Cut & Sew Files for Poly Twill
Using CorelDraw X3, Roland GX-24 cutter, Pressure Sensitive Poly Twill, & the Design Shop software

Example:
- Player name for the back of a jersey
- 2-color, with .25" of background color all around
- All caps

CorelDraw X3:
- Create your image, text, or whatever will be cut from the twill. For this example we'll use the word "DOHERTY" as if a player name for a jersey.
- Select the font and size for the wording (make sure you have the same font in Design Shop or you will need to convert it to curves). We used the 'Impact' font in this example
- Add a contour with the following settings: 1 color, .25 offset (or whatever you want the outline color to be sized).
- Save the file
- Save again as ver.9 to export to Design Shop
- Send this (ver.X3) to the cutting software

Roland GX-24 Cut Studio:
- Put the interior color of twill on the cutter and set your roll width
- Make sure a 60 degree blade is in place
- Adjust force as needed (ours was set to 110 on this cutter; heat applied vinyl uses a force of 130). Make sure to run a test before actually cutting your text or graphic.
- On screen, highlight the interior part of the graphic; in this case the actual word to be cut. Do not select the outline around it.
- "Cutting" and then select "selection" so that you only cut what is highlighted.
- Swap out the twill for the second, or outline, color
- Un-select the word and select the outline around it.
- "Cutting" and then select "selection" so that only the outline is cut.
- You now have a word in the twill and it's matching outline

Design Shop:
- Import the vector image of your graphic or text
- Right click on the vector fill in the design tree (right side of screen)
- Select "Convert to stitches"
- Make the following selections: Type = walk normal; Include holes = uncheck; color change = checked; delete vector object = uncheck
- Click on 'next' thru the rest of the prompts until done with the design elements
- This will create a walking stitch for help with placement of the twill on the garment. You want the outline to be the exact size of the twill – this will make for easier placement
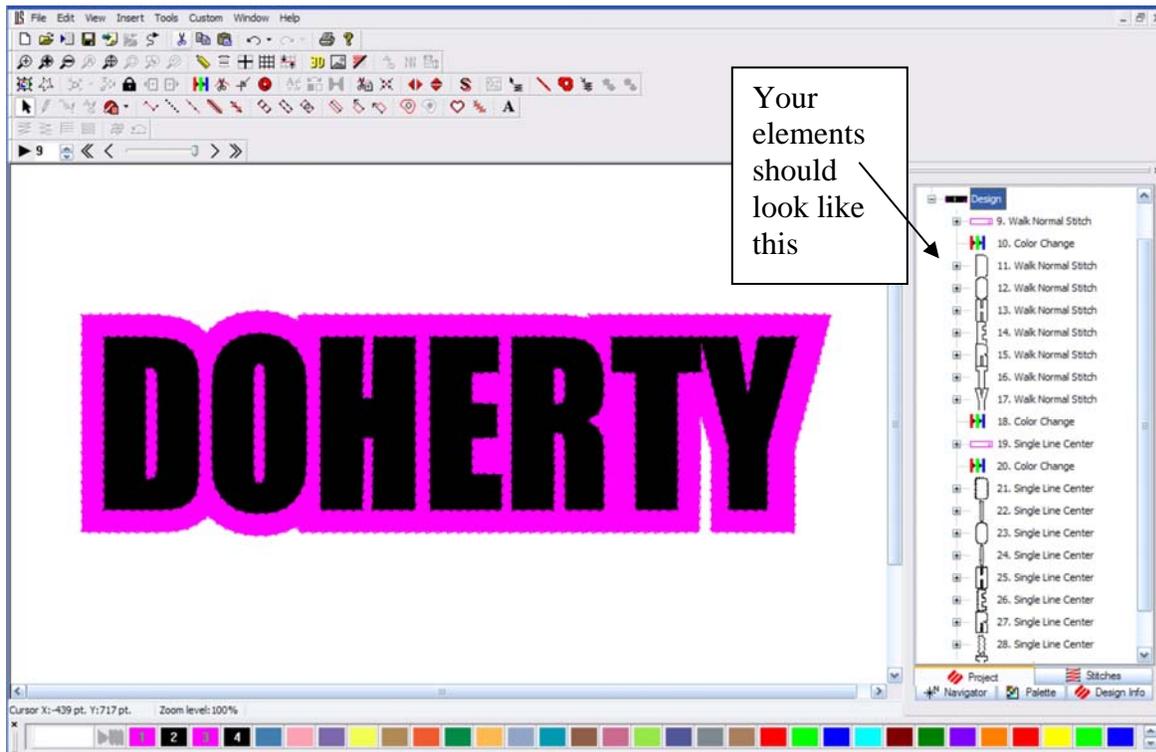
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- Right click on the vector fill in the design tree again
- Select "Convert to stitches"
- Make the following selections: Type = single line; Include holes = check; color change = check; delete vector object = uncheck
- Click on 'next' thru the rest of the prompts until done with the design elements
- Now you have the zig-zag stitch to hold down the twill
- With this done, it's now time to rearrange the elements so they stitch in the correct order with the twill.
- Move the 'single line center' for the outline stitch up the tree so it is the first element to stitch after your color change following the 'walk normal' for the outline.
- Delete the extra color change in the middle of the tree (deleting the second of those two works best)

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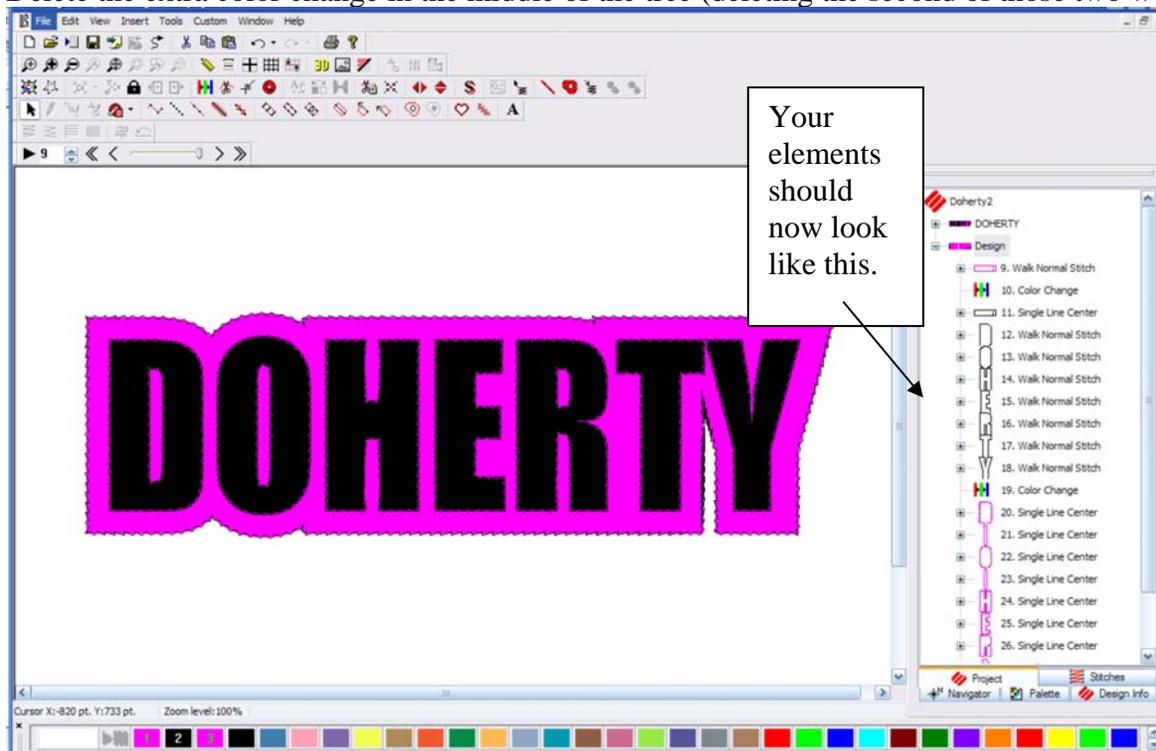
- After the first color change, you will be stitching the 'single line center' stitching to tack down the background layer of twill, then it will proceed to the outline stitching for positioning each letter.
- Now spend some time cleaning up the zig-zag tack downs
- Right click on each 'single line' element and use the following properties: Density = 30; Singleline Width = 35; select "Custom" and use 10% left and 90% right. This will help ensure that the zig-zag stays on the twill more accurately.

Settings for the zig-zag tack down stitching around each letter, and around the background.

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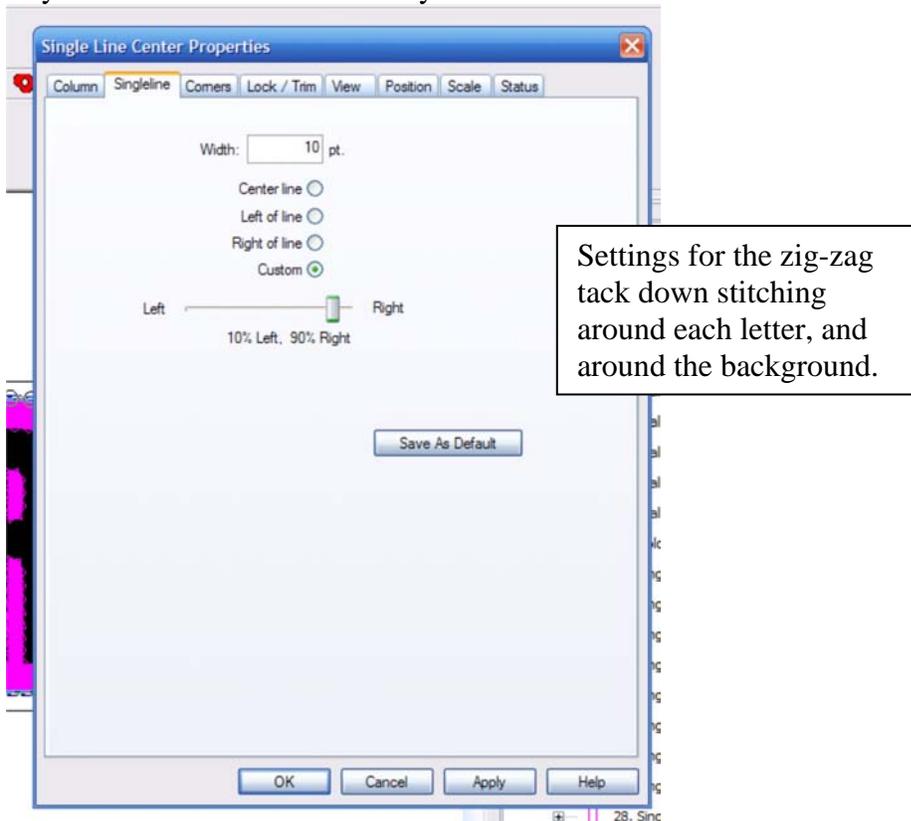
Each time the machine stops for a color change, it allows you to place the twill in position before continuing. Be sure to program a "PAUSE" as the first color selection in Amaya OS so that the machine will stop with each color change.

This is a quick run-through of how we worked the tackle twill cut and sew files. Please call if it seems we omitted any steps in our notes.

Janet / Fabrications
Please call with questions; 269-273-8495