

Pulse Autograph User's Guide

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CHAPTER 1:

Getting Started

This section will give some basic instructions about setting up and running the Pulse Autograph software.

This selection covers:

- Minimum systems requirement for running Autograph on your computer.
- Installing the software.
- Information about the Autograph security device.

System Requirements

Recommended System Requirements:

- Genuine Intel Pentium IV, 2GHz PC, dual-core computer (or better).
- CD-ROM drive
- Microsoft® Windows® XP, Microsoft® Windows®7, or Microsoft® Windows® 8 operating system
- 2 GB of RAM
- At least 1GB hard disk drive space available

Installation

Before you can install Autograph, you must connect all embroidery machines. Once done installing the hardware, you can attach your security device and then install the software.

Installing the Application

By default, the program files are installed in Program Files\Pulse\Autograph, but you can install in a different location by selecting one during the installation process.

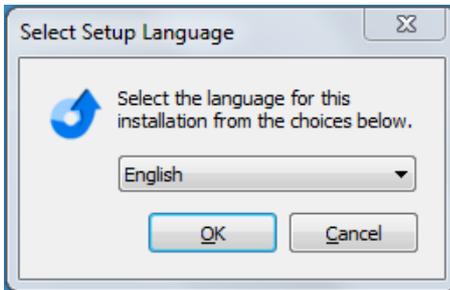
Additional program files including the designs and artwork are installed into the folder Documents and Settings\All Users\Application Data\Pulse\Autograph.



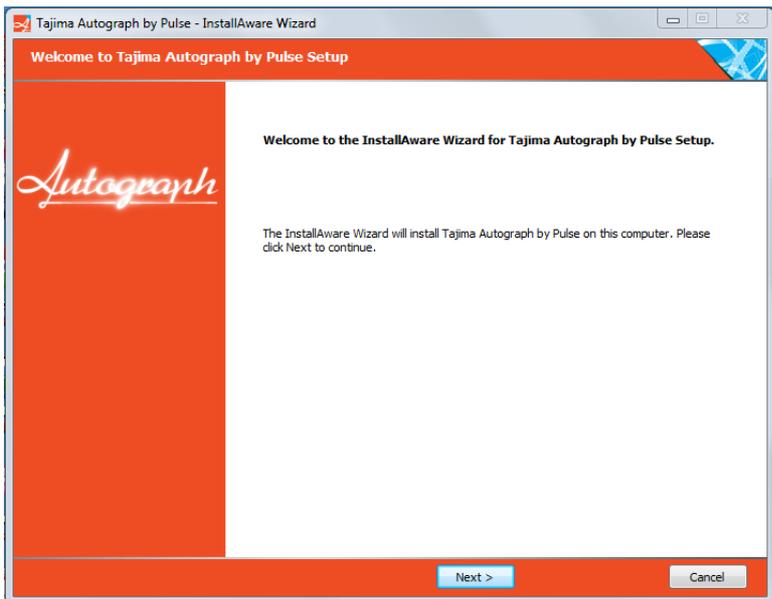
You must be running Windows® XP/Vista/7/8 to install Autograph.

To install Autograph:

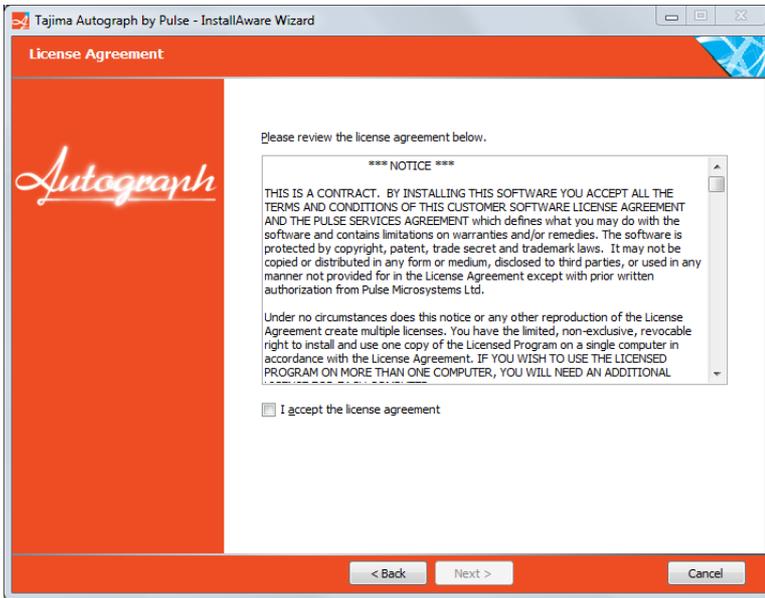
- 1) Insert the Autograph CD into the CD-ROM drive.
You see the Autorun screen.
- 2) Click Install Autograph.
You see the Choose Setup Language dialog.



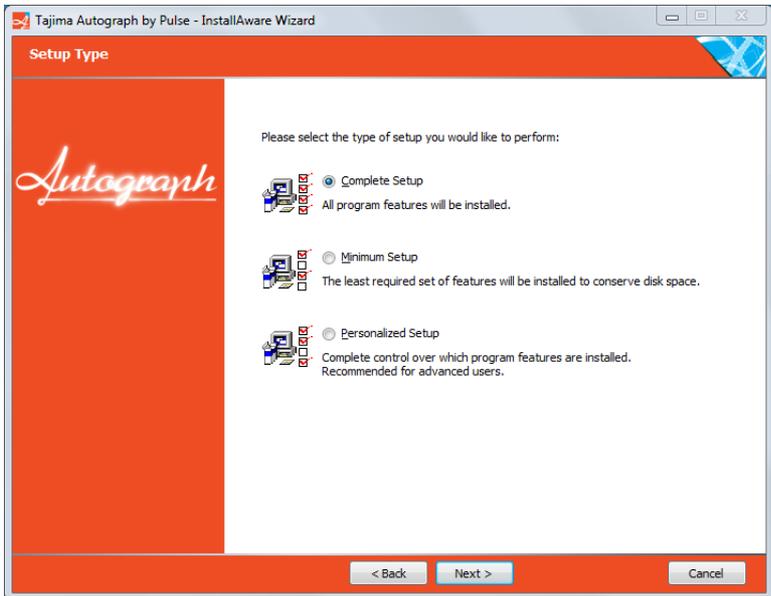
- 3) Choose the language you want to install and click the Install button.
You see an InstallShield Wizard screen.



- 4) Click Next to start the installation.
You see the License Agreement page.



- 5) To accept the terms of the agreement, check the box below the License Agreement text box.
You see the Customer Information page.
- 6) Type your name and company name in the boxes and click Next.
You see the Setup Type page.



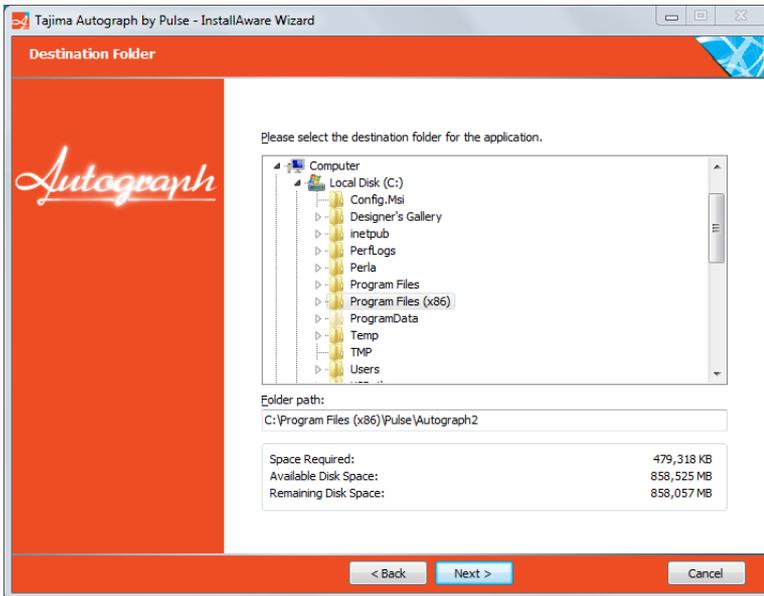
- 7) Select the setup type you want by selecting the appropriate radio button.



Choosing Personalized setup will open the Select Features page. On this page, you can expand the list to view all available features. Check the boxes next to only those you want to install. You can create a fully customized version of the software.

- 8) Click Next.

You see the Destination Folder window.



9) Choose where you want Autograph installed and click Next.

You see the Start Menu window.

10) Choose the name you want to assign to the program in the start menu; click Next.

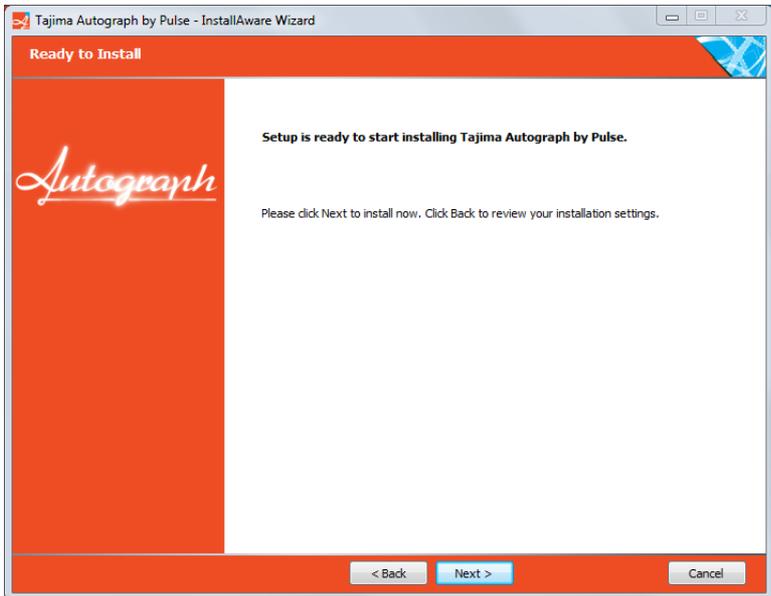


If the computer you are installing on is one that will have multiple users, you can also choose whether the to have the Autograph shortcut icon appear on all users' desktops, or just yours.

You see the Ready to Install window.

11) To start copying files, click Next.

A new Install window opens which shows the progress of the installation. When it is finished, you see the "Setup Complete" window.



12) Click Finish to complete the installation.



By default, the software will now be launched. To close the Wizard without starting the program, uncheck the “Run Pulse Autograph Now” box.

Activating Autograph

The software needs to be activated in order to be used. To do this, you will need an Activation serial number.



A working internet connection is required for automatic activation. If no internet connection is available, the software can be activated manually, by contacting your distributor.

See “Activating Autograph without an Internet connection.”

The following procedures outline the activation processes.

Activating Autograph automatically via the Internet

To activate Autograph automatically with an Internet connection:

- 1) From the Start menu, select All Programs—Pulse—Autograph2—Tajima Autograph by Pulse.
You see the Activation screen.

Activation

Name*:

Address*:

City*:

State:

Postal Code*:

Country*:

Email*:

Phone*:

Fax:

Company:

* Field is required to continue

Product:

Activation Serial Number:

Update Options Activate Now! Close

- 2) Fill in the required activation information in the appropriate fields.



Fields marked with an asterisk (*) are required - your software will not be activated otherwise.

- 3) Type your individual activation serial number into the Activation Serial Number field.
- 4) Click the Activate Now button on the dialog.
The Autograph software will open.

Activating Autograph without an Internet connection

If you have installed the software on a computer that does not have an Internet connection, you will need an activation code (in addition to the serial number) to complete the activation. You will be able obtain this code by contacting your distributor.

To activate Autograph without an Internet connection:

- 1) From the Start menu, select All Programs—Pulse—Autograph2—Tajima Autograph by Pulse.
You see the Activation screen.

- 2) Fill in the required activation information in the appropriate fields.



Fields marked with an asterisk (*) are required - your software will not be activated otherwise.

- 3) Type your individual activation serial number into the Activation Serial Number field.
- 4) Click the Activate Now button on the dialog.
You see a warning message; the message will tell you that the activator is not able to connect to the activation server.
- 5) Click OK to dismiss the warning message.
The Activation dialog now has a new field for the activation code. You will also see a Site ID number in the Activation wizard dialog.
- 6) Contact your distributor. Give them your serial number, as well as the Site ID number that is now displayed in the activation dialog.
You will receive an activation code from your distributor.
- 7) Enter the activation code, and click the Activate Now button.
The Autograph software will open.

Deactivating Autograph

Once Autograph has been activated, it is possible to deactivate the software by re-opening the activation dialog. Deactivation effectively 'frees up' the Activation Serial Number so that it can be used again; for example, if you want to transfer Autograph to a different computer and reactivate it on there.



You must be connected to the internet to deactivate the software.

To deactivate Autograph:

- 1) Open Pulse Autograph.
- 2) On the Autograph title bar, click the About  button.
- 3) You see the About dialog.
- 4) On the About dialog, click the **Activator** button.
The Activator dialog will open, displaying the user's personal information and the Activation Serial Number.
- 5) On the Activator dialog, click **Deactivate**.
You see a warning dialog.
- 6) Click Yes to confirm that you want to deactivate.
- 7) A message appears confirming that the software has been deactivated.
- 8) Click OK to dismiss the message, and then click Close in the Activation dialog.
The copy of Autograph on this computer will now be deactivated, and is no longer available for use. You can now re-use the Activation Serial number on a different computer.

CHAPTER 2:

Learning about the Workspace

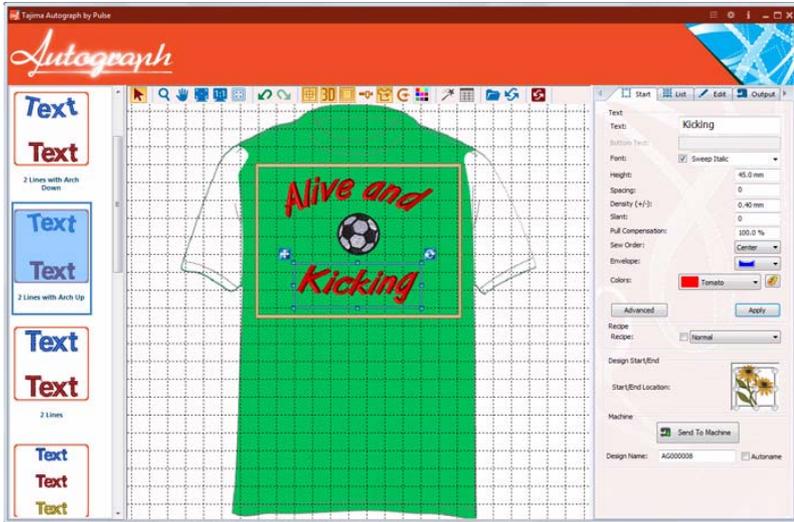
Before you start using the software, we recommend that you learn the basic arrangement of design workspace.

This selection covers:

- The different parts of the workspace environment.
- An introduction to the functions each of the tabs, and what tools each one features.
- Changing the Configuration settings.

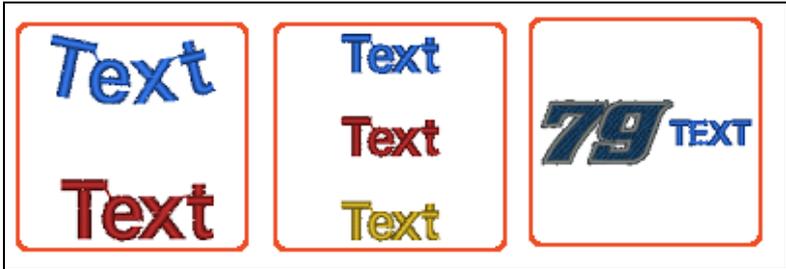
Parts of the Workspace

The Autograph workspace contains a number of different areas which have distinct functions. The sections that follow give an overview of what each of these areas does, and the kinds of information about the design that they contain.



Template Sidebar

The Templates bar is displayed to the left of the workspace. Use the templates in the Templates sidebar to set up new designs. Choose the desired of template by clicking on a preview image of the template. The templates contain a generic text string or strings, plus (depending on the specific template) a placeholder which you can click on to place graphic designs. There are a variety of different arrangements of templates; use the scrollbar on the right of the Template sidebar to view a complete list of the templates available.



Some examples of templates

For more information on modifying the text or other elements of a template, please refer to the “Design Editing” section of this manual.

Toolbar

The Autograph toolbar is located at the top of the design window. It contains a number of useful tools that apply to the Autograph workspace as a whole, such as Select, Pan, and Zoom.

Toolbar Buttons

The following table gives the name each button on the toolbar, plus a very brief description of what it does.

Tool	What it does
	Select: Selects objects in the design window.
	Zoom: Used to increase and decrease the scale of the design in the workspace.
	Pan: Allows you to move the design around in the workspace.
	Fit to Screen: Scales the current design, up or down, so that it completely fills the design window.
	Actual Size: Zooms the design preview to show the design in its real linear dimensions.

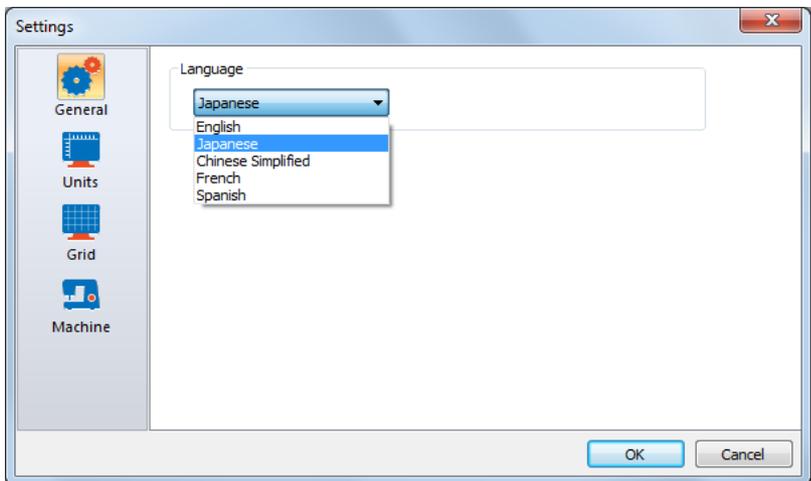
Tool	What it does
	Fit to Hoop: Resizes your design to the maximum size that fits in the current hoop.
	Undo: Undoes to last action that was performed.
	Redo: Reverses the action of the Undo tool.
	Show Grid: Shows and hides the gridlines in the workspace.
	3D: Displays a three-dimensional preview of the stitches.
	Display hoop: Shows an image of the selected hoop in your design workspace.
	Slow draw: Click this button to display the slow draw bar at the bottom of the workspace. This bar shows all thread colors in the design, in order. Dragging the slider simulates the sew-out of the design.
	Show Garment: Shows and hides the garment preview in the workspace.
	Show commands: Toggles the display of design commands on and off.
	Background Color: Opens a list of color swatches, from which you can select to change the color of the Workspace.
	Autodigitizer: Creates embroidery from an image in a few simple steps.
	Import CSV: Click to import a “Common separated values” (.csv) file in order to create multiple output files based on a single Autograph template. (See Creating and Editing New Designs—Import CSV for more details.).
	Open from File: Displays an “Open” dialog box, which allows to open a new design.
	Reset Template: If you load a Template into the workspace and make modifications to it, clicking this button will restore it back to its original configuration.
	Master Reset: Clears all information from the workspace.

The Settings Pages

The settings pages are used to set the overall properties of the Autograph workspace. These include the system of units that are used in the various measurements (e.g. length and stitch density), and the language of the user interface.

To change the language of the user interface:

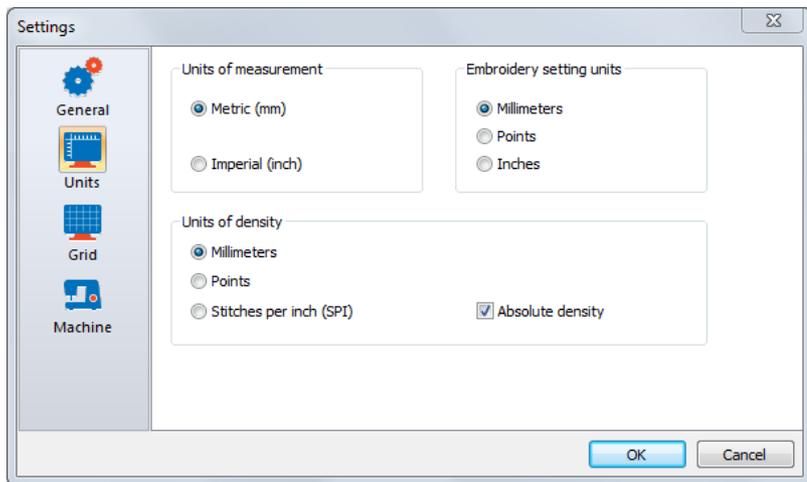
- 1 Click the Settings icon , located on the Autograph title bar.
- 2 In the Settings dialog, click the General  button.
You see the Languages page.
- 3 Click the down-arrow next to the languages field to see the list of available languages.



- 4 Select the desired language from the list, and click OK.
Autograph will display a warning message, advising you that you need to restart the program to apply the language change.
- 5 Restart Autograph.
The user interface will display the new language.

To change the Units settings:

- 1 Click the settings symbol , located on the Autograph title bar.
- 2 On the Settings dialog, select the Units  button.
You see the Units page.



- 3 Adjust any of the following units settings.
 - ◆ In the Units of measurement area, select Metric or Imperial as your unit of measurement.
 - ◆ In the Embroidery Settings Units area, select Millimeters, Points or Inches to set the units used for stitch length and pull-compensation values.
 - ◆ In the Units of Density area, select Millimeters, Points or SPI (Stitches per Inch) as your unit of density value.



Absolute density: You can choose to have the density (which is displayed in the Text area of the Start tab) to be displayed either an absolute value or a relative value (i.e. + or - the base density or the design). To show the absolute value, check the Absolute density box; to show the relative density, uncheck the box.

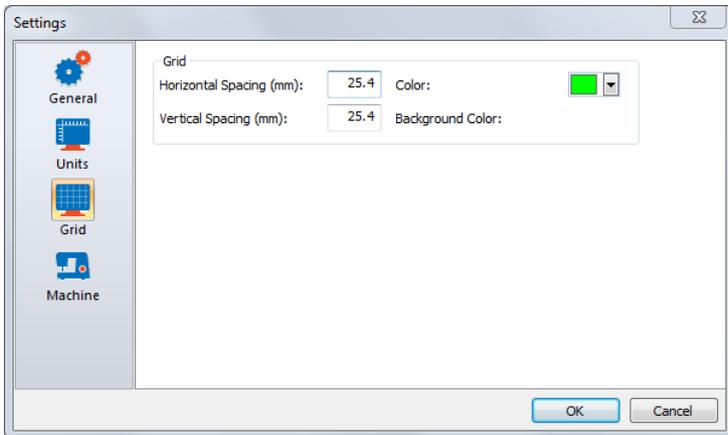
- 4 Click OK to close the dialog and apply the changes.

Grid Settings

You can use the Setting dialog to adjust the spacing of the lines in the workspace grid. To the to change the grid interval, open the Settings dialog, click the Grid  button, and enter new values in the Horizontal and Vertical spacing fields.



By default, the grid spacing will be set to 25.4 mm (1 inch).



You can also select a new color for the grid lines. Next to the Color field click the down-arrow, and then select from the color palette that appears.

Machine Settings

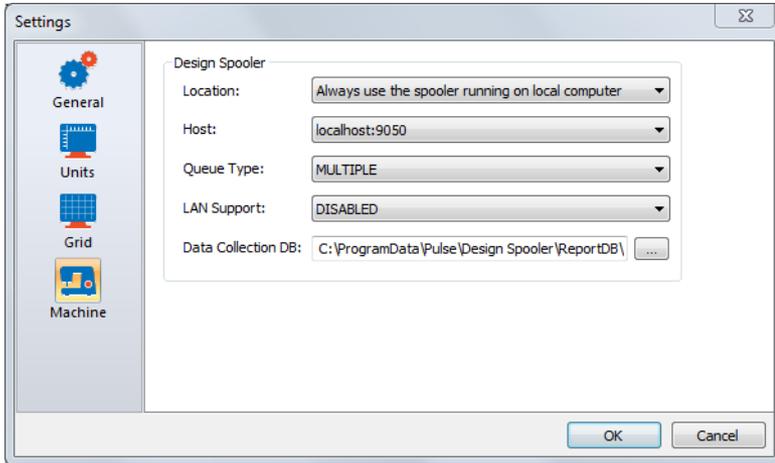
On the Machine page of the Settings dialog, you will find settings relating to the active design Spooler. Among these are those that allow you to set the path to the Spooler, the queue type, and the location for Data Collection database reports.

To configure the Machine Settings:

- 1 On the Autograph title bar, click the Settings  button.
You see the Settings dialog.

2 Select the Machine button.

You see the Design Spooler settings page.



- 3 From the **Location** list, select one of the following options:
 - ◆ **Locate all spoolers on the Network.** This setting allows you to connect to embroidery machines available on your network.
 - ◆ **Always use the spooler running on local computer.** This setting allows you to only use the embroidery machines connected directly to your computer.
- 4 In the **Host** list, select the path to the desired host spooler. The configuration settings for the selected spooler will be displayed and you can make changes accordingly.
- 5 From the Queue Type list, select one of the following:
 - ◆ **Multiple** (Default). Create a separate design queue for each embroidery machine.
 - ◆ **Single.** Create one queue for all the embroidery machines connected to this design spooler. This option is only available to machines that support downloading or pulling a design file from the machine's control panel (i.e. LAN or multi-directional serial machines).
- 6 In the LAN Machine Support field, select one of the following ways to control how to communicate with LAN enabled embroidery machines:

- Disabled.
- Enabled.



Only one design spooler can have this setting enabled at one time.

- In the Data Collection DB, click the browse button  to the location where reporting data is created (only active when the spooler being used is the local spooler).

7 To save your changes, click OK.

Workspace Viewing tools

The viewing tools are located on the Toolbar, which is located along the top of the workspace window. Use these tools to change your view of the design in the Workspace view.

Zoom Tool

Use Zoom to magnify or reduce parts of your design. With Zoom you can either left-click to enlarge your design or right-click to make your design smaller.

When you select Zoom, the cursor changes to a small magnifying glass . To use the Zoom tool, do one of the following:

- To zoom in on the spot where the mouse is currently pointing, left-click.
- To zoom out again, right-click.

Pan Tool

Sometimes you may want to work at a high level of magnification, so garment you are working on will not all fit in the workspace. In these situations, use the Pan  tool to change your view of the project.

- To use panning, select the pan tool, and click and drag the mouse in the workspace.

Fit to Screen

The  tool allows you to scale an entire design and fill the maximum size of a selected hoop on the design window. This feature recalculates stitches where necessary.

View Actual Size

Click the Back to 1:1  tool to have the design appear with its true measurements: that is, 1 centimeter equals 1 centimeter on-screen. Back to 1:1 is useful when you have used Zoom and want to go back and view the design based on its measurements.

To use the Back to 1:1 tool:

- In the View toolbar, click the Back to 1:1  tool to go back to the original design size.

Grid tool

Click the Show Grid  tool to display grid lines in the workspace. To hide the grid lines again, simply press Show Grid again.

Changing Grid settings:

The spacing of the lines in the workspace grid can be modified on the Grid tab of the Settings dialog; to open the Settings dialog, click the Settings button  on the Autograph title bar. You can enter a new measurement into the spacing boxes (given in inches) to change the grid interval.



If the grid is on at the time you make the change, it will not reflect the change immediately; toggle the Grid button off and on to refresh the view.

You can also select a new color for the grid lines; click the “down-arrow” next to the color field, and then select from the color palette that appears.

View in 3D

The View in 3D tool is used to display a realistic three-dimensional view of the design's stitches.

To show the 3D preview, click the View in 3D  tool; to hide the 3D stitches again, press the 3D tool again.

Slow Redraw Bar

The Slow Redraw  bar gives you a preview of how the current design will sew out. It controls which parts of the design will be shown in the design window.

The length of the color 'slider' represents all of the stitches in the design. You can move the slider by dragging to see a design as it will look sewn to a particular point; as you drag it from left to right, more of the design will show in the design workspace. The color display within the scrollbar indicates the thread color – the length of each color is proportional to the number of stitches in that color.

Show and Hide Garment

You choose to display a preview of a sample garment in the workspace by clicking the Show Garment  button; the garment preview image is selected from the list of images in the Garment tab.

See "Learning about the Workspace-Garments" for more details on selecting the preview garment.

Show Commands

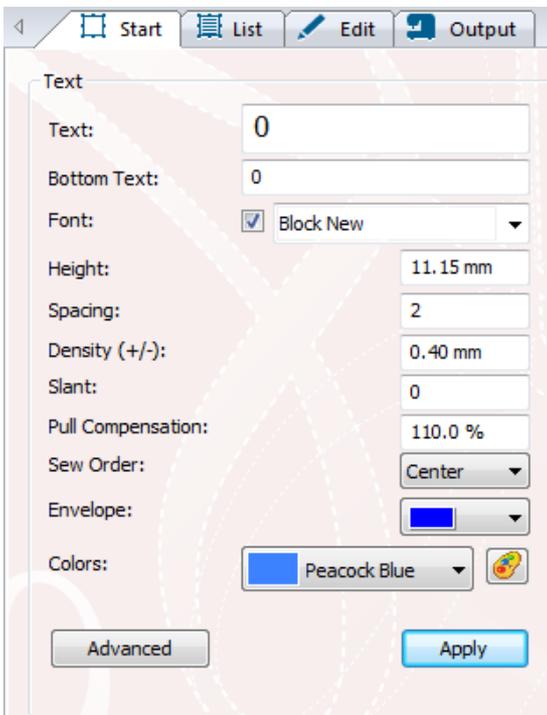
The Show Commands tool displays symbols on the design which show where a command (trim, stop or color change) occurs. Turning on the Show Commands also will display the Start/End location of the design, which is shown by this symbol: .

The Autograph Tabs

The tabs are found on the right side of the Autograph workspace; they include the Start, List, Edit, and Output tabs. In the tabs, you will find all the tools and fields for setting up, editing, and transforming and outputting templates. The sections that follow present a general view of the functions of each tab; for more details, see the following chapters: "Learning about the Workspace-Creating and Editing New Designs" and "Learning about the Workspace-Output Tools and Settings".

Start Tab

The Start Tab displays the properties of the object in the design has currently selected. It will display different properties depending on whether the current selection is a design or a text segment.



If the object is a Design you can use the “Change... button to swap out this graphic, and put another in the same place. You can also use the Colors field to change the thread colors of individual thread segments in the design.

For details on the thread color change procedure, see “Creating and Editing New Designs—Changing Thread Colors.”

If the selection is a text object the Start tab shows a number of different properties pertaining to the text itself - such as its font, color, letter height, slant, etc. You can use the fields to make changes to text; the changes will appear when you click the Apply button.

There are also a number of text effects that are made available when you click the Advanced button – sew order, drop shadow, borders, drop shadow, and others.

For more information about these settings, see “Creating and Editing New Designs—Properties of Text Segments.”

The Start tab has four sections, each with a distinct function; Text/Design, Recipe, Design Start End, and Machine.

Text/Design

This section's title changes depending on whether a Text or Design element is selected.

- For Text objects (words, or strings of words), this area shows controls that allow you to input text into a new design, and make modifications to the selected text (such as height, font, letter spacing, etc.). For information on all of these settings, see “Properties of Text Segments.”
- For Designs (i.e., all designs that are not comprised of text), the Design area allows you to select a new design, and change the colors of threads used in the design object.

Recipe

Recipes contain fabric settings that are applied to the current design. These settings will vary, depending on the type of fabric, or type of garment the design will be sewn on. For example, the “Cap” recipe contains special underlay, pull-compensation, and density settings appropriate for designs that will be sewn on baseball caps.

When you select a recipe, the settings it contains will be applied to the design when it is saved and/or output to the embroidery machine. To choose the recipe, click the down-arrow next to the Recipe field, and then click the Recipe name to highlight it.

Design Start/End

In Pulse Autograph, you can set the start/end sewing locations. This setting tells the embroidery machine where in the design the machine will start and finish sewing.

To select the start and end locations Choose the desired start/end position by selecting the corresponding radio button on the tab in the “flower icon” image.



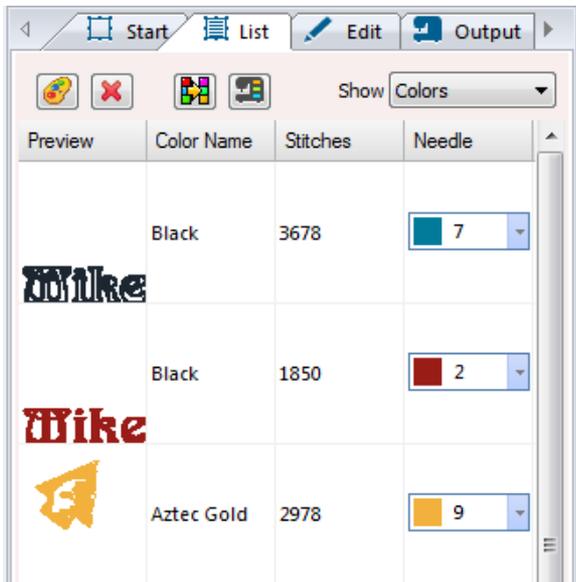
Machine

In the Machine area of the Start tab, you will find the Send to Machine button. Click this button to send the current design to the design queue.

Below the Send to Machine button, there is also a field in which you can enter the design’s name – there is an option also to check **Autoname**. If Autoname is checked, the sent designs will be automatically be numbered sequentially as they are sent to the machine (i.e., 1, 2, 3...etc.).

List Tab

The List tab displays the each individual embroidery segment in the current design, separated by color. The segments are shown in the order of sewing, with the first segment on the top of the list, and the last segment at the bottom of the list.



Each segment is shown in a thumbnail image; to the left of each, the other columns of the List tab show the segment's color (i.e. thread name), the number of stitches it contains, and the needle number.

The list tab includes the following tools and settings:

	Thread change: Allows you to change the color of the selected group or segment.
	Delete: Removes the selected segment or color group from the design.
	Match Machine Palette: Converts the design colors to the closest matching color in the machine palette.
	Setup Machine Needles: Opens up Machine palette. There is a default palette that come pre-loaded with the software. However, you can substitute in any thread from the Thread Gallery.
	Show Objects/Colors: Switches the List view to change how the design is displayed – either as individual object (segments) or grouped by color. This allows you to make color changes to a single segment at one time, or change a whole color group at once.

To change the color of an individual segment of color group, click the down-arrow next to the needle number. This will show the list of available thread colors/needles to choose from. Select a color from this list, and the segment will change to this color.



Note that the list of available thread colors includes those already assigned to segments in the design, plus the colors of the current Machine Palette; the machine palette colors will be displayed with the needle number next to them, while those colors that are not in the palette will have an asterisk (*) next to them. For more information, see “Creating and Editing Designs—Setting up the Machine Needle Palette.”

To select an entirely new color to apply to the segment, see “Creating and Editing New Designs—Changing Thread Colors”

Edit Tab

The Edit tab is where you will find the tools that you can use to modify the design, or individual objects in the design. Tools in the Edit tab are grouped into categories, based on the kind of functionality they have. These are: the Align tools, Edit tools, Object tools, and the Transform tool. For more information, see “Functions of the Edit Tab.”

Tools on the Edit Tab

Tool	What it does
	Center: All selected objects will be centered in the workspace window.
	Horizontal Center: All selected objects are moved so that they are centered left-to-right with respect to each other, but are not moved up or down.
	Vertical Center: All selected objects are moved so that they are centered top-to-bottom with respect to each other, but are not moved left or right.
	Align Left: Aligns all selected objects to the left-most item selected.
	Align Right: Aligns all selected objects to the right-most item selected.
	Align Top: Aligns all selected objects to the top-most item selected.

Tool	What it does
	Align Bottom: Aligns all selected objects to the bottom-most item selected.
	Flip Horizontally: Flips one or more selected objects horizontally.
	Flip Vertically: Flips one or more selected objects vertically.
	Send to back: The selected object is moved behind all the other object in the design.
	Bring to front: The selected object is moved up to the front of the design.
	Add new text: Automatically places a new, default text segment into the current design. Change the content, font, and other properties of this text using the settings on the Start tab.
	Add new design: Opens the Design Gallery window. Through the Design Gallery, you can browse for embroidery files to add to the current design.

Selecting the Hoop

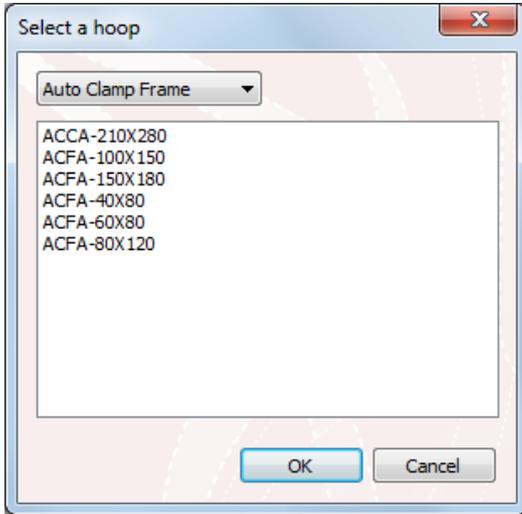
Viewing the hoop or frame on the screen helps you ensure that your design fits properly when you run it on the machine. The image of the hoop that is displayed in the workspace window serves as a guide for sizing and positioning your design.

Autograph comes with many pre-loaded hoop preview images, in a wide range of shapes and sizes.

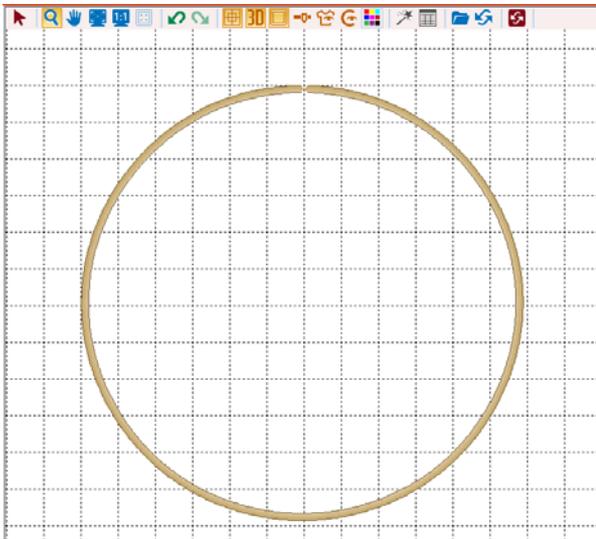
To choose the hoop:

- 1 Ensure that the hoop will be visible by clicking the Hoop  button on the toolbar.
- 2 Right-click the Hoop button, and click Select Hoop in the menu that appears
You see the Select a Hoop dialog.
- 3 Select one of the hoop categories from the drop-down list (e.g., Cap, Round, etc.).

You see a drop-down list of hoops; the list of hoops that are available will change according the category selected. Drag the scroll bar up and down to view the entire list.



- 4 Click on the desired hoop to select it, and click OK.
The selected hoop image appears in the workspace.

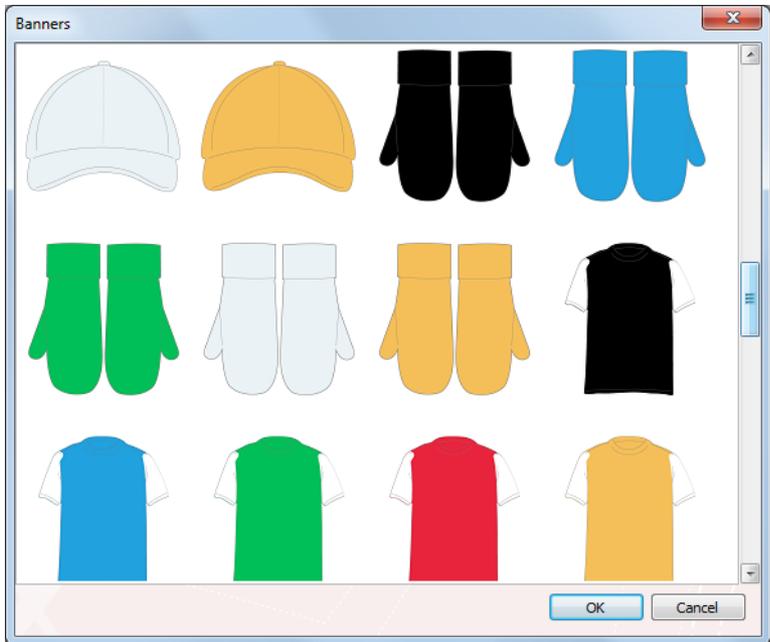


Garments

Use the Show Garment  tool to display garment preview images in the workspace. These garments come in various styles (e.g. cap, T-shirt, jersey, etc.) and colors, and can be used as backgrounds when previewing designs for the customer.

To choose a garment for the Garment preview:

- 1 Right-click on the Show Garment button.
The Select Garment dialog appears.



- 2 Click on the desired garment image in the preview.
A frame will appear around the selected garment.
- 3 Click OK.
The Select Garment dialog will close, and the selected garment will appear in the workspace.



You can click on the Show Garment button to toggle the garment preview on and off in the workspace.

Output Tab

The output tab is where you find the Design Queue and Machine Status tools, and also the Print Preview. These tools allow you to view which designs that are currently queued on the machine, and check the status of the machine that designs are being sent to.

There are also buttons on this tab that allow you to set the design spooler settings, to save designs to disk, and open an existing design in Autograph.

For more information about the tools on the Output tab related to the Design Queue and Machine Status/Data Collection, see the “Output Tools” section of this User’s Guide.

Opening a Design File

If you want to open an existing embroidery design into the Autograph workspace, and then edit it use the **Open from File** button on the Output Tab.

When you click Open from File, a new Windows browser dialog will open. You can then select any available directory (e.g., your hard drive, a network drive, or a portable storage device, such as a USB drive), to open the design from. You can open both unified files (*.PXF) and stitch files (e.g. *.DST, *.DSB, and *.EMB) in Autograph.

Saving a Design File

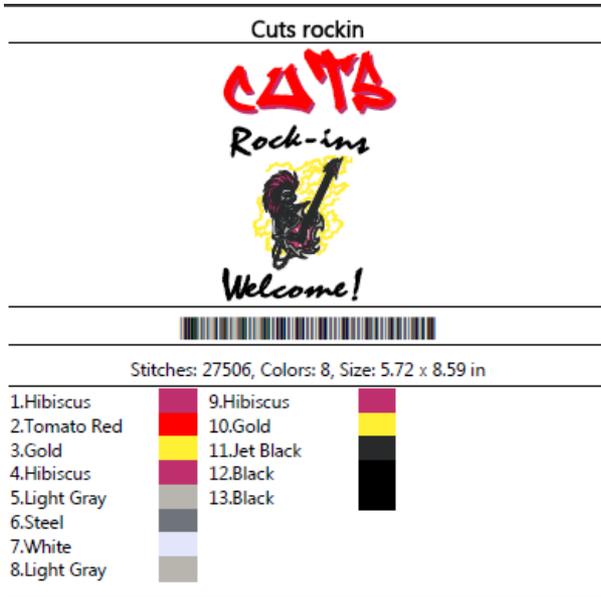
To save a design file to your hard drive, a portable device, etc. click on the “Save to File” button on the Output tab. Files can be saved as either Pulse Embroidery Files (*.PXF) format, Tajima Stitch Files (*.DST) format, Tajima/Barudan Stitch Files (*.DSB) format, Tajima TBF Files (*.TBF) or Tajima Combined Design Files (*.TCF).

Printing a Design Worksheet

Also on the Output tab, you can create a print version of the current design as a worksheet. The Print area displays a preview of the design, along with its number of stitches, number of colors, and the design’s dimensions.

The Print area on the Output tab also displays the names of each thread color, and a color 'swatch' for each, in a grid at the lower half of the worksheet.

The design preview also includes a bar coded version of the design's file name. This can be used to read the design name directly into the machine, for those machines that support bar code scanners.



Example of a printed worksheet, showing the design preview, the bar code, the stitch/color/dimensions information, and the color grid.

To create a hard copy of the worksheet, click the **Print** button at the bottom of the tab. This will open the print dialog for the default printer on your computer; review the print settings, and then click Print to send the design to the printer.

Your Order

The Your Order window is placed at the bottom of the Output tab. This area displays the current information about the design in progress. Using this window, you can see important design parameters (such as the number of stitches), updated in real time as the design is edited.

<i>Your Order</i>			
Stitches:	20088		
Characters:	12	Designs:	1
Text Lines:	2	Dimensions:	84.9 x 130.6 mm
Run Time: 01:06:57			

The information shown in this window includes:

- Number of stitches.
- Number of characters (letters, numbers, etc.).
- Number of lines of text.
- Number of designs used.
- Overall he dimensions of the design.
- Estimated time to sew-out (Run Time).

CHAPTER 3:

Creating and Editing New Designs

This selection covers:

- Using templates to create a design.
- Editing embroidery design in the workspace.
- Arranging and editing objects using the Edit tab.
- Creating multiple designs based on a single Template
- Automatically digitizing a bitmap image using the Autodigitizer

Creating new Designs

The Templates present a very quick and easy way to create new embroidery designs. You can select from a number of sample templates, and edit the text and images in them.

Using Templates to create Designs

Whether the template you use is one of the generic arrangements, or one of the sample templates, the procedure is largely the same.

To create a design based on a template:

- 1) In the Template sidebar, select one of the templates by double clicking on its thumbnail.

The selected template appears in your workspace. Placeholder text appears where the word "TEXT" is shown in the template, and a placeholder graphic appears where the graphic is shown.



- 2) Select the placeholder text and/or graphic segments and customize them to suit your needs.

For example, you can change the text, font, color etc.; for further

details, see “Adjusting Text Properties.”

For details on changing the default graphic in the design, see “Changing a Design in the Template”.

- 3) If applicable, select the generic placeholder image in the template and replace it with one of the designs in the gallery, or a design from another source.

For more information, see “Changing a Design.”



If you want to undo all your changes, you can return the template to its original state by clicking the Reset  button on the toolbar.

- 4) When edits are all completed, you can save the file, or send it to the sewing machine directly.

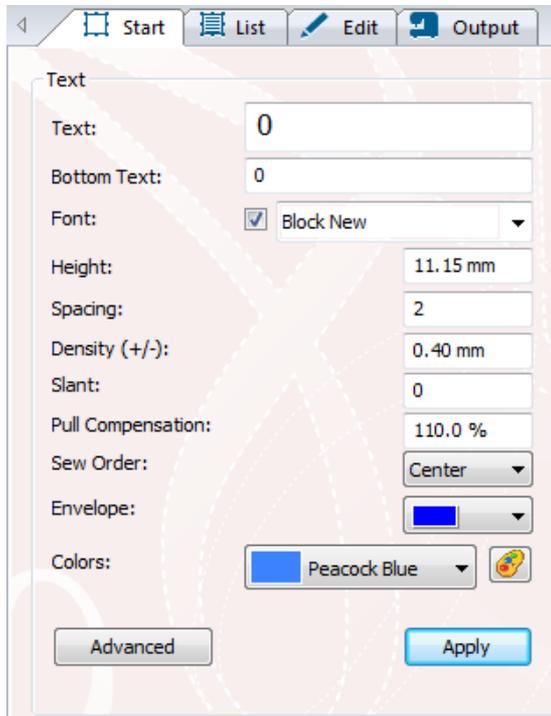
Add Text and/or Designs

Aside from the templates, you can also use the **Add Text**  and

Add Design  tools to add new elements to the open design. These tools can be found on the Autograph Edit tab, in the Add/Delete toolbar area.

The Start tab - an Overview

The Start tab displays – and allows you to adjust – properties of the selected text or design object. Note that the text object or design object must be selected with the Select tool before its properties will show up on the Start tab.



The sections that follow explain each of the properties on this tab, and how to change them.

Properties of Text Segments

When a Text segment is selected, you will see that there are a number of settings that you can use to add interesting effects to your text objects. For example, you can change Lettering height, font, and style (i.e. normal, italic, or bold); you can also add effects to your text, such as stroke, drop shadow, gradient overlay and warp.



The text object must be selected first, before its properties will appear on the Start Tab.

The sections that follow give a guide to the text properties that can be modified on the text tab.

Font

To change the font of a text segment:

- 1) Select the text with the Select tool.
- 2) Click the down-arrow to the right of the font field to view the list of available fonts.
- 3) Click on the desired font to select it.
- 4) Click the **Apply** button to apply the chosen font to the text object.

The segment's font will change to the desired font.

Font Preview

The font preview allows you to get a quick idea of the appearance of all the Autograph fonts, before actually applying the font to the design.

To use font preview, set the checkbox to the left of the font field. Then move the mouse and hold it, over the name of a font in the list (do not click), so that it is highlighted. Autograph will display a 'pop-up' preview image of that font the workspace.



To preview more fonts, just move the mouse pointer up and down the list of fonts.

Height

Determines the height of lettering in your text segment.

To change the height of the text:

- 1) Select the text segment.
- 2) In the height field of the Object tab, type a new value.
- 3) Click the Apply button at the bottom of the object tab.

The letter height will be adjusted accordingly.

Font Spacing

The Spacing setting allows you to add a specified amount of space between each letter (this is effectively the equivalent of “kerning” in print typography).

If the spacing is set at zero, the default, then the normal kerning operation for the font is used. If the spacing is set to less than zero, then the spacing between letters decreases; if it is set to a value greater than zero, then the spacing increases.

To change font spacing:

- 1) Use the Select tool to select a text object.
- 2) Open the Start tab
- 3) In the spacing field, enter the font spacing you want to apply.
- 4) Click Apply to save your changes.

You see your text's letter spacing altered accordingly.

Density Setting

Satin stitch density is measured embroidery points (pts). This is measured as the distance between stitches (each point = 0.1 mm). You adjust density according to the design's size and the fabric you are using.

To make a density change to a segment:

- 1) With the Select tool, select the segment.

- 2) In the density field, enter a new density value; higher numbers correspond to lower density, lower numbers correspond to higher density.
- 3) Click the Apply button.
The density will be applied to the selected segment.

Envelope Shapes

Envelopes are a set of predetermined shapes which, when applied to text, change the overall shape of the segment.

To choose an envelope:

- 1) Select the lettering segment in the workspace.
- 2) In the tabs area, click on the Start tab to bring it forward.
- 3) Click the down arrow next to the Envelope field to see the list of Envelope shapes.



Choice of envelops shapes

- 4) Click a shape to select it, and click Apply.
You see the lettering altered accordingly

Adding Slant to Text

Use the Slant setting to create a slanted effect for your lettering. Slant changes the degree value of the slant on your lettering. A negative value slants your lettering to the left; a positive value slants it to the right.

To add slanted effect:

- 1) Select the text segment.
- 2) Select the Start tab to display the properties page.
- 3) In the Slant field, enter the amount of slant you want to apply to your lettering. The slant is measured in degrees; straight up-and-down is considered as zero degrees.
- 4) Click Apply.

You see the lettering altered accordingly.

Kerning Text Segments

Kerning refers to the space between adjacent letters. You can adjust the kerning of a text segment to make it more visually appealing, or to make it fit in a tighter space.

You can adjust the kerning by entering any number of kerning marks in between the letters in the Text box on the Start tab. You add a “greater than” > symbol to increase kerning, and a “less than” symbol to decrease it. One > or < mark represents 1/20th of the width of a letter “M” of the font you are working in.

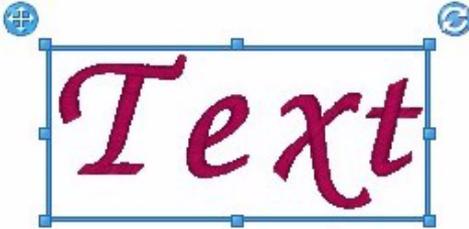
To move letters closer together:

- 1) Select a text segment.



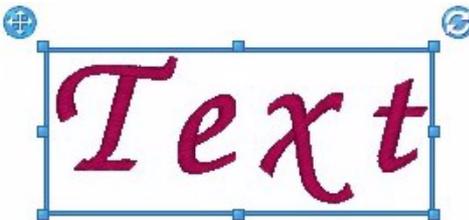
Original text segment, with the kerning as is

- 2) In the Text box (on the start tab), enter the “less than” sign (<) between the letters you want to kern.
For example, if you wanted to tighten the space between the "T" and "e" in the word Text, you would enter: T<<<ext.
- 3) Click the Apply button to apply the change.
You see the lettering altered accordingly.



To move letters farther apart:

- 1) Select your text segment.
- 2) In the Text box (on the Start tab), enter the “greater than” sign (>) between the letters you want to kern.
For example, if you wanted more space between the "x" and "t" in the word Text, you would enter: Te>>>xt.
- 3) Click the Apply Button to apply the change.
You see the lettering altered accordingly.



Pull Compensation

Pull compensation extends (or reduces) the length of stitching in a segment to compensate for the tendency of fabric to “pull together” when embroidery is sewn overtop of it. The amount of Pull

Compensation (if any) required is dependent on the kind of fabric you are sewing on; very stiff fabrics need little or no pull compensation, while loose fabrics need more compensation.

The Pull Compensation is expressed as a percentage of the original stitch length. For example, if you adjust the pull-compensation to 120%, the stitches will be extended 20% longer than with no pull-compensation set.

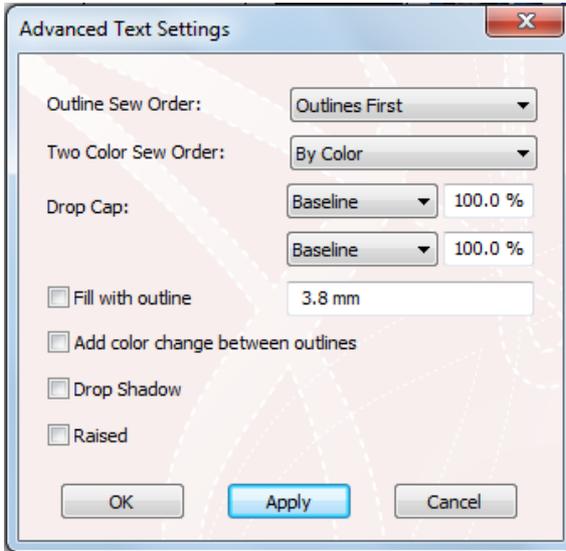
Sewing Order

The sew order property determines at what point in the text segment the sewing will start; on the left, in the right or from the center. To change the sewing order, choose either Left, Right, or Center from the drop-down list, and press the **Apply** button.

Advanced Text Settings

When a text item is selected, click the Advanced button on the Start tab to open the Advanced settings dialog, which has a number of extra tools and settings that apply only to text. Some fonts are digitized with two colors; you can modify the sewing order of the colors in these segments in the Advanced settings.

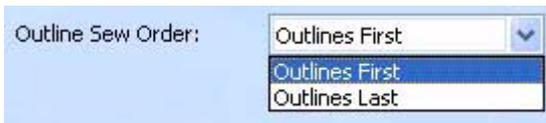
The Advanced Text settings also allow the designer to add outlines, drop caps, and drop shadow to the selected text. Each of these different settings is detailed separately in the sections that follow.



Outline Sew Order

Certain types of lettering segments can have an separate outline of embroidery sewn around the letters. In other words, these letters have two components, a fill and an outline.

By changing on the Outline Sew Order property, you can either have the outline stitches sew before the fill stitches, or have the outline stitches sew after the fill stitches.



Two Color Sew Order

Some of the fonts available with Autograph are two-color fonts. Under the start tab, there is a setting that allows you to change the sewing order of two-color lettering. Two-color fonts can be sewn letter by letter (in which case there will be more color changes) or color by color. You

may prefer to sew lettering letter by letter on baseball caps because achieving proper registration can be a challenge.

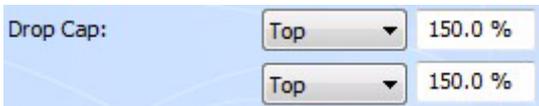
To change the two-color sewing order,

- 1) Open the Start Tab.
- 2) On the Start tab, click the **Advanced** button.
You see the Advanced Text Settings dialog.
- 3) In the Two color sew order field, clicked the down-arrow to select either of the following:
 - ♦ By color.
 - ♦ Sew by letters.
- 4) Click the Apply button.

Drop Caps

The drop caps setting can be used to change the to height and vertical alignment of the letters at the beginning and end of the selected text.

There are two sets of fields for this setting; the top one corresponds to the first letter of the segment, the bottom one corresponds to the last letter. The alignment option determines the position relative to the baseline of the main lettering (baseline, top, center, or bottom).



The size property determines how much bigger than the main segment the drop cap letter will be. This value is expressed as a percentage, with 100% being equal in size to the main lettering.

DROP CAPS

Fill with Outline

The outline is a stitch effect that surrounds lettering with a separate outline of embroidery. There are two types of fonts that come installed with Autograph – outline fonts, which have a vector outline built into them, and regular fonts, which do not. The way that the outline is generated depends on the which type you are applying the Fill with outline to



In the list of fonts in the drop-down list, outline fonts can be distinguished by this symbol  next to the font's name.

For Outline fonts: The border that will be generated will be a true outline of the letters in the font. It will follow the vector outline around the letters, and its width (in mm.) will be determined by the value you enter into the Fill with outline field. The outline of each will sew separately from the fill - you can determine the sewing order (either outlines before fill, or outline after fill) in the Outline Sew Order field on the Start tab.

For regular fonts: If the selected font is *not* an Outline font, Fill with outline will create another layer of stitches, behind the selected lettering, in a different color. This contrasting layer will extend slightly beyond the edge of the lettering, so that it forms an outline around it. In this case, the value of the Fill with outline field determines how far the base stitches extend past the stitches of the top.

To add an Fill with outline:

- 1) Select the Text segment.
- 2) On the Start tab, click the **Advanced** button.
You see the Advanced Text Settings dialog.
- 3) Click the **Fill with outline** checkbox.
- 4) In the width field (to the right of **Fill with outline**), enter the width of the border stitches.
- 5) (Optional) Check the **Add color change between outlines** box to create an outline that is a different color from the fill.



If the selected font is an outline font, you will see that the “Add color change between outlines” check box is active. Check this box to create an outline that is a different color from the fill.

- 6) Click **Apply** to add the Fill with outline stitches, and then OK to close the Advanced dialog.

In the workspace, the new border will appear on the selected text object.

Outline

- 7) To change the color of the border stitches, select that color in the Colors field of the Start tab, and select the desired color from the thread color dialog. For more information, see “Color Change.”

Drop Shadow

Drop shadow adds a shadow shape to a text object, which gives it an illusion of depth.

To add a drop shadow:

- 1) Select the Text segment that you want to add a drop shadow effect to.
- 2) On the Start tab, click the **Advanced** button.
You see the Advanced Text Settings dialog.
- 3) Click the Drop Shadow checkbox to activate it.
- 4) Click **Apply** to generate the drop shadow stitches.

In the workspace, the drop shadow will appear on the selected text object. The drop shadow stitches will be enclosed in an orange frame, separate from the text frame; this frame can be moved independently of the text frame.



- 5) If required, adjust the Drop Shadow's position of by clicking and dragging the direction handle  at the lower-right corner of the orange frame.
- 6) When first generated, the color of the shadow stitches will be chosen arbitrarily. To change the color of the shadow portion of the text segment, select that color in the Colors field of the Start tab, and select the desired color from the thread color dialog. For more information, see "Color Change."

Raised Lettering

The Raised setting is used when sewing lettering onto foam, to give a 3-dimensional effect. The Raised text setting increases the density of the satin stitching, and adds contour and perpendicular underlay to it. This gives the embroidery the increased stability needed for sewing on foam.

To apply the Raised settings to a Text segment:

Select the text segment.

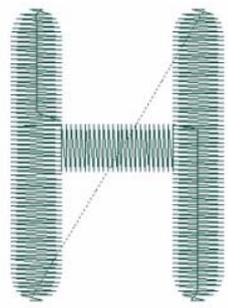
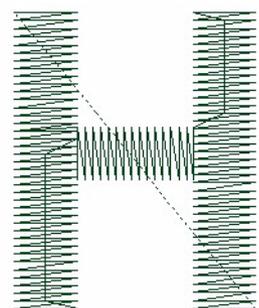
- 1) On the Start tab, click the **Advanced** button.
You see the Advanced Text Settings dialog.
- 2) Check the **Raised** checkbox
- 3) Click **Apply**.

Raised Lettering: Choosing an appropriate font

Not all fonts will work well when creating raised foam lettering. As a general rule, suitable fonts are those that have short stitches at the end of the satin columns, rather than long ones. This is because the short stitches will create more penetrations at the ends of these columns, which will allow for better separation of the foam filling after sew-out.



An exception to this general rule is the 3D Block font, which was digitized especially to be used with foam lettering.

	
Font with short stitches at the column ends - good for foam letter.	Font with long stitches at the column ends - not suitable for foam.

Examples of fonts suitable for foam lettering:

ATHLETIC
OUTLINE

Breezy

Carnival

Kindergarten

Notes on Raised Lettering: Text with Outlines

For a lettering segment in which Fill with Outline is applied *in addition* to the Raised setting, the special settings (increased density, underlay) will only be applied to the “center” stitches, and not to the “border” stitches.

In this case, the border stitches will always be laid down before the center stitches. Therefore, to apply 3D foam to lettering like this, you will want to first sew the border, place the foam, and then sew the center stitches. For more information, see “Fill with Outline.”

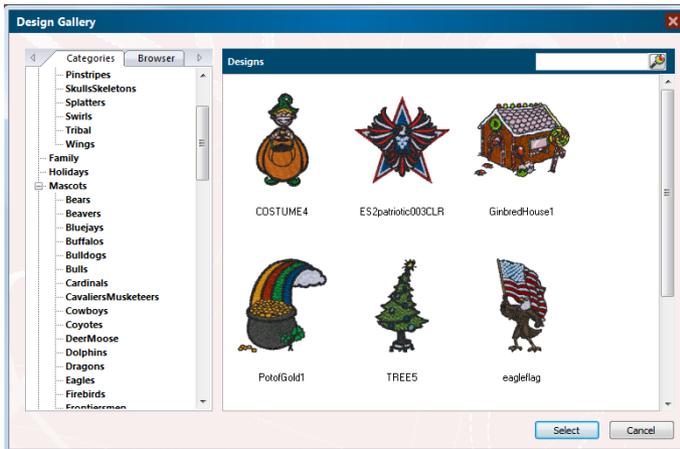
Changing a Design

If you have selected a design (rather than text) in the workspace, you will see a different set of controls on the Start tab. One of these will be the **Change...** button. This opens the Design Gallery, a dialog box that allows you to replace the selected design. There are two ways that you can change the design in your template:

- **Select from the categories tab:** This will show you a list of designs that come pre-loaded with the Autograph software
- **Select from the Browser:** This allows you to choose a design from the any drive that is accessible from your computer.

To replace a design from the categories list:

- 1) In the toolbar, click Select tool.
- 2) Click on the design to select it.
The design will be highlighted by a selection box.
- 3) In the Start tab, click the Change... button.
The Design Gallery will open in a new window.



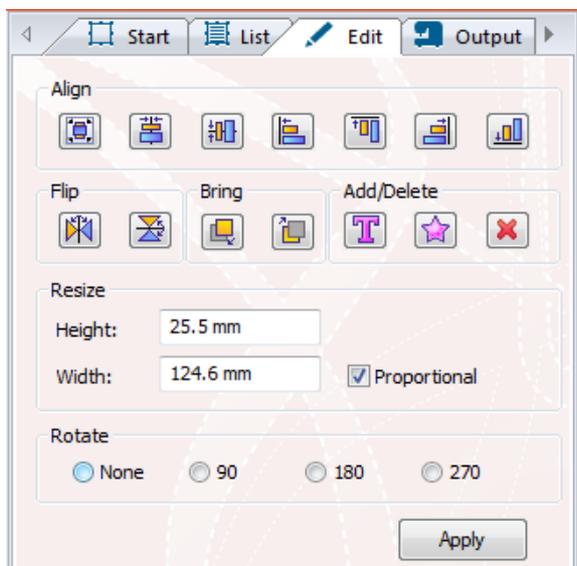
- 4) From the Categories list in the left-hand column of the Designs Gallery, select a category.
You see thumbnails of the designs in the chosen category in the Design Gallery preview panel.
- 5) Click on a design in the preview panel to select it.
- 6) Click the Select button on the Gallery.
The new design will appear in the workspace, replacing the old one.

To replace a design from the Browser:

- 1) In the toolbar, click Select tool.
- 2) Click on the design to select it.
The design will be highlighted by a selection box.
- 3) In the Start tab, click the Change... button.
The Design Gallery will open in a new window.
- 4) In the Design Gallery, click on the Browser tab.
The left-hand column will display a “tree” showing all the available directories on your computer. This includes any portable storage devices (such as a CD and/or USB flash drive) as well as folders on your computer’s drives.
- 5) Browse to the folder containing the design you want to use.
You see the thumbnails of the designs in the directory in the Design Gallery preview panel.
- 6) Click on the design to select it.
A border appears around the selected design
- 7) Click the Select button in the Gallery.
The new design will appear in the workspace, replacing the old one.

Functions of the Edit Tab

Individual objects, or groups of objects in the design can be easily modified with the Editing tools in Autograph. The tools on the Edit tab allow you to modify existing embroidery objects, including both designs and text.



Align Tools

The Align Tools can be used to align different objects in the workspace relative to one another; for example, if you want to make sure that a different lines of text are exactly centered relative to each other.

To align design objects:

- 1) Select all the objects you want to align.

2) Click on one of the following tools:

	Center: The selected object, or group of objects (if more than one is selected) are moved so that it is centered in the frame. Note that, if a <u>group</u> is centered, they retain the original positions relative to each other.
	Horizontal Center: All selected objects are moved so that they are centered left-to-right with respect to each other, but are not moved up or down.
	Vertical Center: All selected objects are moved so that they are centered top-to-bottom with respect to each other, but are not moved left or right.
	Align Left: Aligns all selected objects with the left-most item selected.
	Align Right: Aligns all selected objects with the right-most item selected.
	Align Top: Aligns all selected objects with the top-most item selected.
	Align Bottom: Aligns all selected objects with the bottom-most item selected.

The objects will be realigned in the workspace.

Edit and Arrange Tools

Flip tools

The Edit tools of Autograph can be used to flip or “mirror” objects in the design - can be applied equally to text objects or design. Use the

Flip Vertically  tool to flip an object around a vertical axis (mirrors left/right); use the Flip Horizontally  tool to flip it about its horizontal axis (mirrors top/bottom).

Arrange tools

Embroidery segments in the workspace appear “stacked” in layers, in the order in which they were added to the design. Therefore, objects that are added later may obscure those added earlier. In cases where

this is a problem, you can use the Arrange tools to change the layer order of the selected object.

Using Arrange tools:

- 1) Select the object you want to move in the layer order.
- 2) Do one of the following:
 - ♦ Click the Send to back  tool to put it to the first (bottom) layer.
 - ♦ Click Bring to front  to move it to the last (top) layer.
You see the stacking order changed accordingly.

Adding a New Text Segment

The Add Text  tool is used to add a new text segment to a design.

To add a new text object:

- 1) Create a new design from one of the templates, or open an existing design.
- 2) Select the Edit tab.
- 3) Select the Add Text  tool.
A selection frame, containing a placeholder string (TEXT) appears in the design window.
- 4) Open the start tab, and change the default text by typing new text in the Text field.
- 5) Make any necessary changes to your lettering using the various fields on the Start tab (for example, font, letter height, stroke, etc.)
For more details, see “Properties of Text Segments”.
- 6) In the Start tab, click Apply.
The text object will be modified accordingly.



To remove the text object from the design, select it with the Select tool, and click the “Delete selected objects”  button.

Adding a New Design

The Add Design  tool is used to add a new design object to a design, or to a custom template.

To add a new embroidery design:

- 1) Create a new design from one of the templates, or open an existing design.
- 2) On the Edit tab, click the Add Design  tool.
The Design Gallery will open in a new window.
- 3) Do one of the following:
 - ♦ From the Categories list in the left-hand column of the Designs Gallery, select a category.
 - ♦ To use a design on your computer or network select the **Browser** tab, and browse to the drive or folder which contains the embroidery design you want to add.
The Designs in this category, or in the chose directory, will be previewed in the Gallery.
- 4) Click on a design to select it.
- 5) Click the Select button on the Designs Gallery.
The selected design will appear in your design.



To remove the design, select it with the Select tool, and then click the “Delete selected objects”  tool.

Resizing the selected Object

Use the Resize area on the Edit tab to change the size of the selected Text or Design segment.

By default, the selected design element will be changed proportionally; however, you can uncheck the “Maintain Aspect Ratio” box to change the height without changing the width, or vice-versa.

To resize segments using the Transform tab:

- 1) Using the Select tool, select one or more design segments.
The active segment or segments will be enclosed in a selection box with handles.

- 2) In the tabs area, click the Edit tab.
- 3) In the Transform area of the Edit tab, do the following
 - ♦ In the Width box, enter the width you want for the selected segment.
 - ♦ In the Height box, enter the height you want for the selected segment.



If the Maintain aspect ratio box is checked, you only have to change one of the dimensions (i.e., either height or width); the other dimension will be scaled automatically. To change only one dimension without changing the other, uncheck the Maintain aspect ratio box.

- 4) Click Apply.

The design will be resized to reflect the changes.

Rotating the Selected Object

You can rotate the selected text or design object by selecting the appropriated radio button in the Rotate area of the edit tab; the object can be rotated by 90°, 180°, or 270°. If desired, select the 0° to put the object back in its original orientation.



To rotate an object through a different angle, click and drag the rotation tool  on the selection frame.

Changing Thread Colors

Changing Colors on the Start Tab

You can use the color field in the Start tab to change individual colors a design or lettering segments. A number of manufacturers' thread charts come loaded with the Autograph software. You can select the chart you want to use, and then the color you want, by way of the Threads Gallery dialog.



You can also change the color of an individual segment by selecting it in the list tab; however, this method only allows you to choose from among those colors that are in the design already.
For more details, see “Learning about the Workspace—List Tab.”

To change a color of a segment:

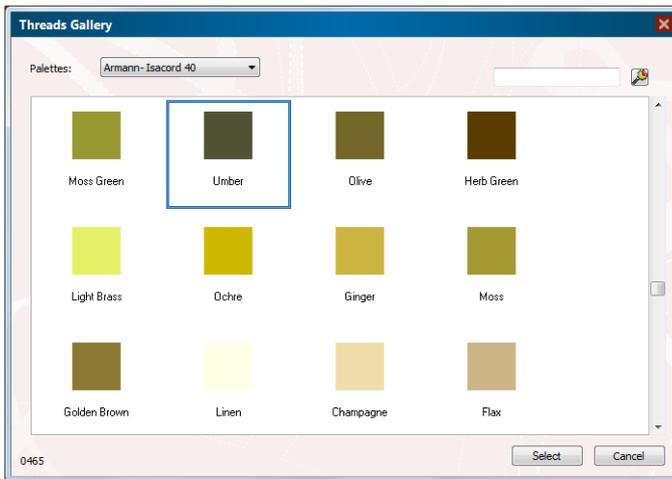
- 1) Select the object (design or text) in the workspace.
- 2) On the Start tab, click the down-arrow beside the color field, and select the color you wish to change.



If the design or text has more than one color in it, the colors will be displayed in this drop-down list in the order in which they come in the sewing sequence, from first to last. To see which color corresponds to which segment of the design, open the **List** tab.

- 3) Click the Thread Change  button.

The Threads Gallery will open in a new window.



- 4) In the Threads Gallery, select a thread chart from the palettes field.
The colors in the Thread Gallery display will change appropriately.
- 5) Click on a color to select it.



If you already know the name (or part of the name) of the color that you want, enter it in the search field at the top-right of the dialog. The dialog will then display all threads containing the text you enter; e.g. entering 'blue' will return "Sky blue", "Light blue", "Blueberry", etc.

- 6) Click the Select button in the Threads Gallery.

The color of the selected segment will change to match your selection.

Setting up the Machine Needle Palette

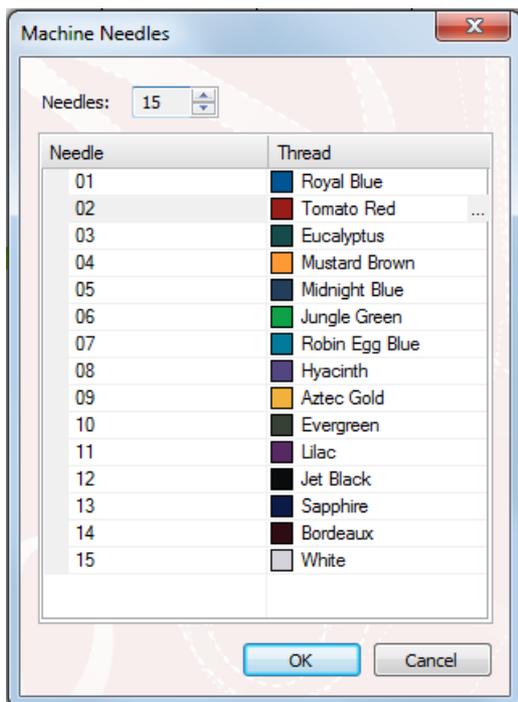
The Needle Palette dialog is intended to display, within the Autograph program, the thread colors that are physically on the embroidery machine. Once set up, this facilitates the process of matching the colors in your design with the needle colors, for the purpose of outputting the design to the machine.

The Machine Needle Palette is installed “pre-loaded” with a set of default thread colors already assigned to each needle. Using the Setup Machine Needles  tool, you can determine which colors in the thread chart are on which needle.

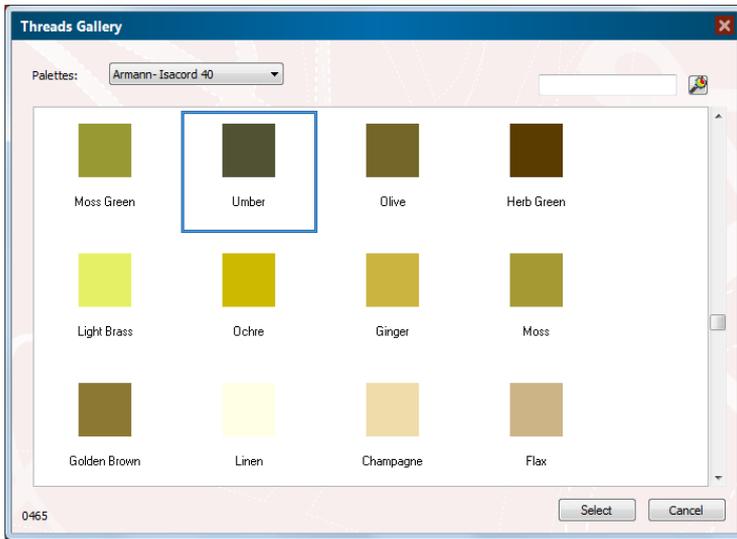
To change threads in the Machine Needle palette:

- 1) On the List Tab, click the Setup Machine Needles  button.

You see the Machine Needles dialog.



- 2) Select the needle number you want to change.
- 3) On the right side of click the button.
You see the Threads Gallery dialog.



- 4) Select the desired thread palette from the Palettes drop-down.
- 5) Choose a thread color form the palette, and click Select.



If you already know the name (or part of the name) of the color that you want, enter it in the Search field at the top-right of the dialog.

The dialog will then display all threads containing the text you enter; e.g. entering 'blue' will return "Sky blue", "Light blue", "Blueberry", etc.

The new color appears in the appears in the Machine Needle list.

- 6) Repeat steps 2-5 for each needle you need to change.
- 7) When done, click OK on the Machine Needles dialog to close it.

Matching Design Colors with the Machine Palette

The Match Machine Palette  tool is a quick way to convert design colors to the actual Machine needle colors, as assigned in the Machine Needle palette.

In order to use this tool, you must first create a Machine Needle palette that correctly reflects the needle thread colors on the machine. For the details about that procedure, see “Setting up the Machine Needle Palette,” above.

Once the Machine Needle palette has been set up, the procedure is very simple; create a design (or open an existing one) and click the Match Machine Palette  tool (located on the List tab). This tool’s color-matching algorithm will automatically assign each color segment in the design to the needle with the most similar color in the Machine Needle palette.

When you output the design, the colors will now match those of the machine needles.

Autodigitizer Wizard

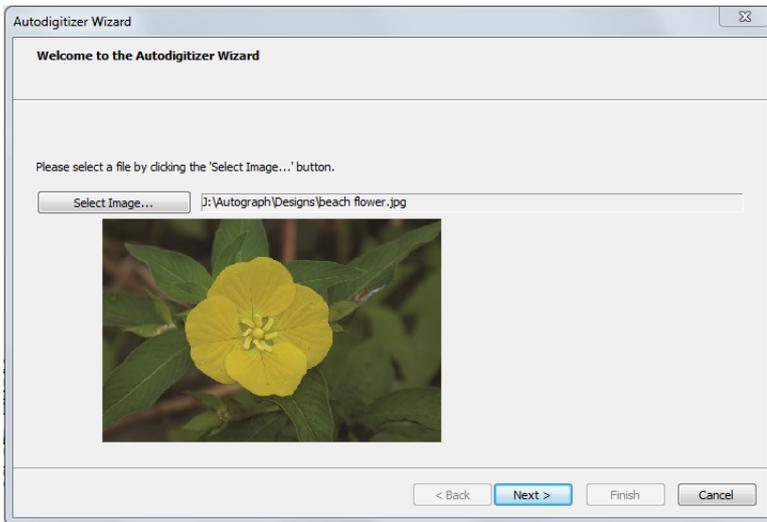
You can create embroidery from imported images in a few simple steps using the Autodigitizer Wizard. This tool uses a step-by-step procedure to convert bitmap images to embroidery segments; simply choose an image and follow the instructions as they come up.

You can use images with shading because by the Autodigitizer ignores closely related colors when cleaning the image during color matching (see step 3).

Step1: Open the Image file

- 1) On the toolbar, select the Autodigitizer  icon.

You see the Autodigitizer Wizard window.

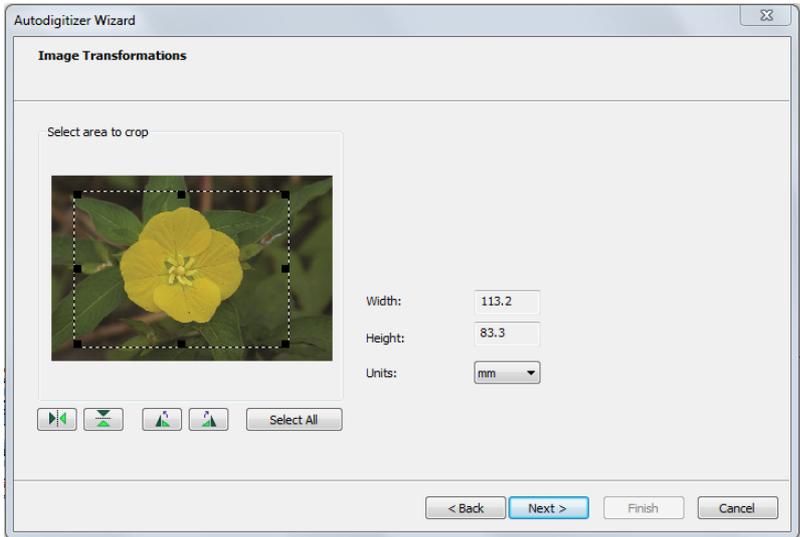


- 2) Click Select Image to choose the type of file you want to autodigitize.
- 3) Click Next.

You see the Autodigitizer Wizard-Image Transformations window.

Step2: Image Transformations

In the Image transformation window, you can (if you wish) crop the image that you just imported, and change its size before digitizing. If the image is one of the bitmap formats (such as *.jpg or *.bmp) files, you can crop, rotate, flip and resize the image.



- 1) To crop the image, select only the portion you want to digitize; place your the mouse pointer over the black dots around the image and drag them to resize the selection box.



To reset the selection, click Select All to select the entire image again.

- 2) To set the image size proportionally, enter a width or height in the corresponding box of the dialog. Select the units system in the box below.
- 3) Click on any of the following Transform buttons do any of the following to the image:

- ◆ Flip horizontally  .
- ◆ Flip vertically  .

- ◆ Rotate 90° Clockwise .
- ◆ Rotate 90° Counterclockwise .

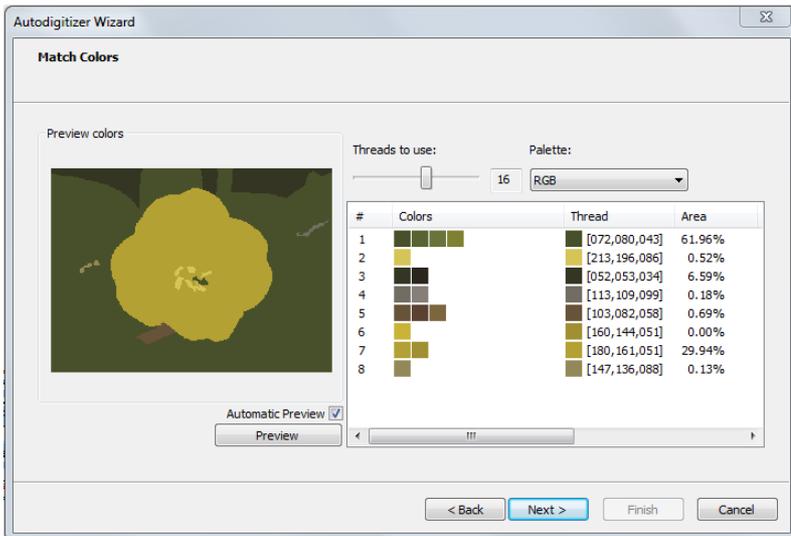
4) Click Next.

You see the Autodigitizer - Match Color window.

Step 3: Color Match

In the Match Color dialog, the original colors of the image (RGB) will be shown in the Colors column. When you choose the thread palette, the wizard will match these RGB colors to the closest color in the chosen palette.

These threads, and their RGB numbers, will be displayed in the Thread column; the Area column will show the percentage of the area of the entire design that is covered by the color in that particular row.



- 1) Select the thread palette you wish to use for the embroidery from the drop-down list at the top of the dialog.

- 2) Select the number of thread colors that will be used to create the autodigitized image by dragging the “Threads to use” slider; left for fewer colors, and right for more colors.



Check the Automatic Preview box to automatically update the image as you change the number of colors; or, uncheck Automatic Preview and click the “Preview” button manually to see the change in the image.

- 3) To further reduce the number of colors, click and drag color “swatches” (squares) into another color row. When a color swatch is moved to a new row, the stitches originally assigned to that color (the one that you moved) will be given the new color.

In the Area column, you will notice that the percentage is now the sum of the area of the two colors that have been combined.

- 4) After reducing the number of colors to a suitable number, click Next.

You see the Automatic Segments window.

Step 4: Setting the Automatic Segment widths

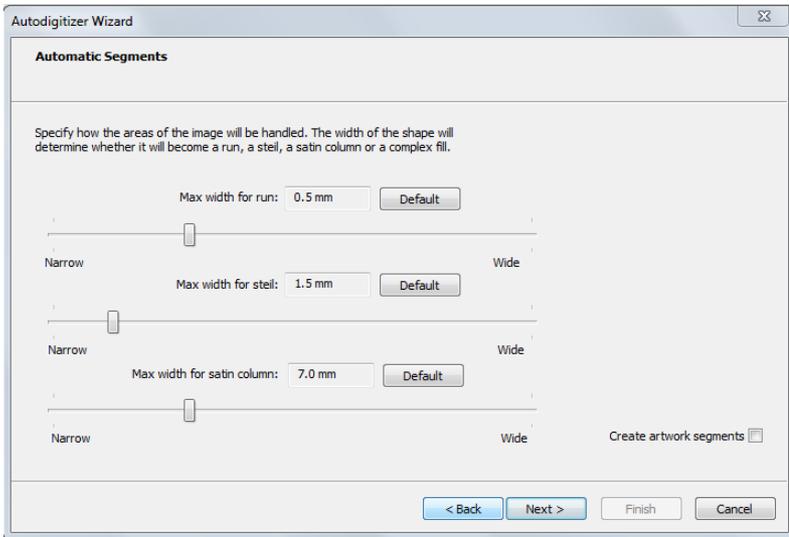
The Autodigitizer wizard algorithm will automatically choose different stitch types to apply, depending on the shapes that it encounters in the image to be digitized.

Effectively, what happens is that long, narrow parts of the image will be digitized as either Run, Steil, or Satin Columns (anything larger than a certain defined width will be digitized as a Complex Fill). Which of these three types will be used for the narrow parts of the image will depend on the actual width (in embroidery points) of the color segment to be digitized.

By default, segments will be digitized as follows:

Width (in the image)	Segment type applied
0.1–0.5 points	Run Stitch
0.6–1.5 points	Steil Stitch
1.5–7.0 points	Satin Column
7.0 points or wider	Complex fill

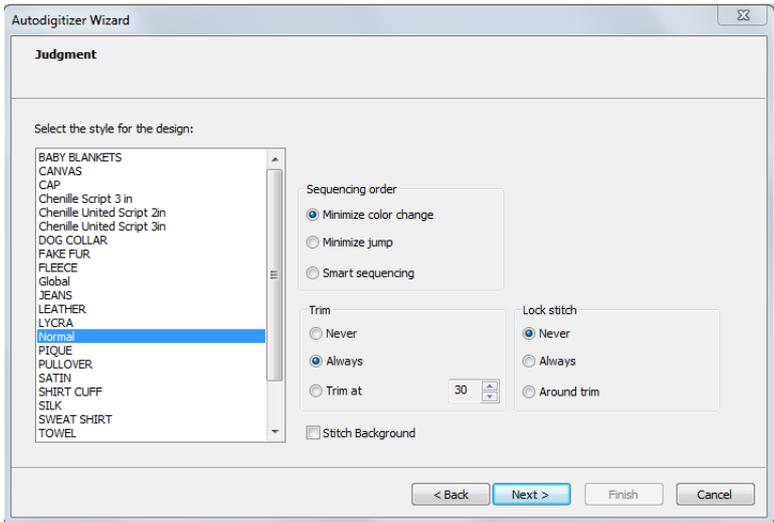
However, you are able to override these values for each type of stitch, using the controls on the Automatic Segments page.



- 1 Drag the sliders for each of the embroidery segment types to determine the maximum width that each stitch type will apply to.
The chosen width will be displayed in the small boxes above each slider; to return each to its default value, click the Default button.
- 2 Click Next.
You see the Judgment window.

Step 5: Judgement Settings

This window allows you to change the settings that will be applied to the stitches. Also, there is also the option to digitize the background of the image.



- 1) Select the recipe (style) that is appropriate for the fabric you will be sewing onto.
- 2) In the Sequence Order area, select one of the following to adjust the sewing sequence:
 - ♦ Minimize jump.
 - ♦ Minimize color change.
 - ♦ Smart sequencing.



Smart sequencing is a option that preferentially moves narrow border stitches later in the sewing sequence, so that the sew on top of large complex fill areas, rather than the other way around.

- 3) In the trims area, select any of the following trim settings:
 - ♦ Never.
 - ♦ Always.
 - ♦ Trim at. The system will place a trim if the distance between stitches is longer than the distance displayed in the Trim At box.

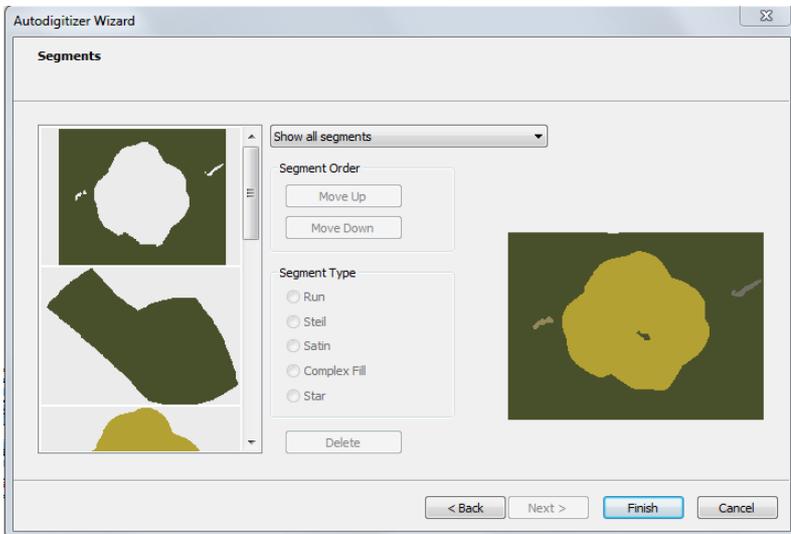
- 4) In the Lock Stitch area, select any of the following lock stitch settings:
 - ♦ Never.
 - ♦ Always.
 - ♦ Around Trim.
- 5) To create stitching of the background, check the “Stitch Background” checkbox. (Check background is off by default).
- 6) Click Next.

You see the Segments Window.

Step 6: The Segments View

In the Segments window, a complete list of the segments in the design will be shown on the left side of the dialog; use the scroll bar to see all of the segments.

In this window, you can change the sewing order of segments, select which type of segment is shown in the list, and convert segments from one embroidery segment type to another.



- 1 To change the sewing order of any individual segment, do the following:

- ◆ Select the segment
- ◆ Click on the “Move up” button to move it earlier in the sewing sequence
- ◆ Click the “Move down” button to put it later in the sewing sequence.

You see the segment move accordingly.

2) To show the segments belonging only to a certain type, click the down-arrow next to “Show all segments” and choose one of the following:

- ◆ Show only run segments.
- ◆ Show only steil segments.
- ◆ Show only satin segments.
- ◆ Show only complex fill segments.
- ◆ Show only star segments.

You see that only the stitch segments of the selected type are shown in the sequence view.

3) To change the stitch type of any segment:

- ◆ Select the segment.
- ◆ In the Segment Type area, click the radio button corresponding to the stitch type you want to convert the segment to: Run, Steil, Satin, Complex Fill, or Star.

4) To delete a digitized segment:

- ◆ Select the segment.
- ◆ Click the Delete button.



Once you have deleted a segment, the only way to get it back is by using the back button to return to the Judgement page, and then hitting Next again to return to the Segments page.

5 Click Finish to autodigitize the design and view the design file in the design workspace.

Using the Import CSV feature

The **Import CSV**  tool is a way to create ‘name drop’–type designs for output.

This type of design consists of a single design with at least one text segment (with or without other, non-text, elements) serving as the template. A number of variations on the text can be superimposed on top of each other, in layers – one for each design that will be sewn out. Sewing stops between each layer, to permit the machine operator to remove the garment that has finished sewing with a new, blank one. Doing this allows a large number of garments of a similar design (but with variable text) to be sewn based on a single output file.

The **Import CSV** tool facilitates this process. With this function, you can type all the require text strings into a table in CSV (“comma-delimited” format) which can then be imported it into Autograph 2.



Spreadsheet programs (such as Microsoft Excel) can be used to create *.csv files, using the “Save as” tool. However, any program that can save as *.csv may be used to create the list of names.

After the CSV is imported, the design will have of a series of text segments, stacked in the order that they appear in the CSV. When sent to the machine, the text will then sew out in this same order, with a stop in between each “layer,” for removing and re-inserting the hoop.

To use Import CSV:

- 1) Create a new design including at least one text segment, or open one of the existing templates.



NUMBER

A hypothetical template, with a graphic and two text strings.

- 2) Create a spreadsheet containing the text strings you want to import. Ensure that there is one column for each text string within your Autograph template.

The first column of imported text will be assigned to the text segment that comes first in the sewing order, and the second to the second, and so on.

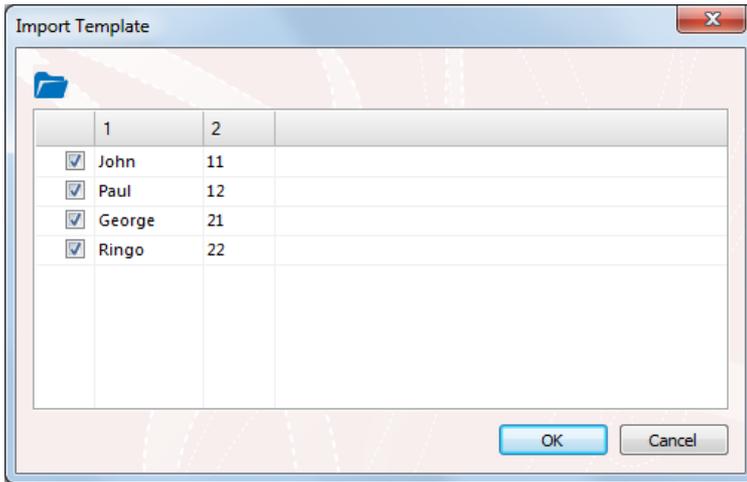


So, if you have a text segment that you want to be kept constant (for example, a team name), make sure that it comes later in the sewing order than the text segments that are variable.

	A	B	
1	John	11	
2	Paul	12	
3	George	21	
4	Ringo	22	
5			

- 3) Save the spreadsheet in*.csv format.
- 4) Going back to Autograph, select the Import  CSV tool.
You see the Import Template dialog.
- 5) Click the folder button.
You see a browse dialog.
- 6) Browse to the directory where the *.csv file has been saved, select it, and click Open.

The names appear in the list in the Import Template dialog.



If you do not want to place one (or more) of the rows, uncheck the box to its left; then, the corresponding text strings will not be generated.

7) Click OK.

*The imported text strings from the *.csv now appear as embroidery text segments in the design.*



CHAPTER 4:

Output Tools and Settings

This selection covers:

- Outputting designs to the machine.
- Viewing the design queue.
- Checking machine status.
- Viewing reports.

Using the Output tools

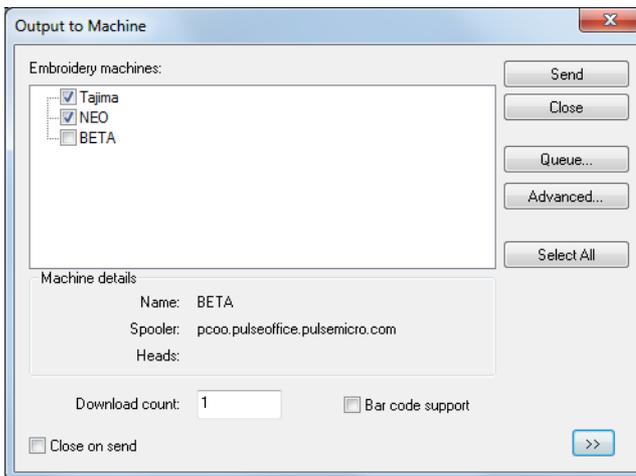
Send to Machine Tool

You can send embroidery files directly to the embroidery machine from Autograph. Note that the following procedure applies only to designs in which the colors of the design have previously been matched to the needle colors in your Machine Needle palette. Otherwise, you will have to assign colors after sending the file to the machine - see, "Assigning Needles while Outputting a Design" for that procedure.

To send a design to the queue:

- 1 In the tabs area, select the Output tab.
- 2 In the machine area of the Output tab, click the **Send to Machine** button.

You see the Output to Machine dialog; the machine (or machines) will be listed in the Embroidery machines window.



- 3 If there are multiple machines on your spooler, select the one you want to send the design to by clicking the checkbox next to the machine name.



If your machine has a bar code reader, you can check **Bar Code Support** at the bottom of the dialog; this will make all file names that are output readable by bar code scanners.

4 Click the Send button.



If there is only one machine available on your design spooler, the design will be sent directly that machine's design queue. Therefore, the Output to Machine dialog will not appear, and you will not have to preform steps 3 and 4.

The design will be sent to the Design Queue; you will see the Output Results dialog, which shows the design's output status.

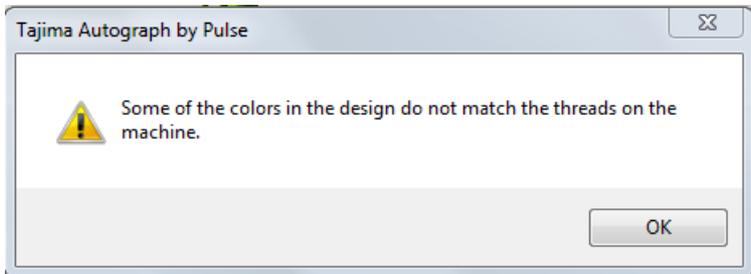
Assigning Needles while Outputting a Design

In Autograph, the list view allows you to change the original design colors to match the colors set on the machine palette (see “Creating and Editing New Designs—Setting up the Machine Needle palette”).

However, you can also match the colors while sending the file to the machine. This is accomplished by using the **Automatic Needle Assignment** tool; check this box (on the Output tab) and this tool will be invoked whenever you send a design which contains any colors that do not match those in the Machine needle palette.

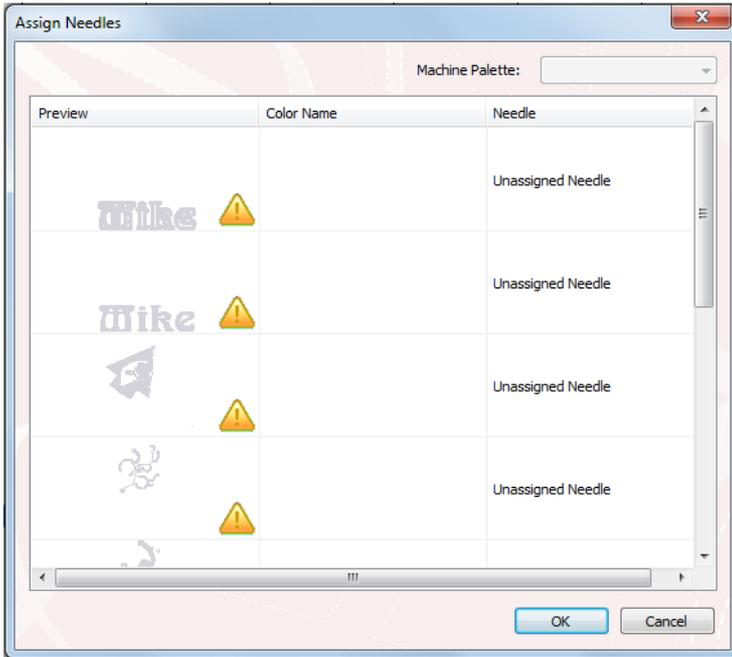
To Assign Needles while Outputting the Design:

- 1 Ensure that the Automatic Needle Assignment box, located on the Output tab, is checked.
- 2 On the Start tab, click **Send to Machine**.
You see a warning dialog.



- 3 Click OK to dismiss this dialog.

The Assign Needles dialog opens.



- 4 To assign needles to the colors in the design, do the following steps:
 - ◆ Select the first segment labelled as an “Unassigned needle” in the list
 - ◆ Click the down-arrow next to next to the “Machine Palette” field.
 - ◆ The color in the machine palette be displayed.
 - ◆ Select a color from the list.
- 5 Repeat **Step 4** for each segment in design.
- 6 Click OK.

The design will be sent to the machine.

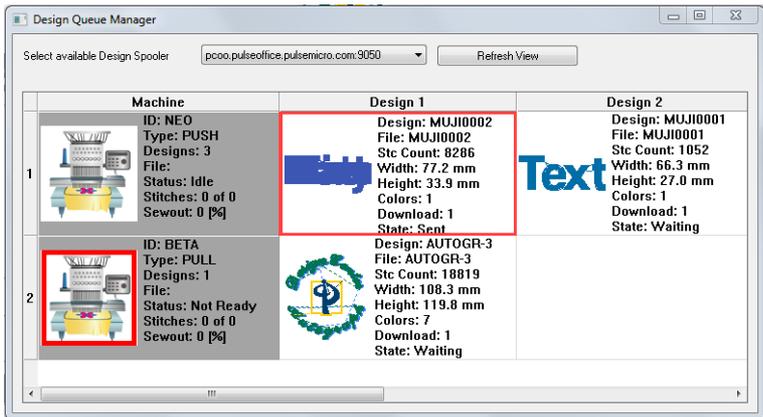
Viewing the Design Queue Manager

In the Output to Machine dialog, you can view designs pushed to your embroidery machines. On the Output tab, click the Design Queue button, which will open a dialog (Design Queue Manager) similar to the one below. Then, you can select an available design spooler and see machine status information.

To open the Design Queue Manager:

- In the Machine area of the Output tab, click the “Design Queue” button.

You see the Design Queue manager.



The Design Queue Manager dialog allows you to view all machines and published designs for a design spooler. The machines and designs connected to a design spooler are displayed one at a time. You can view detailed design information, sewing condition data and other properties for each published design as well as delete one or more published designs from the list.

As designs are sent to machines, they will appear at the end of the queue on the right side. Designs that have been downloaded to machines will disappear from the list, depending on the Download count value. The design's status and machine download percentage value will update as designs download to a machine.

The following table describes the information shown within the Design Queue Manager dialog.

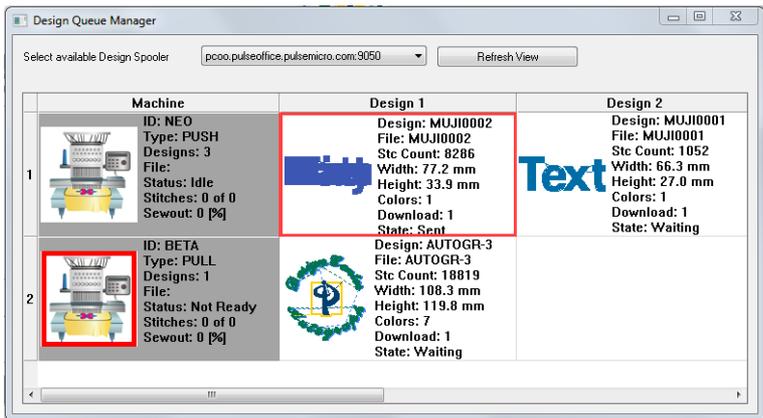
Displayed Information	What it means
<i>The following information is shown in the Machine column (far left). In the Machine column, each row displays information for a specific embroidery machine.</i>	
ID	The machine name.
Type	The type of download: Push or Pull. Push: The design is sent to the machine automatically. Pull: The design can be pulled (downloaded) from the queue directly from the embroidery machine.
Designs	The total number of designs in the queue.
Download	As a design downloads to an embroidery machine, you can view the progress. You will see the percentage of the total design size remaining.
<i>The following information is shown in each Design column. In the Design columns, each row displays information about designs that have been sent to an embroidery machine (shown far left).</i>	
Design	The design name.
File	The file name.
Stc count	The design's stitch count.
Width	The design's width.
Height	The design's height.
Colors	The number of color changes in the design.
Download	The number of downloads set by the Download Count setting.
State	The current state of the design: Waiting or Sent. Waiting: The design is waiting to be downloaded. Sent: The design is currently being downloaded to the embroidery machine.

Assign Needle Numbers

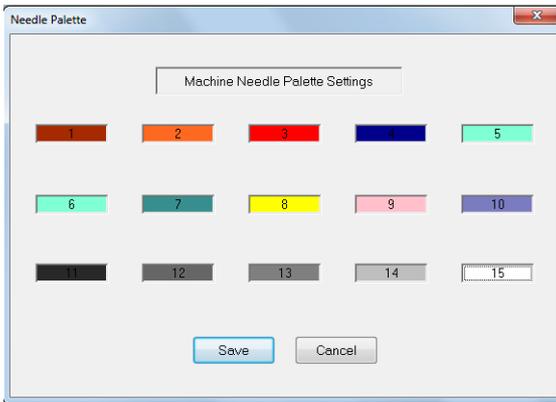
This feature allows you to set the color sequence and assign the needles for a design from the computer, rather than at the machine itself. First, save a design as *.TBF, and then output it to the machine as usual. Then, open the Design Queue, select your design from the queue, and change the needle number assignments from there.

To assign needle numbers from within the Design Queue

- 1 Output your *.TBF design to a machine.
- 2 On the Output tab, click the Design Queue button.
The Design Queue will open.



- 3 To assign colors to your machine's needle palette, do the following:
 - ♦ In the queue dialog, mouse over the TBF machine and right-click on it
You see a context menu.
 - ♦ Select Set Needle palette from the menu.
The Needle Palette for the chosen machine opens.



- ◆ Each rectangle represents a needle on the machine; click on the rectangle for each needle, and choose a color from the palette that appears.
- ◆ Repeat until you have assigned a color to each needle.
- ◆ Click save.



You can also change the Needle Palette from within the Assign Needle Sequence dialog, by clicking the **Set...** button next to the machine palette.

- 4 In the Design Queue, right-click on the design, and choose "Assign needle #" from the context menu.

The Assign needle sequence dialog opens.



The dialog shows a preview of your design, the sequence of colors currently assigned to it along the right (the Needle Bar) and the color palette available on your machine along the bottom.

- 5 Click the Use Machine Palette button.

The colors in your design change to the colors of the corresponding needle in the machine's palette.



Optionally, you can select the **Match Machine Palette** checkbox to have the design colors automatically matched with their closest equivalents within the colors on the needle palette.

- 6 To change the color assignment of one of the colors in your design's sequence, click on that color in the Needle Bar and then click on the color you wish to assign to that needle in the machine palette.

To change all occurrences of a color in the Needle Bar simultaneously, check **Apply Change to all needles with the same #** prior to selecting the new color from the Machine palette.



To make it easier to tell which segment you are changing in the sequence, check **Highlight color**. When this setting is on, only the selected segment will appear in color in the preview, and all other segments will be greyed-out.

The preview displays the new color for that segment.

- 7 Repeat the process with the remaining segments in your sequence.



At any point in this process, you can press the **Restore Original Palette** button in the dialog. This will reset all the colors to their original state when the design was output.

- 8 Click OK.

The design will now appear in the Design Queue with the colors as you have assigned them.

Data Collection

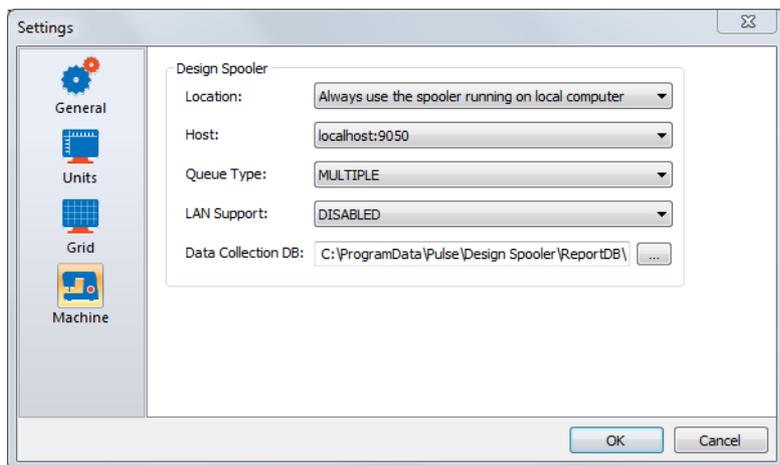
After you have installed Autograph you need to configure the software for data collection, which first involves configuring the location of design spoolers.

Configuring the Location of Design Spoolers

A Design Spooler manages the delivery of designs to embroidery machines using cables (or, if applicable, a LAN connection). Autograph can access spoolers over a network, can be configured to use the spooler running on the local computer. By default you will have access to the machines connected directly to your computer.

To configure the design spoolers:

- 1 On the Tajima Autograph title bar, click the Settings  button.
You see the Settings dialog.
- 2 Select the Machine button.
You see the Machine settings page.



- 3 From the Design Spooler Location list, select one of the following options:
 - ♦ **Locate all spoolers on the Network.** This setting allows you to connect to embroidery machines available on your network.
 - ♦ **Always use the spooler running on local computer.** This setting allows you to only use the embroidery machines connected directly to your computer.
- 4 In the Host list, select the path to the desired host spooler. The configuration settings for the selected spooler will be displayed and you can make changes accordingly.
- 5 From the Queue Type list, select one of the following:
 - ♦ **Multiple (Default).** Create a separate design queue for each embroidery machine.
 - ♦ **Single.** Create one queue for all the embroidery machines connected to this design spooler. This option is only available to machines that support downloading or pulling a design file from the machine's control panel (i.e. LAN or multi-directional serial machines).
- 6 From the LAN Machine Support list, select one of the following ways to control how to communicate with LAN enabled embroidery machines:
 - ♦ Disabled.

- ♦ Enabled.



Only one design spooler can have this setting enabled at one time.

- 7 In the Data Collection DB, click the browse button to the location where reporting data is created (only active when the spooler being used is the local spooler).
- 8 To save your changes, click OK.

Viewing Machine Status

You can view embroidery machine information in real time, or collect data for reporting. Before viewing embroidery machine information, your machine must be setup to send data to your software.

Receiving Data from your Embroidery Machine

The following steps are for a two-head Tajima machine. Check your embroidery machine's documentation to find out how to set the machine to network.

To receive data from your embroidery machine:

- 1 Make sure your embroidery machine is set to network so two-way information can be communicated from the machine to the software and vice-versa.



What you select depends on the Tajima model you have.

- 2 Press F4 on the Tajima control panel. (NW is displayed.)
- 3 Turn the dial and set it to "0" to enable the network connection.
- 4 Open a stitch design in Autograph.
- 5 On the Start tab, click **Send to Machine**.
You see the "Output to machine" dialog.
- 6 If there are multiple machines on your spooler, select the one you want to send the design to by clicking the checkbox next to the machine name.

- 7 Click Send.

You see a dialog appear showing the status of the design output. Click OK to close the dialog.

- 8 Go back to your machine's control panel.
- 9 Press menu key A on the control pad until number 4 is displayed.



These instructions are for embroidery machines connected to serial ports.

- 10 Select Tajima tape format and press SET twice.

When you see M:- the "-" means the design is loading. When the design finishes downloading, the dash becomes a number.

- 11 Go back to Autograph.
- 12 Close the progress dialog, if not already closed, when the design output is complete.
- 13 On the Output tab, click the "Machine Status" button.
You see the Data Collection window.
The Data Collection window gives you information such as the machine's name, design information, the machine's status (running or not running), the machine's speed, and the current stitch.
- 14 From the list at the top, select the Design Spooler connected to the machines you want to view.
- 15 To update the Machine list, click Update Machine List.
- 16 Select the machine whose status you want to view.

In the main Data Collection window, you can view the design sew out in the thread colors you selected for your design. The design is gray and as it sews the correct colors appear. For DSTs, a default palette is used.



You can have a maximum of 10 embroidery machines configured for Data Collection. For each embroidery machine, you need to have a serial port connected.

- 17 Close the window when you are satisfied with the machine and design status.

Viewing the Status of your Embroidery Machine

Machine Status allows you to see on-screen the status of a configured embroidery machine and to automatically associate downloaded files to the machine. Use the  arrow to change the associated file.

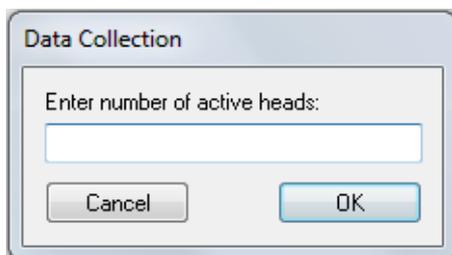


When you select the manufacturer and model of your embroidery machine to configure the software, make sure you select the Tajima Serial Connection option to set up the port properly. The port must be set up so you can use Machine Status.

The Data Collection window gives you information such as the machine's name, design information, the machine's status (i.e. running, not running, thread breaks, etc.), the machine's speed, and the current stitch. You can view a list of published designs for all configured embroidery machines. For *.TBF and *.PSF files, the Data Collection window lets you watch the design sew out in the thread colors you selected for your design. The design is gray and as it sews, the correct colors appear. Other file formats use the default color palette.

To view the current status of your embroidery machines:

- 1 On the Output tab, click the "Machine Status" button.
You see the Data Collection window.
- 2 To update your entire embroidery machine list, click Update Machine List.
- 3 Select the installed embroidery machine you want to view.
You see the following machine status information: machine name, design file name, current machine status, and the sewing speed of the design.
*In the main Data Collection window, you can view *.PSF design files sew out in the thread colors you selected for your design. The design is gray and as it sews, the correct colors appear. For *.DST and other design files, a default palette is used.*
- 4 To choose the number of heads you want to use for the design, click the O button.
You see the Data Collection dialog.



- 5 In the Enter number of active heads box, enter how many heads you want to use from the selected embroidery machine and click OK.
- 6 To view the list of published design for the selected machine, click List.
- 7 Close the Data Collection window when you are satisfied with the machine and design status.

Viewing Collected Machine Data

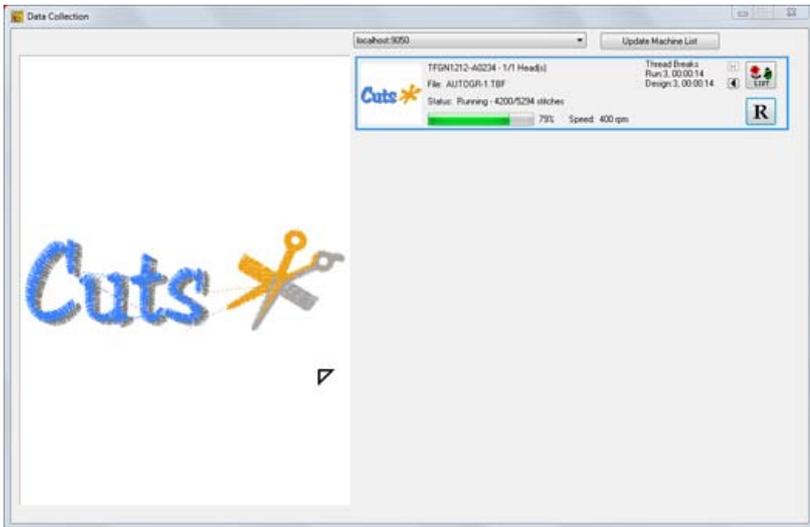
Autograph has a set of reporting tools that allow you to view and save data from embroidery machines connected to the design spooler. You can select from a number of different report types, depending on the information that you want to see; you can also select the time frame for which you want the data collected.

Viewing the Activity Database

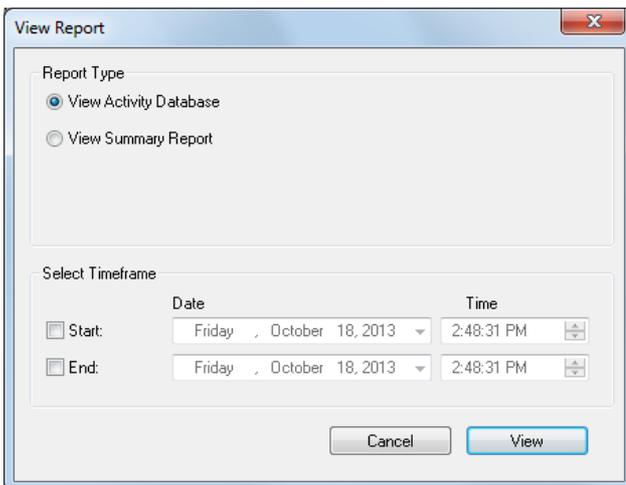
You can view a report of the activity database. The activity database stores each event received from the embroidery machine.

To view an activity database report:

- 1 On the Output tab, click the Machine Status button.
You see the Data Collection window.



- 2 To view the report from one of the embroidery machines, select a design queued for that machine from the list on the right.
- 3 Click the report button **R**
You see the View Report dialog.
- 4 In the Report Type area, select View Activity Database.



- 5 In the Select Timeframe area, select the Start or End time periods for the Activity Database.



If you do not select the start and end time, the entire time frame will be displayed.

- 6 Click View.

You see your report. The activity database stores each event received from the machine.

Activity Report								
Time Interval: 10/21/13 11:46:48 - 10/21/13 12:00:48								
Machines: TFGN1212-A0234								
	Machine	Reason	Head #	Date	Time	End Date	End Time	Duration
1	TFGN1212-A0234	Running		10/21/2013	11:53:56 AM	10/21/2013	11:54:10 AM	0:(null):00
2	TFGN1212-A0234	Thread Break	1U	10/21/2013	11:54:10 AM	10/21/2013	11:55:16 AM	0:(null):01
3	TFGN1212-A0234	Running		10/21/2013	11:55:16 AM	10/21/2013	11:55:35 AM	0:(null):00
4	TFGN1212-A0234	Thread Break	2L	10/21/2013	11:55:35 AM	10/21/2013	11:55:38 AM	0:(null):00
5	TFGN1212-A0234	Running		10/21/2013	11:55:38 AM	10/21/2013	11:56:48 AM	0:(null):01
6	TFGN1212-A0234	Thread Break	2U	10/21/2013	11:56:48 AM	10/21/2013	11:57:36 AM	0:(null):00
7	TFGN1212-A0234	Running		10/21/2013	11:57:36 AM	10/21/2013	12:00:31 PM	0:(null):02

Understanding the Activity Database

To understand your activity database, you should know what each of the column headings mean.



Certain reason codes (i.e. Needle Break, Load Frames or Shift Change) are associated with older Passport Boxes. Operators had the option to enter reason codes manually. Depending on your machine configuration, you may view reason codes not listed in the table below.

Column Heading	What it means
Record #	The identification number stored for each activity.
Machine	The machine name.
Box	This option is ignored.

Column Heading	What it means
Reasons	<p>This lists the Reason names and/or ID Numbers. Each Reason ID corresponds to a specific reason. The following lists what each Reason ID Number refers to:</p> <ul style="list-style-type: none"> •0 = Box Running •1 = No Reason •2 = Thread Break •3 = Needle Break •4 = Design Change •6 = Bobbin Change •7 = Load Frames •13 = Shift Change •28 = Box Off •-1 = All Reasons •90 = No Data •29 = Passport Off •30 = Passport Start •31 = Sewout End •32 = Null Sewout End •33 = Machine Error Code •34 = Stop Switch •35 = Emergency Stop •36 = Frame Stepping •90 = No Data
<p>Note: The No Reason code is caused by: user stops, frame out and communications, system or machine failures.</p>	
Head #	The number of machine needle heads running during the activity.
Date	The date the activity started.
Time	The time the activity started.
End Date	The date the activity ended.
End Time	The time the activity ended.
Duration	The total time span of the activity.
Design	The name of the design.
<p>Note: The name of the design will be for the last design sent to the machine. You should always associate your designs.</p>	

Column Heading	What it means
Stitches (all heads)	<p>The accumulated number of stitches sewn for a specific design. This number depends on whether the box is Stopped or Running.</p> <ul style="list-style-type: none"> - A box that is Stopped records the total number of stitches sewn for the design so far. - A box that is Running records the number of stitches sewn for the specific time interval. <p>The bracketed number (all heads) is the stitch count for all heads sewing out the design.</p>
<p>Note: If one head from a group of running heads stops sewing the design, the All Heads number will continue to count the number of stitches sewn for the specified head. This All Heads number will include the stopped head's partial stitch count in its total as well.</p> <p>For example, an activity database entry of 2766 (3000) means that Design A has 2766 stitches and is sewing out on two heads. One of these heads stopped running after sewing 234 stitches for Design A. This stopped head made the total stitches sewn out, by all heads, increase to 3000 stitches.</p>	
Total (all heads)	<p>The total number of stitches in the associated design.</p> <p>The bracketed number (all heads) is the total number of stitches in the design multiplied by the number of running machine heads. This value only changes when you change the associated design, unless the stitches already sewn exceeds this value. If so, the value should change to match the current stitch count.</p>
<p>Note: If you do not associate the design, this value will not be reported correctly.</p>	
Operator	The Operator's number.
Heads	Number of heads running on the machine.

Viewing Summary Report Data

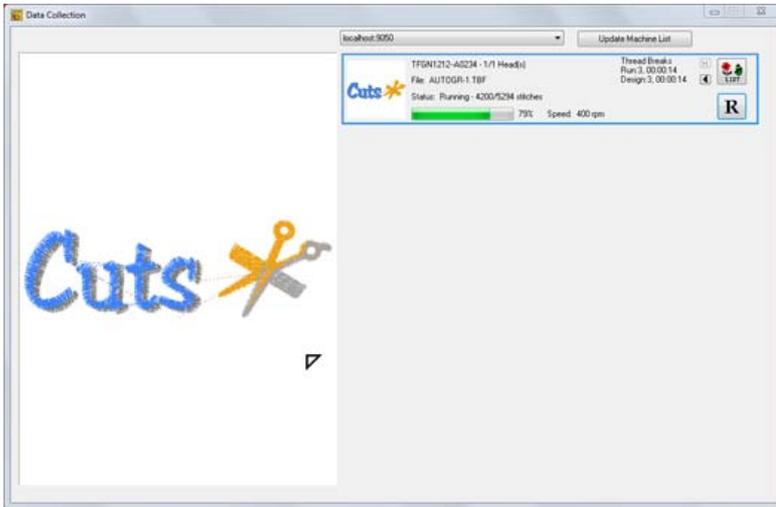
You can view a summary of the data that has been collected.



If Data Collection is disabled, you will only retrieve previous summary report information. To view updated report information, you must first enable Data Collection. Click the Spooler Settings button, and select the local spooler as your design spooler host. From the Data Collection Database box, browse to the location where reporting data is created.

To view a summary

- 1 On the Output tab, click Machine Status.
You see the Data Collection dialog.



- 2 To view reports for one embroidery machine, select an embroidery machine. To view reports for multiple embroidery machines on a design spooler, select a design spooler.
- 3 Click View.
You see the View Report dialog.

View Report ✖

Report Type

View Activity Database
 View Summary Report

Select Timeframe

Start: Date: Friday, October 18, 2013 Time: 2:58:29 PM
 End: Date: Friday, October 18, 2013 Time: 2:58:29 PM

- 4 In the Report Type area, select View Summary Report.
- 5 In the Select Timeframe area, select the Start or End time periods for the summary you want to view.



If you do not select the start and end time, the entire time frame will be displayed.

- 6 Click View.

You see your report. The summary report lets you see the number of heads, total down time, total running time, the ignored time where no data was received, the efficiency total number of stitches, the effective and actual machine speed, the total number of stitches and the total number of pieces.

Headline	# of Pieces	Production	Plan Type	Ignored Time	# of Stitches	# of Pieces	Running Speed (st/heads)	Total Count of Heads	Speed / Length	# of Pieces
7 Lateral Heads 3	8	0:00:04.43:00	0:00:00:21:14	0:00:00:20:32	1.00	20:45:21:20:00	102 (2517)	15 (115.51)	365	4
7 Lateral Heads 4	4	0:00:20:57:36	0:00:00:50:15	0:00:00:02:26	3.84	08:07:17:04:30	773 (2676)	26 (2118.09)	773	4
7 Lateral Heads 5	8	0:00:21:01:10	0:00:00:48:00	0:00:00:04:12	2.00	02:03:16:04:30	522 (2616)	24 (942.62)	522	4
7 Lateral Heads 6	8	0:00:24:03:00	0:00:00:39:46	0:00:00:01:01	2.00	07:08:22:36:30	848 (2643)	30 (4172.75)	848	4
7 Lateral Heads 7	4	0:00:04:03:00	0:00:00:03:40	0:00:00:01:50	2.01	4:04:14:30	344 (2668)	16 (4118.09)	344	4

Understanding the Summary Report Data

To understand the information shown in the summary of report data, you should know what each of the column headings mean.

Column Heading	What it means
Machine	The machine name.
# of Heads	The number of heads running on the machine.
Downtime	The length of time the specified machine stopped running (excluding ignore time).
Run Time	The length of time the specified machine was running.
Ignore Time	The total length of time the following reason codes occurred on the machine: <ul style="list-style-type: none"> • Maintenance (11) • Box Off (28) • Passport Off (29) • Null Sewout End (32) • Sewout End (31)
Note: Sewout End codes will only be added to the ignore time when no stitches are sewn following the previous Sewout End.	
Effcy. (%)	The percentage of time the machine was running. Effcy. (%) = Run Time/(Run Time + Downtime)
# of Stitches (all heads)	The accumulated number of stitches sewn from the head. The bracketed number (all heads) is the stitch count from all heads sewing out designs.
Note: If one head from a group of running heads stops sewing, the All Heads number will continue to count the number of stitches sewn from the specified head. This All Heads number will include the stopped head's partial stitch count in its total as well.	
For example, an activity database entry of 17858 (19759) means that 17858 stitches were sewn from a single head. 19759 stitches were sewn by all of the heads put together, including the stitch count from any head that stopped while sewing designs.	
Running Speed (all heads)	The number of stitches sewn per minute on one head. The bracketed number (all heads) is the number of stitches sewn per minute on all heads sewing out designs.

Column Heading	What it means
Total Speed (all heads) in stitches per minute	<p>Total speed = Total number of stitches sewn on machine / (Run Time + Down Time)</p> <p>The bracketed number (all heads) is the total speed of all running heads.</p>
<p>Note: The time is listed as mm:ss. For example, 44:55 is 44 minutes and 55 seconds and not 44.55 minutes.</p>	
Speed/Design in stitches per minute	<p>Speed/Design = [# of stitches / # of Pieces] / Time in minutes</p> <p>The average speed taken to sew out a design.</p>
# of Pieces	The number of finished products produced during the specified period.
Thread Breaks	The number of thread breaks on all heads during the specified period.

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