Classes were held between 9 and 4 all three days and were given by instructors Liz Jaspersen, Lawrence Davenport and Freddy Ortega.

Ms. Haley, decided to sign up for this dynamic course because she knew it would help her to realize her business goals. She gained confidence in mastering techniques and received solid information on how to market her business.

The Brother University curriculum was designed and written by embroidery professionals with over 100 years worth of combined experience in every facet of the industry,



Items covered were business ownership, technology, designing a working environment, as well as the latest techniques, outsourcing suppliers, and marketing.

Much more than just a simple how-to seminar, commercial machine embroiderers receive personal hands-on training. Much of the focus is on optimizing business opportunities, as well as the technical aspects of owning or developing a successful commercial embroidery business.

We developed a program based upon a survey sent to existing embroidery customers and incorporated the subject areas they thought they needed to develop. They wanted the opportunity to learn from experienced personnel, and that is how the staff was chosen. These courses are excellent for the home sewing novice trying to get into the business or to enhance an existing commercial

business. This program is part of Brother International's focus on providing ongoing support for our clients who have purchased Brother embroidery machines.

Peter Holland, Sr. Director and General Manager of Brother International Embroidery Division said "These workshops will be a natural progression for a customer who purchases an embroidery machine, as it will support and educate them and give them the tools to build their businesses.

Additional classes are available and are quickly filling up. For more information, visit us online at www.brotheraskus.com/ipd/main.asp, or call Brother toll free 888-444-3167.

Schedule of Classes Available:

January 29 – 31, 2003	Fort Worth, Texas
March 26 – 28, 2003	Bartlett, Tennessee
June 25 – 27, 2003	Cincinnati, Ohio
September 17 – 19, 2003	Somerset, New Jersey

Design Dr.

Adding Pull Compensation to TrueType Fonts

The TrueType Font feature has brought a world of new fonts to our fingertips. Not all of them lend themselves to attractive embroidery, but most of the time the problem lies in their narrow column width. Follow the instructions below for an easy way to apply pull compensation to any TrueType font.

To create a TrueType font, click on the TrueType tool. Right click with the mouse to create a baseline. Type in your text and set the Size, Style, and Multiline Spacing, followed by OK.

The text will now be on the screen. Click on the View drop down menu; select ShowHide, click on Running Stitches and Fill Stitches to hide them, and then click on OK.

Select the text on-screen, press *enter* on the keyboard, and select the Stitches tab. In the top right corner of the Stitches tab enter the desired percentage of pull compensation (for example 30%) in the Pull Compensation value box.

The text will reappear on the screen with the added pull compensation. Return to the *view* menu, select ShowHide, click on Running Stitches and Fill Stitches to turn them on again, and click on OK.

The text is ready to sew. If after doing a test sewout the pull compensation needs to be adjusted, repeat the steps above, entering an adjusted pull compensation value.

Marlys Griggs
Independent Brother Trainer

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Contact your representative today.

Need Help?

The Technical Office in New Jersey has relocated to:

100 Somerset Corporate Boulevard
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OLD NUMBER: 732-764-5700

NEW NUMBER: 908-704-1700

CUSTOMER SERVICE:
KIMBERLY NIN, EXT.3369

SALES MANAGER:
ROBERT TOBIA, EXT.3366

TECHNICAL AND SOFTWARE SUPPORT:
Toll Free 1-877-427-6843



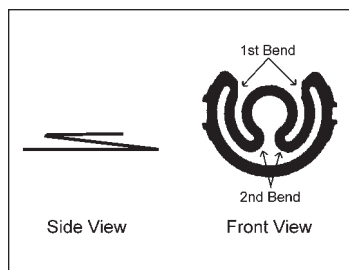
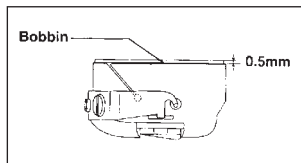
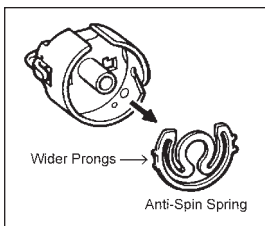
Thread Tensions 1 - 2 - 3

Below are items related to thread tensions and tension problems as found on Brother embroidery equipment. They are listed in the order that they most often occur. Use this form only as a guide. Following this guideline will help with proper tension adjustments to reduce puckering of the fabric and reduce thread breaks. For best results, use genuine Brother parts.

1. Anti - Spin Spring for Bobbin Case

• What is it for?

Also called the “No Backlash Spring”. It is used to keep the bobbin from spinning after the take-up lever has pulled the stitch tight. If allowed to spin this would cause the bobbin thread to be thrown out of the groove in



the bobbin causing a very loose tension as the machine starts up again. Some may say they are not required on embroidery machines, but with the speeds achieved on Brother embroidery machines today, they do make a difference. Running the machine with out one may not cause an immediate problem, but they do make a difference and are needed in these types of machines with jumbo bobbins. It is strongly recommended when replacing one, to replace it with a Brother Anti-

Spin Spring p/n#S35583001, which comes in the Brother bobbin case assembly p/n#S35584001.

• When do you check it?

At installation of machine and at every bobbin change.

• How do you check it?

Install a brand new bobbin, (for the correct weight), in the bobbin case. Hold bobbin case level with open side up or lay upside down on a table. The bobbin should be .5mm above the top of the bobbin case. I recommend the

pre-wound, with two cardboard sides that have a serration on the flat surface of the cardboard. This helps slow down the bobbin when in machine.

• How do you adjust it?

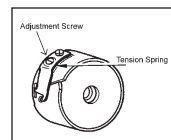
Remove the spring by taking it out with a small slotted screwdriver. Note how you took the anti-spin spring out of the bobbin case to adjust it, as it will only go back in properly one way. You will need to bend the spring in two places so that the spring will be even against the bobbin as illustrated. Re-insert the spring and recheck your adjustment. Try to make it as even as possible all the way around the bobbin case. You may need to repeat this procedure a few times until it is correct.

2. Bobbin Case Tension

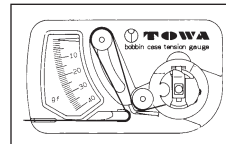
• What is it for?

To keep under thread tension constant, works with top thread to form a proper stitch.

• When do you check it?

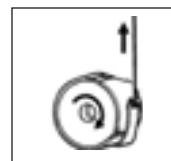


At install and at every bobbin change. When tensions are believed to be the problem, **ALWAYS** check and adjust bobbin first if necessary. The bobbin tension will change over time due to lint build up underneath its tension spring.



• When do you clean it?

Clean the bobbin case when you can no longer get enough tension on the bobbin. For example, when the adjustment screw is turned all the way down or the bobbin tension becomes erratic.



• How do you clean it?

Loosen the adjustment screw until the spring lifts off the bobbin case about 1mm. You may want to do this over a table just in case you loosen the screw too much and it falls out. It will make it easier to find. Then using the corner of a piece of backing, rub underneath the spring to remove any lint buildup. Then adjust by retightening the screw and recheck your tension.

• How do you adjust it?

One of the most accurate ways to check the bobbin tension is with a bobbin tension gauge. The gauge will take into account the pressure of the anti-spin spring while setting the tension. Adjust the bobbin tension after



adjusting the anti-spin spring and cleaning under the bobbin tension spring on the bobbin case. You will not need a full bobbin to check the tension when using the gauge. When inserting the bobbin into the bobbin case it should spin clockwise when viewed from the backside. Insert the bobbin into the gauge and adjust the tension between 15-30 grams with 22 grams being ideal. Read the tension of the gauge while pulling the bobbin thread slowly out away from the gauge. Do not pull to fast or to slow as these are not realistic speeds of the bobbin. It is important to pull the thread smooth and steady to get a good reading. If you see the needle on the gauge jumping up and down, there could be a problem with the sides of the bobbin itself. The cardboard could be bent over or the bobbin could have been wound incorrectly. If you see the needle on the gauge jumping up and down, the machine will also sense this while it sews, and you will have erratic tensions. Discard or fix that bobbin if possible. You will want the bobbin thread to come out the bobbin as smoothly as possible.

Checking without a bobbin tension gauge. First clean under the tension spring on the bobbin case, and then insert a new bobbin. Hold the end of the bobbin thread up and find the point at which the tension spring will hold the weight of the new bobbin and the case. Adjust the tension spring to let the bobbin and case start sliding down the thread by it's own weight (Like a spider on its web). This method is not meant to replace the use of a gauge, but to get you close to proper tensions if you do not have one. You may need to further tighten the adjustment screw if the bobbin thread is showing on the top-side of the fabric while sewing.

3. Main Tensioners

- **What are they for?**

Main upper thread tension control of machine.

- **When do you adjust them?**



At install, new spool of thread, then only after bobbin has been cleaned and adjusted. Run a tension test first, if you are still having trouble check the thread path and rethread the complete path of the troublesome needle or change out the needle or spool of thread.

- **How do you adjust them?**

At installation, new spool of thread, and for any tension problems after the bobbin has been adjusted as well as testing for proper tensions. A good starting point is when the top of the black screw located inside the white tension knob is

flush with the start of the screw threads inside the tension knob, then turn the knob clockwise (tighten) two more turns. For looping problems, turn knob clockwise (tighten) no more than one half turn at a time. If you have to turn the knob more than two to three turns, then there may be something else that needs to be checked. For bobbin thread showing on top, turn the knob counter clockwise (loosen) one half turn at a time. Again if you have to turn the knob more than two to three turns, then there may be something else that needs to be checked. TIP: (Use red dot as reference point)

4. Pre-tensioners

- **What are they for?**

To provide enough tension so that the thread turns the thread break sensor wheels.



- **When do you adjust them?**

At install, new spool of thread, after removing & cleaning them, and also as a last resort along with Thread Tree Tensioners for individual needle tail lengths during trims.



- **How do you adjust them?**

Plastic Knob Type

Adjust by turning the knob until the top of the silver screw inside the knob, is even with the step inside the knob where the screw threads start.

Metal Knob Type

Screw the knob down until the top of the knob is even with the slot in the stud.

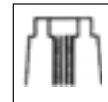
5. Thread Tree Tensioners (4 & 6 Head machines only)

- **What are they for?**

To take the looseness out of the thread between the thread stand to the tension base on the machine head.

- **When do you adjust them?**

At install, new spool of thread, after removing & cleaning them and as a last resort along with pre-tensioners for individual needle tail lengths.



- **How do you adjust them?**

Adjust by turning the knob until the top of the silver screw inside the knob, is even with the step inside the knob where the screw threads start. If you have long tails, adjusting for individual needle tail lengths by tightening the white knob one full turn, then test trim to view outcome. If the tails are too short then loosen knob one full turn and test trim to view outcome of adjustment.

TIP: (Use red dot as reference point)

6. Check Springs

- **What are they for?**

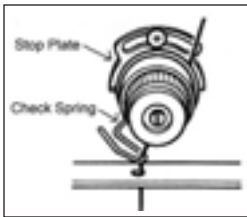
To help keep the slackness out of the thread as the take-up lever is moving into position to tighten the stitch.

- **When do you adjust them?**

Looping problems, metallic thread, or for thread that may slip off the main rotary tension disk.

- **How do you adjust them?**

With the thread off of the check spring, use a flat tip screwdriver to turn the black screw inside the main tension control knob counterclockwise (loosen) until the check spring comes off of the silver metal stop plate along the left side of the main control knob. Then turn the screw clockwise (tighten) until the spring just touches the stop plate, and continue turning approximately 1/8 to 1/4 turns, further clockwise (tighten). NOTE: Rotary



tension will turn as well and is OK. This would be the normal position of the check spring. If you have a looping problem that could not be solved by any other means, the silver stop plate could be adjusted by loosening the phillips screw above main tension control knob and rotating the silver stop plate clockwise until the space on the right side of the phillips screw looked to be larger than space on the left. This would mean that the check spring will have to travel further to get to the stop plate, make sure the check spring is readjusted to match as described above.

7. Thread Path

- **What is it for?**

The thread path lines the thread up for proper functions of all mechanisms in the thread path and is also another form of thread tension, and thread tension problems.

- **When do you check it?**

If the machine was sewing correctly and you just started having a problem on a needle.

- **How do you adjust it?**

Remove the thread completely out of thread path. Rethread completely, and as you are threading it, keep pulling on it as you go through the eyelets and other guides to see if tension has changed dramatically. If at any point you feel a difference in tension, look at that area just threaded closely. You may have to use some fine abrasive cord, through the eyelet or around the wheel to polish up the area having the problem. The take-up lever eyelet is one of the main areas of thread guide tension problems. The surface of the eyelet may

become tarnished from metallic thread or the environment, causing a dramatic increase in tension. Try the abrasive cord here or even some silicone spray in the eyelet. Make sure that the thread is wrapped two turns clockwise around thread break sensor wheel. It can be wrapped more if a technician feels it would help. It should also flow smoothly as it comes off the wheel. When the thread is going around the main rotary tension disk, the thread should be wrapped around the groove of the disk one and a half turns clockwise. If the metal disk does not rotate smoothly during the sew off, remove it, and clean the metal wheel, sometimes placing a little bit of baby powder on the three pieces of felt helps.

8. Other Notes

- All the above notes, suggestions, recommendations, solutions, etc. are all just guidelines to setting tensions and correcting tension problems. The first thing to always do is to look for the obvious. For example, if you are having “*FALSE THREAD BREAKS*”, look at the thread break sensor of your machine. Is it turning or moving properly? Usually you will find that if its not functioning, you must find out why it does not move. On rotary thread break sensors; if the tension is to light coming from the top of it, the loop of thread around the wheel cannot grasp the wheel tight enough to turn it. You may find the problem by examining the area just before the wheel. Usually found is lint or dust under the plate, that the thread is slides under. If too much lint has accumulated in that area, it will not apply enough tension on the thread. On the newer style pretensioners with the white knob, spring and two tension disks the thread is suppose to pass between the disks to the left. Sometimes these disks look parallel, but need to be straightened.
- The next thing to do is set bobbin tension. The bobbin is used with every needle. All bobbins are not wound exactly the same. As a precaution, you may want to check your bobbin tension when replacing the bobbin. When sewing hats, the lint from some hats fall into the bobbin causing the tension to change, even after a few hats, so check and clean the bobbin case often when sewing hats. Clean the bobbin tension spring, set the anti-spin spring and try again.
- Now that the bobbin is set to an exact tension you can adjust the top tensions. This is easy to do once the bobbin has been set. Sew out the bobbin tension test most of you should have. Which is nine or twelve different color letters, depending on the amount of needles your machine has. This could be a letter “H” sewn out at 1” and add plenty of pull comp to make them wide. Or



Tech Talk



the “I” test also with plenty of pull comp to be wide. After sewing this, look at the bottom of sew out to determine proper tensions. Ideally, you should see the white streak of bobbin as wide as the two outer streaks of thread 1/3, 1/3, 1/3. Anything close is acceptable. If all the needles are the same width, but the bobbin streak is thinner, you can adjust the bobbin by loosening it, then all the streaks will become wider on the next sew off. But by doing this, you have changed your bobbin tension to a lighter setting. You could change each individual top main tensioner instead by tightening each of them one turn clockwise, which will cause the bobbin streak to

become wider on the next sew off. Take a good look before adjusting too much and if the bottom of your sewing is not picture perfect adjust to the best of your ability.

• To review...

- Step 1. Look for the obvious
- Step 2. Adjust the bobbin case
- Step 3. Adjust the main tension
- Step 4. Check the thread path
- Step 5. Check the pretension

For Technical Assistance - Please Call Toll Free 1-877-427-6843

Embroidery Group

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FOR SOFTWARE SUPPORT

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 ssupport@brother.com

2003 Trade Show and Convention Schedule



DATE	SHOW/LOCATION
January 17-19	ISS Long Beach, CA
January 13	Monograms Today/Atlanta
January 29-31	Brother University, Fort Worth, TX
February 21-23	ISS Tampa, FL
February 21-23	Sew & Quilt Expo, San Mateo, CA
March 6-8	Original Sew & Craft, Clearwater, FL
March 13-15	Original Sew & Craft, Duluth, GA
March 14-16	ISS Atlantic City, NJ
March 21-22	Network 2003 Cleveland
March 20-22	Original Sew & Craft, Cleveland, OH
March 28-30	Sewing & Quilt Expo, Pleasanton, CA
March 26-29	Brother University, Bartlett, TN
April 24-26	The Printwear Show, Indianapolis
April 24-26	ISS Chicago, IL
May 1-3	Innovations in Emb, Boston, MA
June 25-27	Brother University, Cincinnati, OH
July 12	Monograms America, Atlanta, GA
August 1-3	Sew & Quilt Expo, Hawaii
August 15-16	Embroidery Mart, Nashville, TN
Sept. 5-7	ISS Fort Worth, TX
Sept. 18-20	Printwear, Long Beach, CA
Sept. 17-19	Brother University, Somerset NJ
Sept. 26-28	Sew & Quilt, San Mateo, CA
October 2-4	Original Sew & Craft, Chantilly, VA
October 9-10	Original Sew & Craft, Overland Park, KS
October 16-18	Original Sew & Craft, Rosemont, IL
October 15-18	SGIA, St. Louis, MO
Nov. 13-15	Original Sew & Craft, Minneapolis, MN

Notes from the Editor

It gives me pleasure to know that many of you have taken the time to read my newsletter during the year. Several of you have responded favorably via email. Please keep the emails coming. I enjoy reading them. It is my intention to continue to publish Stitchy Business throughout 2003, and if there is something you want us to write about in our future newsletter, please submit it to me.

Please keep in mind that our toll free tech support line is available to answer your questions and help you with any problem you may be faced with both machine and software. Many of your questions will easily be answered over the phone by one of our trained and experienced technicians

We are looking forward to seeing you at Brother University next year. Our classes have been designed to give you the information and experience you need to succeed. I hope you will have the opportunity to sign up and join next year.

I want to wish all of you a happy, healthy holiday season and prosperous New Year.

May all your wishes and dreams come true.

Lisa.Lattarulo@brother.com

Technical Seminar Schedule 2003

LOCATION	DATE	MACHINE
Peabody, MA	January 11	1 Head
Bartlett, TN	January 25	1, 4, 6 Head
Irvine, CA	February 8	1, 4, 6 Head
Denver, CO	March 22	1, 4, 6 Head
Fort Worth, TX	April 12	1 Head
Atlanta, GA	May 10	1 Head
Somerset, NJ	May 17	1 Head
St. Louis, MO	June 21	1, 4, 6 Head
Scottsdale, AZ	July 19	1, 4, 6 Head
Irvine, CA	August 23	1, 4, 6 Head
Miamisburg, OH	September 13	1 Head
Portland, OR	October 25	1, 4, 6 Head
Los Angeles, CA	November 8	1, 4, 6 Head (In Spanish)

For more information, details on topics or to register, call 1-877-427-6843.

www.brotheraskus.com/seminar/regform.asp

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Parts, Accessories & Supplies

SALE!

The PAS Store is proud to offer, once again, our annual special sale of the basic HoopMaster Tubular Hoop Kit. Each Kit contains: the HoopMaster Station; 1 FreeStyle Arm and Arm Mounting Base; 1 Pocket Alignment Guide and T-Square; your choice of one machine-and size-specific Fixture; and a how-to-use video.

Normally selling for \$545, this Kit is now on sale for \$490.50 (Sale ends 1/31/03)!

That's a 10% savings we know you'll want to take advantage of. We ship the same day, so now's the time to place your Order for Christmas delivery. Please mention this Stitchy Business Newsletter when placing your order at 1-877-850-7179. Happy Holidays from your friends at the PAS Store.

