Nancy Mini is Madeira USA’s senior marketing coordinator and backing specialist for the E-Zee Backing & Topping® division at Madeira USA’s headquarters in New Hampshire. Self taught to run multi-head commercial embroidery machine. She problem solves, creates stitch outs for illustrating articles in trade press, and provides stitched color samples. A product expert, she often leads internal product trainings with an emphasis on backing stabilizers and toppings.

Erich Campbell works out of Black Duck Embroidery in Albuquerque, New Mexico. An award-winning commercial embroiderer/digitizer with 16 years of experience, Erich maintains an industry blog, while actively contributing to social media marketing. The newest member of Madeira USA’s NAMES, Erich’s seminar subjects and trade magazine articles gravitate to problem solving, simplifying techniques into workable how-to’s and all reflect his wide range of accomplishment with illustrative stitch outs.
Meeting the Challenge Head On: Embroidering on Caps

Welcome to our webinar!
Meeting the Challenge Head On: Embroidering on Caps

You will learn -

- Cap styles
- Digitizing tips
- Using the correct backing
- Locations for designs
- And more!
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Anatomy of a Cap
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Styles of Caps

- High Profile
- Low profile
- 5 vs. 6 Panel
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Styles of Caps

- FlexFit caps
- Military hats
- Bucket hats
- Structured / Unstructured caps
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Design Considerations

- Mesh backs
- Center seam
- Cap frame limitations
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Locations for Designs

- Front
- Side
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Locations for Designs

- Back strap
- Above keyhole
- Across FlexFit back
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Locations for Designs: All Over!
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When Good Caps Go Bad!

Logo crooked, overlaps horizontal seam

Logo out of registration on right side

Underlay stitches show at top of design
Digitizing for Caps

- Stitch from the center, out
- Stitch from the brim, up
- Avoid “flagging”
- Maintain registration
- Adding color changes
- Avoid excess movement
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Digitizing for Caps

Keep script fonts properly sequenced

Wrong!

Correct!
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3D Embroidery on Caps

- Satin stitches work best
- Create “end caps” where stitches may not cover the foam
- Use a heavy stitch density of 2.0 - 2.5
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3D Embroidery on Caps

- Choose foam color that is similar to thread color
- Stitch underlay and/or outline stitches before placing 3D foam
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3D Embroidery on Caps

Use a hairdryer to shrink away foam that may be visible
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**Hoopng Caps**

- For single location
- For multiple locations
- New flat type placements
- Backing placement (full ring for 270° hoops)

Wrong!  
Correct!
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Choosing Cap Backing

- Size needed
- Thickness and weight
- Adhesive backing
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Thread and Needle Info

- Always use a sharp point needle
- Slow machine down to 650 – 700 SPM
- Hold your Start Button for a “Slow Start”

<table>
<thead>
<tr>
<th>Thread</th>
<th>Recommended Needle Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>Polyneon #40</td>
<td>75/11 - 80/12</td>
</tr>
<tr>
<td>Polyneon #60</td>
<td>65/9 - 75/11</td>
</tr>
<tr>
<td>Frosted Matt #40</td>
<td>65/9 - 75/11</td>
</tr>
<tr>
<td>FS Metallic #40</td>
<td>75/11 - 80/12</td>
</tr>
</tbody>
</table>
Include a Cap Backing in your next order and save 10%!
E-Zee Cap Just Right 2.5 oz. (6 options)
E-Zee Cap 3.0 oz. (4 options)
Use Promo Code CB-10

No other discounts apply. Savings cannot be applied to previous orders. Discount taken off of single unit pricing. This promo code cannot be used to reduce pricing of thread collections, thread kits or drop ship items. Enter promo code in Promo Code Box when placing orders online. Have ready when placing orders by phone.
ACT SOON! Offer valid through August 24, 2016.

To keep learning more, visit Erich’s weekly posts!