

Carl

ZSK STICKMASCHINEN Customer Magazine

Autumn 2020 - N°3

The ZSK Embroidery Technology Magazine

Embroidery | News | Technology | People | Trends | ZSK Worldwide





Embroidery in the times of Covid-19

Covid-19 has unexpectedly overrun us all. While the virus was still far away in China at the turn of the year, it came to Europe and thus also to Germany with unexpected speed and intensity.

After the initial state of pure uncertainty and weeks in which we followed the figures of the RKI Institute (Robert-Koch-Institute), the measures of the Federal Government gradually came into effect. From week to week, from day to day, our everyday life and work life then changed - right up to an almost complete lock-down.

Understandably, this created a kind of shock-induced paralysis in many people. But it is gratifying to see that many of our customers in the embroidery industry have gone through this phase by own power with a great deal of creativity, flexibility and commitment. Those who could have converted their production lines to mask production, thus helping to secure urgently needed supplies and safeguard jobs. During this time, ZSK also used all available demonstration machines for mask production and created nice designs with the active support of the entire team.

On the way back to a "new normality", we had also planned our popular ZSK Open House in September 2020 to present our innovations in embroidery machines. However, due to the continuing uncertainty and for the protection of all those involved, we finally decided to cancel the on-site event this year. Instead, we will present our innovations digitally, so that you will neither have to travel nor take a contact risk to stay up-to-date.

Over the next few weeks, follow us on our digital channels, our website, our Facebook and YouTube channels, and especially the following versions of our customer magazine CARL. In this issue, we focus on more general topics, in the following edition you can expect more of our technical innovations from the ZSK portfolio.

We hope you enjoy reading CARL and invite you to visit us digitally on our other channels. Of course we are also available for personal discussions.

Stay healthy!

Sincerely Yours

Carl

36 Trends in Fashion

It's all about contrasts - the radical changes in politics and society are also influencing the textile and garment sector.



42 ZSK - FOR A LIFETIME?!

When I asked Walter Biegelbauer for an interview in May 2020, he answered: "An interview about my life at ZSK? We'll be finished in two minutes." Well, it wasn't quite like that after all ...

48 T8 CONTROL UNIT MORE BARCODES

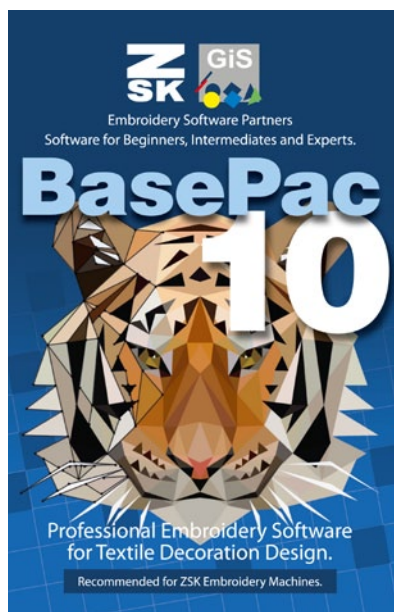
Barcodes to load designs - we have extended this method with additional barcodes.

50 BASEPAC 10 TUTORIAL CREATE A SEQUIN DESIGN

ZSK digitizing expert Britta Sanders explains what to do to digitize with sequins.

Editorial	2
BasePac 10 - 64Bit version available.....	4
QR Code - Useful strange pattern.....	4
eLace Embroidery.....	5
Review texprocess / techtextil.....	6
ITMA 2019.....	10
History in Fashion	12
Crafting Smart Textiles.....	15
Embroidering textiles with Braille	18
Leather upholstery	22
Trends in fashion embroidery.....	28
Uniform accessories	32
Quilting thick yarn	36
Jubilee - 50 years in profession	40
Online Platform - ZSK Digitizing Academy	40

Competition - Economy in transition.....	41
SPRINT - Quick Change system	41
ZSK – For a lifetime?!.....	42
T8 - More Barcodes to load designs	48
BasePac 10 - How to create a sequin design	50
Vitordigitizing - Step by step HAC design	52
BasePac 10 - Quicktext with Head Selection	55
EPCwin 7 - How to create a bead design	56
Service Tool I - Maintenance tool	59
Service Tool II - T8 remote control.....	59
Pier Paolo Scotti.....	60
SPRINT - New magnetic belt frame	66
400 / 495 Arm Spacing - Dual Orientation hoop	66
Legals.....	67



BasePac 10

64-Bit version available

Starting with the new version 10.08, BasePac is available in both 32-bit and 64-bit versions for computers with the corresponding Windows operating system. According to the BasePac developers, the new 64-bit version now performs the stitch calculation on a 64-bit computer almost twice as fast.

After the update to 10.08 and the restart, there is an indication for another update with suitable 64-bit computers; this concerns the 64-bit version. For 32-bit computers, the update is not offered and would not install. ■

Update: bit.ly/BasePac

QR Code

Useful strange pattern

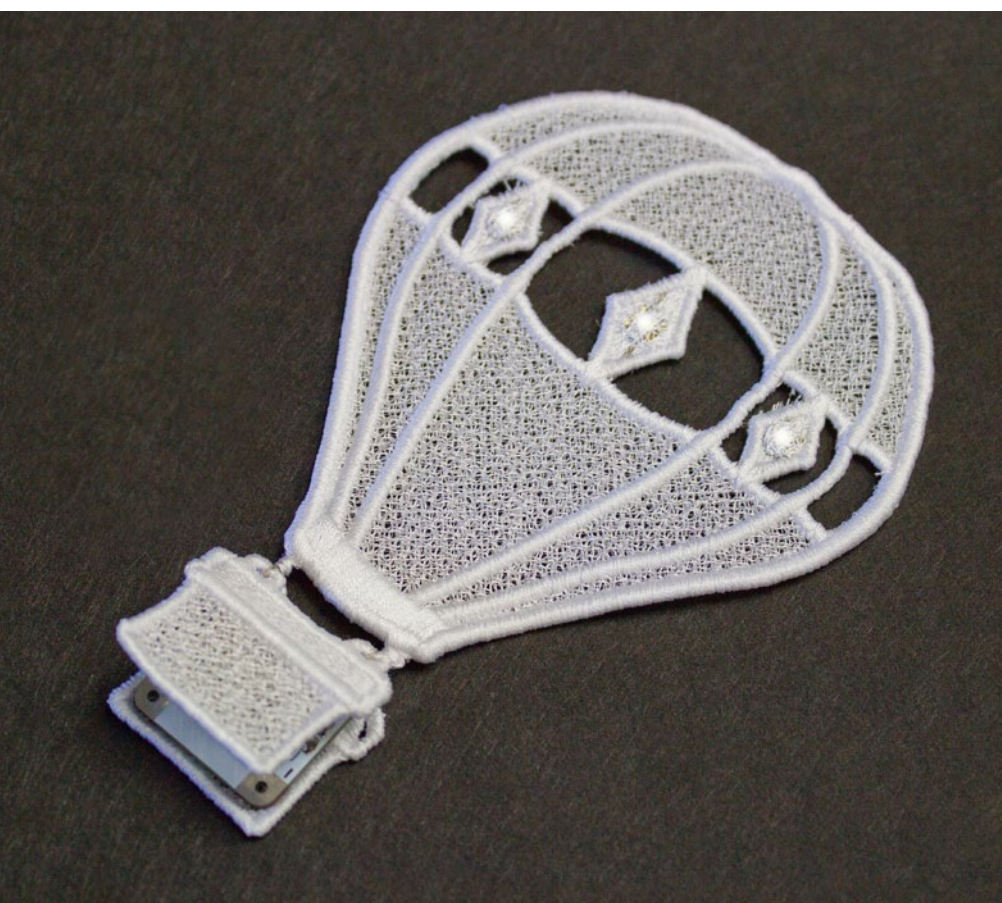


QR codes have become a very useful tool in sharing information and resources very quickly.

This can come in handy during trade shows, meetings, or networking.

F-head embroidery has the ability to quickly and cleanly add QR codes to materials while providing options for scaling and adjustments. This technique can be easily applied to things like tablecloths, samples, or handouts. ■

eLace Embroidery

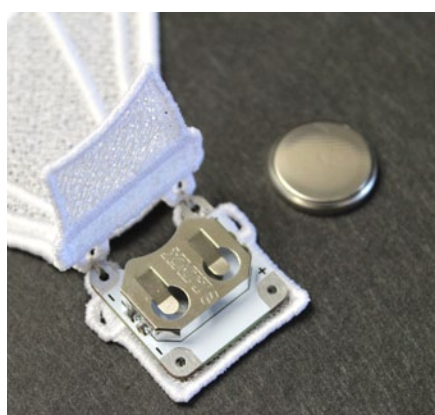


Combining ZSK's technology for accurate LED sequin placement, conductive thread, and free-standing lace techniques.

Embroidery machines, used with dissolvable backing material, have the ability to create free-standing lace. Often seen as a decorative piece, these lace products can now include lights or sensors by integrating sequins and conductive thread in a fully automatic process.

The conductive thread is easily hidden within design elements of the piece and connect directly to the battery carrier (here provided by Teknikio). Thread tension, small stitch distances, and layering all play a part in creating a piece that is stiff enough to hold its shape and pattern once the backing is dissolved away.

This technique creates opportunity in taking something that has been seen as purely decorative for centuries and adds the possibility of blending it with function. ■



Contact Details

ZSK Research and Training Center

990 Industry Drive
Tukwila, WA 98188
USA



Review

texprocess / techtextil

At texprocess 2019 in Frankfurt / Main, Germany, ZSK Stickmaschinen presented the complete range of its SPRINT 7 Series.

The SPRINT 7 Series machines come with 18 needles, servo drives, an increased efficiency compared to the SPRINT 6 Series, a Home Function (return to centre position after each job) and the capability to save the design starting point. The 7L (400mm x 600mm) and 7XL (400mm x 1.400mm) equipped with drive systems located on the upper part of the machine body.

As the models are without sidewalls they enable embroidery of extra wide products. The size of the embroidery

field sets a new standard for compact single head embroidery machines.

A highlight at ZSK Stickmaschinen was the latest ZSK Bead Device that can embroider glass beads from 2.0-3.0mm in diameter and 1.5-1.8mm in height. The ZSK Bead Device handles flat and curve shaped beads and does not require any plastic rolls. The beads can be directly filled into the device, which allows working with a variety of bead manufacturers.

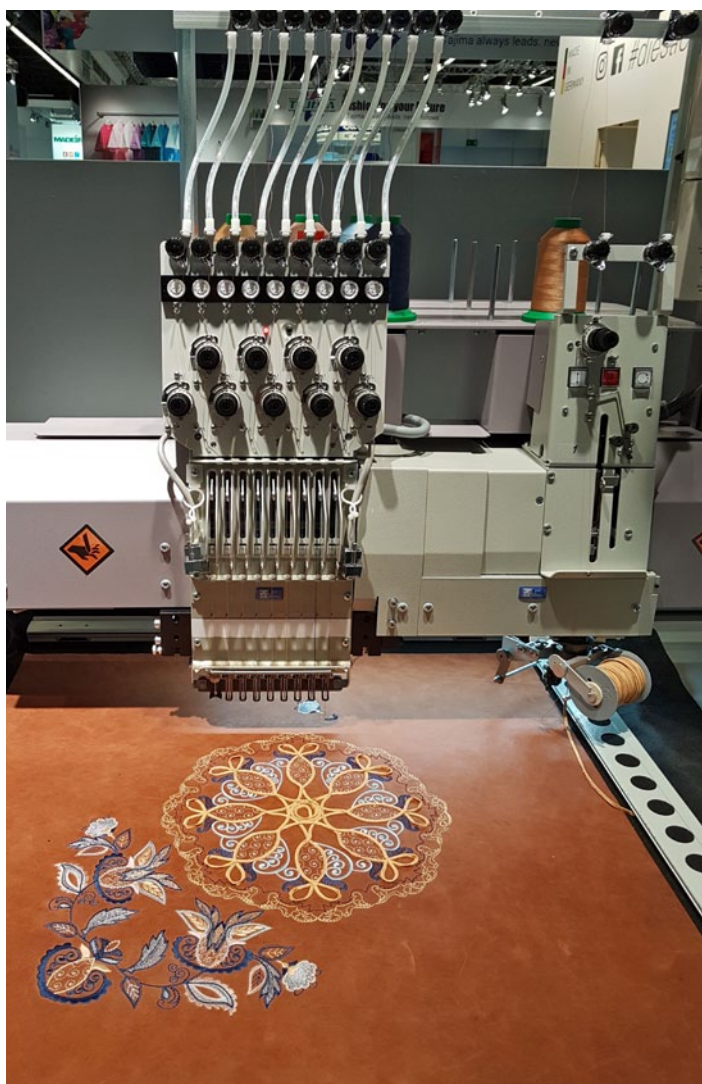


New model SPRINT 7

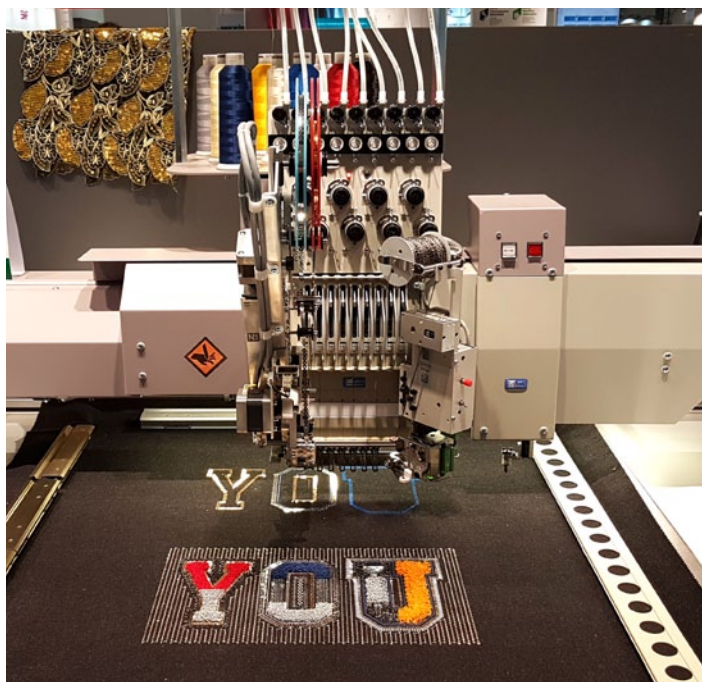
ZSK new Bead Device on SPRINT 7XL

Texprocess was combined with techtextil 2019, where ZSK was showcasing in parallel its technical embroidery systems. On a JGVA 0109-550-700 technical embroidery machine, we were producing a smart memory game and also demonstrating fast laying of carbon fiber with a special new technique called HV-TFP for high volume Tailored Fiber Placement. This new technique has been developed in cooperation with Nobrak France, and was first introduced at JEC Paris in March 2019.

HV-TFP technology, is laying down two or more rovings simultaneously. With the same number of stitches, we are now laying double or more number of rovings. The new functionality can be combined with other ZSK options like "fast fiber laying" thus leading to a considerable increase in productivity. HV-TFP is available exclusively on ZSK Technical Embroidery Systems.



Leather embroidery on a ZSK combination machine



JCHA 0109-550 combination machine with sequin and cording device

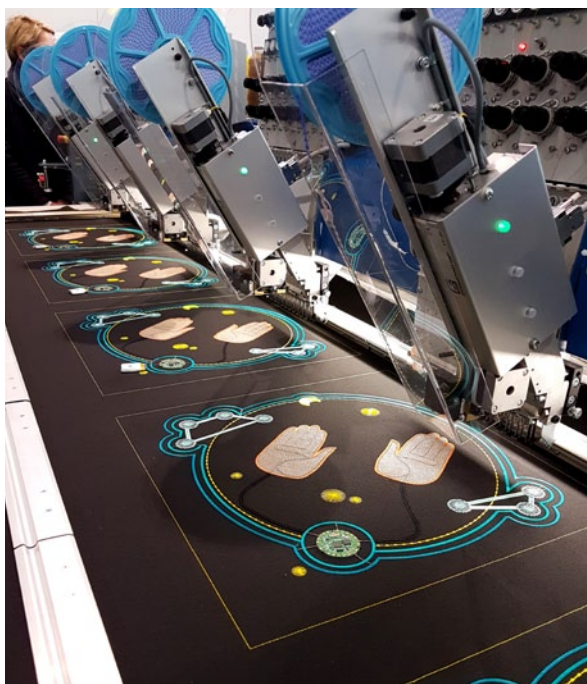
Apart from these two stands, ZSK was also participating in two special show events, the so-called microfactories. One of these was organised by RWTH Aachen and demonstrated serial production of smart textiles.

ZSK was showing conductive yarn embroidery and its applications. Applications such as textile touch and capacity sensors, conductive paths and pads were presented as well as the electrical connection of LED sequins and electronic boards on a ZSK RACER 6 W embroidery machine.

The other micro factory was organised by company Ring Maschinenbau and focusing on leather perforation.

ZSK was showing embroidery and quilting on leather with its Racer 1 XL and with the ZSK Vision System (camera-based system) for single head embroidery machines.

This system allows to overcome different tolerances and achieves perfect results. The camera system has been specially developed to meet tolerances of approx. ± 0.3 mm, as these are unique for each part. Quilting, embroidery and cut, perforation and lamination can be easily combined in one design.



ZSK production at Smart Textiles Micro Factory

Texprocess and techtextil are still among the most important places to present ZSK embroidery machines and solutions. The combination of both shows and the easy access for visitors from one show to the other is a good solution. We are happy with the good response from customers as well as from new national and international contacts. The event was one of our show highlights in 2019.

HIGHLIGHT ZSK FAMILY DINNER

It is already a tradition to have a "ZSK Family Show Dinner" during the big shows which is meant to be a meeting and networking point for ZSK and its partners and customers from all over the world.

This time we could welcome more than 50 international partners and customers from more than 20 countries relaxing after the show with regional specialties like Apfelwein (Äppelwoi) and delicate international menus.



RACER 1XL with ZSK Vision System



After show relax zone at the "ZSK Family Show Dinner"

Contact Details

ZSK STICKMASCHINEN

Your Contact:

Mrs. Ute von Cranach
email: ute.voncranach@zsk.de



ITMA 2019

ITMA, a show highlight every four years and held in Barcelona from 20.-26. June 2019, attracted over 105,000 visitors from 137 countries.

AT ITMA, ZSK was supported by its Spanish partner VAM while organizing the show, set up and tear down of the booth, and particularly during all the show days. The cooperation was a great pleasure for the whole ZSK show team from Krefeld, and ZSK wants to thank the VAM team again for their hard work and great job done.

In the ZSK booth, technical innovations both from its standard machine portfolio and its technical embroidery systems were shown. SPRINT and RACER models represented the ZSK tubular machine portfolio. Highlights for technical embroidery applications were a flatbed CHALLENGER and a JGVA 0109 - 550 triple combination machine.



ZSK technical embroidery system JGVA 0109 - 550



The ZSK and VAM exhibition team: Well done!

A novelty was also the ZSK Bead Device shown on a SPRINT 7 XL machine with an extra large embroidery field. The ZSK Bead Device processes glass beads from 2.0-3.0 mm in diameter and 1.5-1.8mm in height, and can handle flat and curve shaped beads.

A technical embroidery machine, JGVA 0109-550 with three different embroidery heads, a standard F-head, a W-head (cording, coiling, taping) and a K-head (chain and moss stitch) showed the efficient placing of fibers by HV-TFP (High Volume-Tailored Fiber Placement), and the placing of LEDs and electronics.



Rooftop terrace of "Happy Rock Bar & Grill"

"ITMA is still the place to go and highlight every four years for us, again with an overwhelming international flair. ITMA is an excellent opportunity to meet our customers from all over the world, and to connect with many more new companies from the textile and embroidery world.

The fair was an excellent place to showcase new ZSK products and solutions, like our bead device and our innovative solutions in the field of technical embroidery where we can state a fast growing interest."

Julius Sobizack, CEO ZSK STICKMASCHINEN

The ZSK "Vision System" was presented on a ZSK RACER 1XL embroidery machine. The camera-based system continuously monitors the location of perforation, elements or colour changes. The system places and adjusts the embroidery design to perfectly fit possible shrinkage or elongation of the material. With the Auto Select Bobbin Changer which is a unique ZSK feature, the machine is able to match needles with bobbins. This way sewing yarn can be matched with thick bobbin yarns or colours of upper yarn, and bobbin yarn can be matched.



The place to be: ITMA Barcelona!

HIGHLIGHT "ZSK FAMILY SHOW EVENING"

On Monday evening, ZSK invited to its traditional "ZSK Family Show Evening" where more than 50 ZSK partners and customers from all over the world met with the ZSK team from Krefeld.

The event location, the „Happy Rock Bar & Grill“ in shopping centre Las Arenas was a good suggestion again from VAM. It was a perfect spot as it was offering easy access from the showground, excellent food and drinks and finally a fantastic view from its rooftop terrace.

Contact Details

ZSK STICKMASCHINEN

Your Contact:

Mrs. Ute von Cranach
email: ute.voncranach@zsk.de



Grassi Museum of Applied Arts, Leipzig
21.11.2019 – 20.09.2020

Embroidery Exhibition

“History in Fashion”

by Reiner Knochel for Gunold, March 2020

The renowned Grassi Museum of Applied Arts in Leipzig/Germany hosted a very special embroidery exhibition from November 2019 till September 2020.

Perfectly curated by Dr. Stefanie Seeberg, the museum presented around 130 historical objects, most of them from the museum's own collection and presented to the public for the first time.

There were fragments shown from ancient Egyptian grave goods as well as hand embroideries from the Middle Ages, the Baroque times and the “Roaring Twenties”. Interesting to see how the curator also included contemporary exhibits in each of the themed rooms. For example pieces from current collections of famous fashion brands demonstrated how historic embroidery inspired today's designers.

Left: embroidered robe,
Germany, approx. 1925
Photo: Esther Hoyer

Another room showed a black robe from 1900, hand embroidered with pearls and sequins to create a luxury starry sky look. Next to it the modern version of it, presenting a robe by Swiss couture label Akris making the robe glow with embroidered LED lamps.

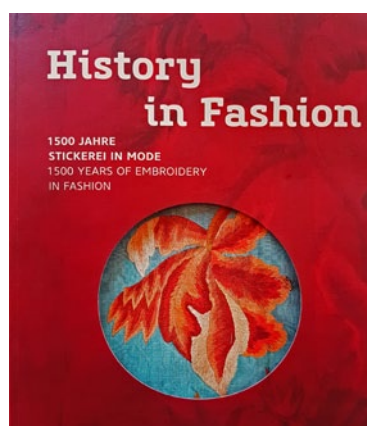
While most of the exhibition rooms were rather dark to protect the sensitive old threads and fabrics from too much light, the last room was light-flooded and open, offering a great view also to the museum's garden. Here in the "Orangerie", nine textile design students from Burg Giebichenstein's Academy of Fine Arts in Halle/Germany presented their visions of contemporary embroidery. A very special challenge for the students, guided by Professor Bettina Göttke-Krogmann who introduced different hand and machine embroidery techniques to the young creatives. The project was generously supported by ZSK, providing a Sprint XL machine and by Gunold embroidery threads and backings, enabling the talented designers to realize their ideas.

Another ZSK machine was provided for the duration of the exhibition. Weekly workshops were organized and guided by Magdalena Orland, M.A. at the textile faculty of Burg Giebichenstein Halle, who provided insights both in machine and hand embroidery.

There is a catalogue available with lots of high quality photos, explanations and illustrations of all exhibits (available in German language only...): <http://bit.ly/HistoryInFashion> ■



Big interest in the ZSK machine presented in the embroidery exhibition. Photo: Esther Hoyer



Exhibition Catalog "History in Fashion" published by Grassi Museum für Angewandte Kunst Leipzig



Embroidered gloves, Germany, 18th Century
Photo: Esther Hoyer

The exhibition has been extended until September 20, 2020.

More info at : www.grassimak.de

Contact Info

Reiner Knochel

www.reiner-knochel.com

E-Mail: mail@reiner-knochel.com

GUNOLD® 

www.gunold.de

E-Mail: service@gunold.de





Kerrie Masone
Senior Researcher at Material ConneXion

Crafting Smart Textiles

Material ConneXion, the leading materials-driven design authority, provides perspective on embroidering electronics into the next generation of 'smart' fabrics and blurring the boundaries between technology and craft.

Machines are slowly weaving into every aspect of our lives, from how we communicate to how we work. Still, consumers and our clients are hungry for craft. At Material ConneXion, we believe the current interest in craft and handmade things is a direct reaction to the digital age. The less natural and physical items in our day-to-day life, the more we crave a reversion to their tangible artisanship.

Computational technology has been integral to the information, communication and entertainment industries for decades, and, increasingly, computers operate our homes and cars. While technology touches almost every aspect of our lives, the clothes we wear stand out as one of the most promising and least explored frontiers for information technology, offering countless applications in healthcare, sports, and well-being.

With technical complexity creating visual simplicity, it is easy to find smart textiles as more familiar than foreign, and more low-tech than high-res, making them a great medium for special effects. Smart textiles, and in particular those created with technical embroidery, combine age-old processes with cutting edge advances. It is a field that creates opportunities to work across craft and computation to create textiles that look and feel like fabrics while also functioning as sensors and actuators.

E-textiles are contemporary craft; combining novel materials, tools, and techniques with those traditionally associated with crafts.

Kerrie Masone
Senior Researcher

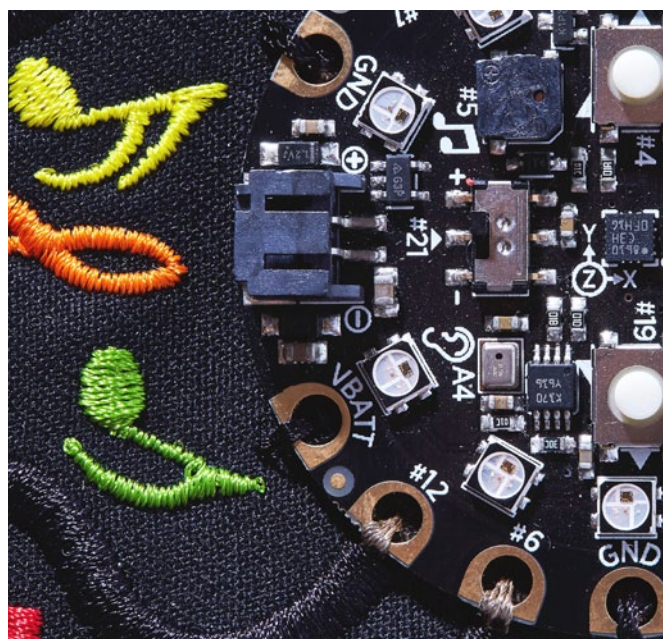
Our clients are looking to solve one of the major challenges of electronic textiles going from niche to mainstream — making the technology invisible before it is useful. It must literally become part of the warp and weft of fabrics, with the circuitry for sensing and actuation indistinguishable from the yarn. To achieve this, they need to make electronics smaller, more flexible, stretchable, and washable. Finding reliable and durable ways of creating electronic textiles is one of the most immediate research goals in their field. Craft, particularly technical embroidery produced, is an important driver of this work, often providing the answer to questions, such as how to keep circuitry closed, or how to maintain aesthetics of conductive fabrics.



Besides the current appetite for the look and feel of craft, there is also a strong desire for personalization. As technology becomes more intimate both in distance to the body and in its ability to act as a conduit for informational and personal identities, materials and more specifically textiles, are increasingly called upon to “perform” via responsive interfaces. The ability of embroidery to disguise and reveal has long been part of its allure, which when combined with technology will become a key element to its future significance. Haptic qualities and personalizing technology are both functions that craft introduces to the smart material design process. While early wearable technologies aimed at finding solutions for how to “wear” computational devices on the body, current design challenges are focused on enhancing social adoption and cultural relevance based on ever-expanding consumer preferences.

E-textiles are contemporary craft; combining novel materials, tools, and techniques with those traditionally associated with crafts. The process of creating functional, reliable and aesthetically pleasing e-textile results is heavily reliant upon the manual skill and technical expertise of the maker. Hand-craft, that knowledge of materials, is incredibly important for the future of design. As technology is further embedded into the varied materials of everyday life, we will need flag bearers who have developed tacit knowledge and relationships with those materials. At the same time, embracing change in the design of systems that produce new technologies will create more opportunities for human engagement and collaboration with fabrication machines.

Within design, the craft, and digital fabrication industries are increasingly collaborating to create innovative new methods of production. Through these collaborations, ways of using smart or electronic textiles, which can sense and react to their environments have made significant advancements — developments that have proven useful not only in the field for which they are intended but across industries. In Material ConneXion’s view, the Old World technique of embroidery is key to the connected and communicative sensory fabrics of the future. ■



About Material ConneXion®

Material ConneXion is the world’s leading design-driven material resource and trusted advisor to Fortune 500 companies. We define “what’s new and what’s next” in materials and incubate new ideas, so brands can make smarter design decisions. Our international network of specialists follows 75+ industry topics to provide a cross-industry perspective on materials, sustainable design, and product development.

Sources

- <https://onlinelibrary.wiley.com/doi/full/10.1002/asi.21136>
- <https://www.colorado.edu/atlas/smart-textiles>
<https://www.colorado.edu/atlas/2018/06/12/weaving-smart-textiles>
- <https://www.wgsn.com/blogs/future-craft-digital-age-re-master-sabina-weiss/>
- <https://www.fastcompany.com/90127475/6-designers-explain-why-craft-still-matters-in-a-digital-world>
- <https://www.detroitnews.com/story/life/home-garden/2018/09/27/art-craft-lives-modern-age/1370176002/>
- <https://www.smithsonianmag.com/innovation/embroidering-electronics-next-generation-smart-fabrics-180968449/>
- <http://www.ijdesign.org/index.php/IJDesign/article/view-File/3177/793>
- <https://medium.com/@jna1x3/smart-textiles-with-block-chain-a-match-made-in-heaven-b268bfca035c>

A photograph of a brown knitted sweater and a white cane with a black tip resting on a light-colored, textured floor. The background is a bright, out-of-focus interior space with white furniture.

BasePac 10 with Braille option

Embroidering Textiles with Braille

BasePac 10 with the optional Braille extension offers a special patented embroidery technique with which all textiles can be embroidered with Braille characters. Compared with the usual embroidery techniques, the necessary convexity is brought about to guarantee the legibility of the individual dots of the Braille printing.

Essential information whether initials for the identification of class uniforms, colour indications or care instructions can be embroidered onto all textiles. The embroidered guidance hardly modifies the fabric and neither reduces wear comfort nor care.





Color information in Braille embroidered in textiles

Braille for textiles

Visually impaired people are facing a lot of problems. To manage these difficulties, they always need innovative ideas to alleviate their everyday routine. With a new, patented procedure, texts and symbols are embroiderable in Braille by ZSK embroidery machines. That will simplify orientation in the daily-life of many blind people.

Choosing clothes is important for many blind persons. They see less to nothing, but they are seen remarkably well in most cases. Therefore, it is important, to be able to trust in their outfit. They need assistance with the choice of their apparel. Embroidered indications enable blind people to

handle this situation on their own. They do not need any longer inaccurate and expensive technical devices, like color or barcode scanners. Non-textile differentiators, like metal- or plastic-sheets become dispensable. They limit wear comfort and care of the garments and there is always a risk of damaging the textiles with foreign materials in the washer or drier.

Embroidered Braille as a mass-product

Embroidering Braille industrially has often been tried without success. The problem: the pillar fabric were destroyed while embroidering.

Today's procedure preserves the textile, and actually the dots are still readable after accidental over-ironing. A convexity of 0.4mm guarantees the readability.

The method to embroider Braille industrially opens a lot of new opportunities. Formerly single garments had to be embroidered with high effort e.g. to help blind children distinguishing their clothes.

Now, everyone has the chance to embroider textiles with Braille in high or low quantities with only little effort. It also creates new opportunities for designers, who can design individual clothing especially for blind people.



Information on a hotel towel embroidered in Braille



T8 screen while processing Braille

Textiles, like garments, beddings, towels or bags are marked and individualized for many different reasons and sectors. Among these are sports clothes or workwear, or catering and hotel industry.

Another possible area of use for embroidered Braille is the production of promotion material, particularly for blind people.

Freedom from barriers

Applying differentiators or care instructions to textiles offers a lot of opportunities to simplify the daily work and leisure of blind people. The enhanced self-determination improves the accessibility to public life, too. This fulfills the demands of various UN and EU resolutions and laws and leads to a higher quality of life for visually impaired people.

What you need to embroider Braille

Braille Font is an optional extension for BasePac 10. The option can already be added starting from the package BASE.

The option uses a patented embroidery technique and is exclusively available for ZSK embroidery machines.

You do not need to be familiar with Braille to translate text - BasePac does this for you. The option is easy to understand and use.

Necessary requirements to embroider Braille:

Base Pac 10 BASE Item No.: 945.500

Braille font option Item No.: 945.437


A network connection between BasePac and the ZSK embroidery machine

Contact Details

ZSK STICKMASCHINEN

email: software@zsk.de





EXCLUSIVE EMBROIDERY **LEATHER** **UPHOLSTERY** FOR DEMANDING INDIVIDUALISTS

Rühl Leder, a long-established company based in Mülheim an der Ruhr, Germany has been one of ZSK STICKMASCHINEN's customers since mid 2018. In the day-to-day work, Rühl Leder is using several types of ZSK embroidery machines to process different car and motorhome parts. For this purpose, each machine has been designed with the appropriate special equipment like the ZSK leather set-up. Apart from the machines, Rühl Leder is using the BasePac Premium punch program from ZSK STICKMASCHINEN to design individual embroidery files.



While talking to Stephan Rühl (Managing Director) we learn more about the history of the company. In 1890, Friedrich Wilhelm Rühl founded a leather tannery called FW Rühl Lederfabrik KG in Mülheim a.d. Ruhr. Nowadays, the family business is run by Stephan Rühl who offers exclusive leather interior for cars since 2000, and same for motorhomes since 2006.

In mid 2018, Rühl invested in ZSK embroidery machines so that they can now also realize individual embroidery in the vehicle interior, e.g. on seats, armrests, headrests, shifters and steering wheels. Apart from passenger cars and motorhomes, the company also handles antique furniture, couches, armchairs and unusual items such as exclusive violin cases.

STEPHAN RÜHL - THE LEATHER EXPERT

Stephan Rühl is closely connected to the material leather due to the fact that he virtually grew up with the product. Already at the age of 6, he was often in the family-owned tannery and has helped here and there. This has given rise to his lifelong leather passion, which has accompanied him

on his various career stages in Italy and the USA. Back in Germany, he turned the former parental tannery into a successful leather equipment company - with new product portfolio, high-quality materials, modern machinery outfit like ZSK embroidery machines, first-class processed products and a dedicated and talented team.



RÜHL LEDER - PRODUCT PORTFOLIO

Focus of the company's portfolio nowadays is motorhomes and automobiles, offering exclusive unique items as well as small and medium series up to 2,000 pieces p.a. The equipment of ships, hotels, restaurants and cafés represent another business area within the Rühl Leder portfolio.

Rühl is working with its own special "motorhome leather" which is available in 18 colors. Apart from this, the company also offers a top exclusive leather type "water buffalo" in a variety of 5 colors.

The quality of the leather as well as gentle workmanship are rated very high at Rühl Leder. Through elaborate special treatments, Rühl's special motorhome leather achieves its extremely high resistance to light and color fastness thus complying with the automotive DIN standard. The motorhome leather by Rühl is much softer than other types of leather and very comfortable due to its high breathability regardless of season. The advantages of the water buffalo leather are particularly pleasant surface feel as well as extremely high breathability.

A SUCCESSFUL CONCEPT

Stephan Rühl explains what is his individual concept and why it is so successful. Obviously it is his combination of "highest quality" and "best possible customer service". By combining "best leather + lamination + design + associated fixings" Rühl achieves highest quality. And secondly, he is putting much effort and a lot of time in personal customer consulting. While talking to his customers, he also presents the manifold possibilities of individual embroidery on leather, in order to find the perfectly fitting individual designs together with his customers.

"Even after 5 years, I want my customer to be happy with the product that I have sold him, and the product must still look new," sums up Stephan Rühl.

THE DECISION FOR ZSK EMBROIDERY MACHINES

Previously, jobs like punching and embroidery were outsourced by Rühl, which in the long run turned out to be difficult and time-consuming. Thus in 2018, the decision was made to purchase punch software and embroidery machines for these jobs. Upfront, Rühl's employees did some research to find suitable embroidery machines and equipment, and finally suggested the ZSK machines and software to Stephan Rühl.

After discussions in Krefeld during which Stephan Rühl and his partner Burhan Karpuz were able to clarify the points that mattered to them, they too were convinced and the machines could be configured with the appropriate special features.

First of all, he was looking for a machine suitable to embroider logos on small parts such as headrests. For this purpose, a SPRINT 6 from the proven SPRINT series was selected and equipped with the ZSK leather set-up which allows to combine thin and thick yarns on one machine, and to process both in one pattern. This type of machine takes up little space, is robust and very user-friendly, making it particularly suitable for beginners.

With the ZSK SPRINT embroidery machine, the first samples were embroidered, and sample parts made for the Caravan Salon 2019 in Düsseldorf. At the fair, the patterns with the individual embroidery were so well received by the audience that Rühl booked orders for more than 150 cars there.

Next he wanted to extend his work on backseats and headliners, which required a machine with a particularly large embroidery field. Motorhomes require an embroidery field of at least 80 to 100 cm or even up to 130 cm. Due to its extra wide embroidery field, a CHALLENGER machine was chosen for this purpose.

We could not offer this combination and this degree of individualization without the embroidery machines from ZSK STICKMASCHINEN.

Stephan Rühl



The decision for the CHALLENGER fell quickly. "The overall width is the most important and critical factor, and that's exclusively available from ZSK STICKMASCHINEN," Rühl explains his decision. In addition, the machine is equipped with an automatic selective bobbin changer, which first of all allows to work with sewing and embroidery threads on one single machine. Second, with ZSK's selective bobbin changer, the different bobbin threads are automatically assigned correctly.

Finally, another topic was the embroidery of the car side parts. Together with ZSK STICKMASCHINEN, a machine was configured precisely for this purpose: a RACER 2XL equipped with the ZSK leather set-up, 2 heads and 24 needles for a large variety of colors.





TIME FOR LEGENDS

TRADITION AND PROGRESS SINCE 1925

MADE
IN
GERMANY



Laco
1925

There are pilot watches - and there are pilot watches from Laco. The German company is proud of its long tradition as an exclusive manufacturer of high-quality timepieces. An indispensable cockpit tool, especially in the 1940s, the modern Laco expresses the wearer's individuality.

A Laco pilot watch is not only a precision, hard-wearing timepiece on your wrist, but also a chapter in contemporary history.

(1) Pilot Watch Original, Westerland Erbstück, 45 mm manual winding
(2) GMT Pilot Watch, Frankfurt Schwarz, 42 mm Automatic (3) Pilot Watch Original, Replika 45, 45 mm manual winding

WWW.LACO.DE | INFO@LACO.DE



According to Stephan Rühl, the customization with embroidery represents an extra value for the creation of unique pieces (cars, vintage cars, motorhomes ...). With the new ZSK machines, Rühl is able to individually embroider leather parts of all shapes and sizes in automotive and motorhome interiors.

And finally with the ZSK BasePac punch software, Rühl is able to create customized embroidery designs in-house, and to quickly change design files if needed.

“Our employees were trained intensively on site by ZSK. The delivery and installation of the machines were timely and without any problems. The ZSK Service assisted us a lot especially during the start-up phase to quickly become familiar with our new segment embroidery.” says Stephan Rühl.

The solid workmanship and the robustness of the ZSK machines convinced the entrepreneur Rühl as much as by the expertise of the ZSK employees. Last but not least, this new additional competence in-house helps him to set up new business segments and to also address other customer groups, which should ultimately increase the business volume.

“Individualism is branded with me, and my goal is to design my products individually. Meanwhile, I became a real fan of the ZSK embroidery machines and the combination of sewing and embroidery. We could not offer this combination and this degree of individualization without the embroidery machines from ZSK STICKMASCHINEN.”



Contact Info

Rühl Leder GmbH

www.ruehl-leder.de

info@ruehl-leder.de



TRENDS

IN FASHION EMBROIDERY

by Reiner Knochel for Gunold

Embroidered circles using plain and ombré shades from the Sulky viscose range

It's all about contrasts - the radical changes in politics and society are also influencing the textile and garment sector. Digitization is one of the key words and we are constantly surprised by new developments in smart technologies. On the other hand, many consumers are re-thinking their values, they are more informed and more critical which can be seen also in sales figures.

Nowadays, High-Tech materials are affordable for everybody and are fascinating people no matter with gender or generation. At the same time, natural materials are having their come-back and sustainable companies and products are booming.

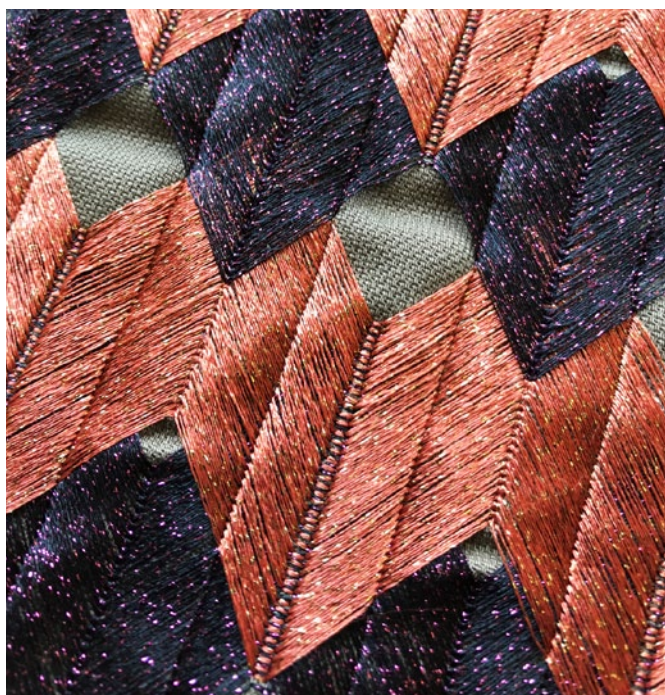


Fig.1: Poly Star thread on cotton fabric

Society's diremption is also pictured in the next season's colour palette; there are loud, bright and intensive colours on one side as well as subtle, natural and earthy tones on the other. Same same with the fabrics: transparent, coated and high-gloss finished materials share the market with matt and structured fabrics made of natural fibres and threads. (Fig. 1 / 2)

The next fashion collections will show lots of voluptuous blossoms. There will be classical flowers like the pansies in Figure 3, embroidered with the COTTY 30 cotton thread as well as exotic and colourful bouquets and flowers using Gunold's rich choice of glossy viscose and special effect threads.

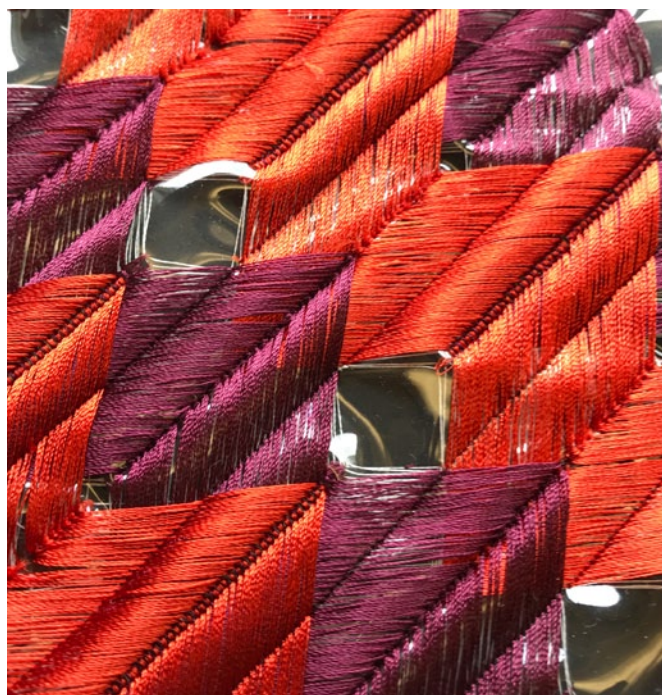


Fig. 2: Poly by Gunold on transparent foil by Sam Fashion Italy



Fig. 3: Pansies, embroidered in cotton thread Cotty



Fig. 4: Poly Star thread on milky foil by Sam Fashion Group Italy



Fig. 5 Multicolour Sulky thread on semi-transparent foil by Frizza Italy



Fig. 6: Glow-in-the-dark thread Glowly on cotton fabric

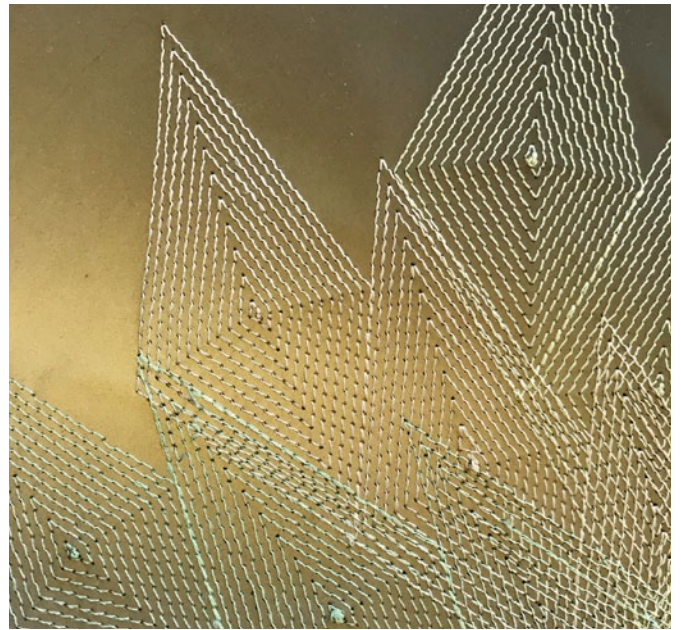


Fig. 7: Matt glow-in-the-dark-thread on reflective fabric by Frizza Italy

Transparency will remain a strong topic; besides clear materials, milky and semi-transparent foils are becoming more important, as shown on the following pictures.

Figure 4 displays a feathery grayish rose tone (Poly Star) embroidered on a milky foil by Sam Fashion Group Italy. Figure 5 shows trendy multicolour shades of Sulky viscose on a semi-transparent foil by Frizza Italy.

We will discover the comeback of pastel shades. Simple geometric structures remain a strong trend, realized in a matt look using effectful glow-in-the-dark pastel shades from the GLOWY range. (Fig. 6 / 7)

Shades of blue will play a major role in 2020 and in the next seasons, inspired also by Pantone's colour of the Year 2020, Classic Blue 19-4052. (Fig. 8)



Fig. 8: Medley of blue tones from Gunold's thread assortment

About the author

Reiner Knochel is working for Gunold and is as well a freelance consultant and networker within the textile and embroidery business. With more than 25 years of experience, he is a bridge builder between the creatives and their production partners.

In his seminars and consulting activities he is informing, teaching and supporting brands, designers and product developers about creative and technical possibilities in embroidery and how to interpret latest trends into embroidery.

Contact Info

Reiner Knochel

www.reiner-knochel.com

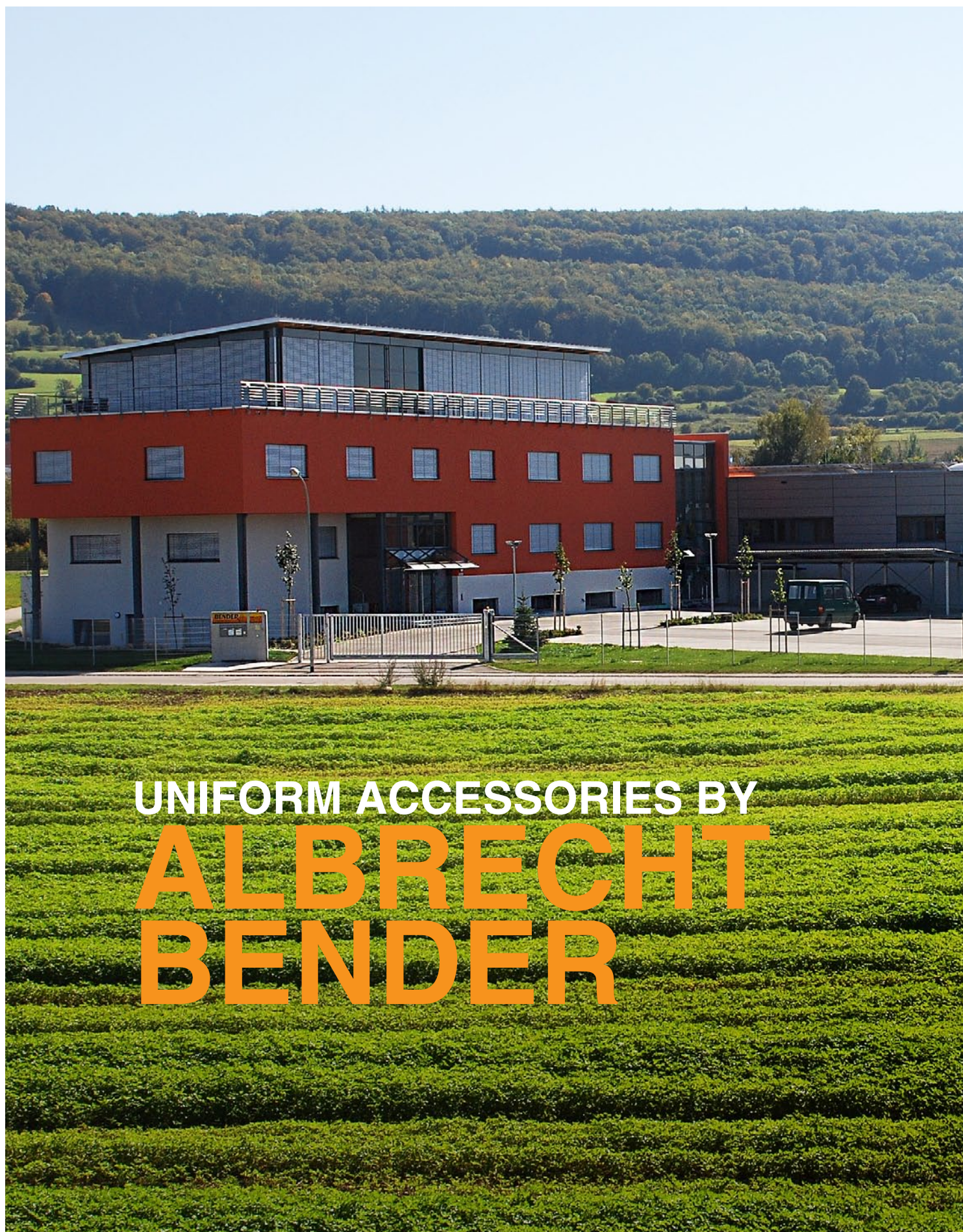
E-Mail: mail@reiner-knochel.com



www.gunold.de

E-Mail: service@gunold.de

Text & Photos: Reiner Knochel, Designs: by GS UK



UNIFORM ACCESSORIES BY
**ALBRECHT
BENDER**



SUCCESS WITH TRADITION AND INNOVATION

Albrecht Bender in Weißenburg was founded in 1864 in Ansbach. In 1892, the company was acquired by the grandfather of the current managing director, as the company was registered and approved as a supplier to ancient royal Bavarian regiments.

Today, the family-owned business is run by the third generation, Gerhard Fürst, with the support of his son Roland Fürst and factory manager Ludwig Pfaller.

Albrecht Bender is a specialized manufacturer of all kinds of uniform accessories – from emblems to laces and trimmings. With its extensive range of high-quality products of steady quality, Bender supplies the retail market, industry, government agencies and public organizations. Among their main customers are armed forces, fire brigades, police forces, railway services as well as international airlines and organizations like NATO, THE UNITED NATIONS and even European Royal Dynasties.

Apart from its headquarters in Weißenburg, the company has branches in Czech Republic and Tunisia where machine embroidery is predominant. On a small scale, hand-embroidery is still being offered. The group employs a total of 350 international employees.

EMBROIDERY DEPARTMENT

Since the very early days, Albrecht Bender has been offering items that are refined and individualized with artistic hand-embroidery. Already back in 1933, Albrecht Bender had its first embroidery machine in use. Over the past decades, the machine embroidery business has grown considerably, and the equipment has been adapted to the expanding business.

"THOSE DAYS IN ATLANTA"

Until 1996, embroidery on ribbons and tapes was done with embroidery frames on so-called name stripe machines. In the long term and with the growing quantities, this system was no longer up-to-date and no longer efficient. The process of laying carrier material into the frame was too time-consuming.



Factory building at A. Bender with ZSK embroidery machines.

But we were at least as convinced of the know-how at ZSK STICKMASCHINEN and the special ZSK customer service.

Gerhard Fürst



Consequently, in 1996 Mr. Fürst was looking for a solution that could automatically pull and transport woven ribbons and tapes, while embroidering the carrier material. He had samples stitched at all well-known international embroidery machine manufacturers. The result however was not satisfactory. Some patterns were imprecise, some were precise, but with an embroidery look that was totally inappropriate for the European market. The ideal solution was not there yet.

At the trade fair in Atlanta in 1996, Mr. Fürst first met with the ZSK management and with Mr. Metzler, at that time head of the ZSK software department. Shortly after this conversation, the idea was born and the solution found.

Within the following weeks, ZSK engineers developed equipment according to the customer's requirements. And just after six months the first five ZSK embroidery machines with the new developed technology were delivered.



ROLL2BASKET device for embroidering on textile band

to Bender. At least as revolutionary as the ribbon equipment was a software developed by ZSK, the ZSK "Production Manager". Albrecht Bender used this software already in 1996 for the central administration of their monograms and was probably one of the first companies at that time with a fully automated workflow for personalized name embroidery.

When asked what had been the decisive factor to go for ZSK machines at the time, Mr. Fürst answered: "Of course we were impressed by the robustness of the machines and the quality of the embroidery. But we were



ZSK ROLL2BASKET units at a ZSK RACER multihead embroidery machine

at least as convinced of the know-how at ZSK and the special ZSK customer service. It was very important for us that we could work and negotiate directly with the manufacturer and not with a representative. And that was the case with ZSK. "

The Albrecht Bender machine embroidery department is one of the most advanced in the world. Today, the company has almost 100 of the latest computerized ZSK embroidery machines from the SPRINT, RACER and CHALLENGER series, starting from single-head up to 18-head machines. The numerous single-head machines equipped with ROLL2BASKET are mainly used for the production of name stripes. The four 18-head machines, Mr. Fürst's so-called "battleships", are particularly used for the mass production of badges.

DIGITAL AND COMPUTERIZED – IN THE PAST AND TODAY

Next to the embroidery hall is the process planning department where we see how Bender employees "communicate" with the embroidery machines in their factory. As already described, individual name embroidery is a fully

automated work process here since long. Process planners are sending orders exclusively from the server to the individual embroidery machines. The ZSK "Production Manager" is the software providing the central competence for these processes.

ADVANTAGES IN DAY-TO-DAY BUSINESS

The advantage of a network is that all patterns are stored centrally on the server. The setup time at the embroidery machine is reduced, errors in the name transfer are eliminated. Given the multitude of names, this is a huge advantage for the company and a relief for the employees. In the event of capacity bottlenecks, jobs can be easily and quickly transferred to any free machine available on the network. Small machines can be managed without large personnel and embroiderers can handle the big machines instead.



"The embroidery machines play a decisive role for our business. They are running continuously and that works perfectly. A daily routine without the ZSK machines is inconceivable for us," explains Mrs. Rauenbusch, embroidery expert at Albrecht Bender.

Through regular maintenance and the constant retrofitting of innovations, Albrecht Bender keeps its machinery up-to-date. After more than 20 years of operation, the first generation of ZSK machines is now gradually being replaced by new ZSK SPRINT and RACER machines.

CHALLENGE AND USP

"Our biggest challenge and at the same time a unique selling proposition is probably the complexity of our product portfolio, the large number of production processes and the wide range of our production batches from 1 to 1 million pieces" summarizes Roland Fürst.

It is not an easy task to successfully organize, structure and manage all of this. Thanks to the experienced and prudent management and a committed team with a headcount of 350 employees, and state-of-the-art machinery including 450 high-performance and smart ZSK embroidery heads, Albrecht Bender continues to be on the road to success. ■

Contact Info

Albrecht Bender GmbH u. Co

www.a-bender.de

mailbox@a-bender.de



Quilting thick yarn

There are applications and designs where ZSK embroidery machines process sewing thread. Unlike the very fine embroidery thread for machine embroidery, the sewing thread is rather thick.

Here we show some points to consider when digitizing for thick yarn and application.

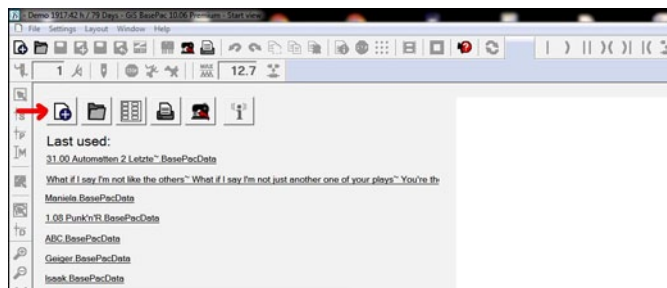
Digitalization

Embroidering with sewing thread must be considered when digitizing the embroidery design.

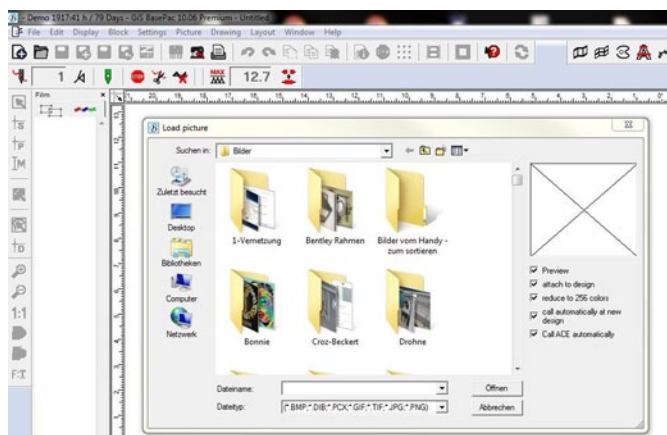
Using the example of **BasePac 10 Premium**, we will show you step by step the procedure and the most important settings.

1. Open new file

Open a new empty file in BasePac Premium by a click on the icon "paper sheet +" (see red arrow)



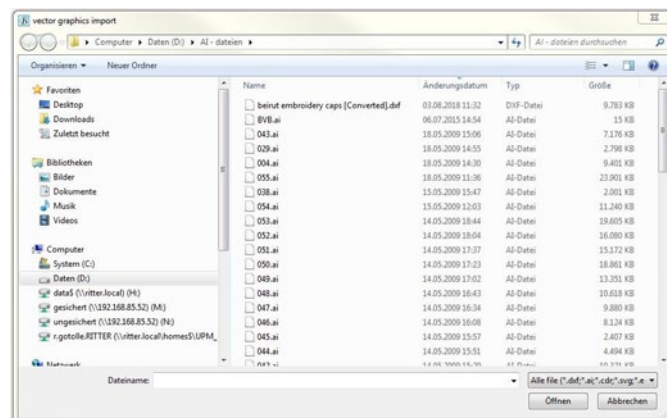
If the basic settings of BasePac have not been changed, the "Load picture" window pops up automatically.



Select an image as a template for tracing or choose "Cancel" to do something else like loading vector data.

2. Load

To load vector data (dxf, ai, cdr, svg) choose "File" at the top menu and select "import vector data".

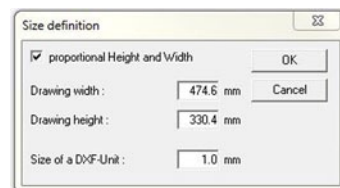


Choose your file. Supported data formats are:

- AutoCad .dxf
- Illustrator .ai (version 3 - 8)
- .svg
- Corel Draw .cdr (version 7 - X4)

3. Open a selected file

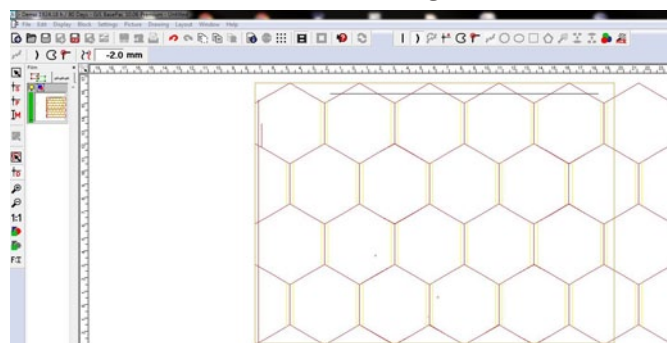
Opening a selected file with the "Open" button leads to an automatic pop up window "Size definition"



The window informs about the size in mm (millimeter) and offers the possibility to resize.

Note: Please check that the "Size of Unit" is 1.0, else change the entry to 1.0!

After a click on "OK" the chosen design is loaded.



SPRINT 7

Embroidery Solutions
by

**Z
SK**

3 New Models
18 Needles
Servo Drives
Home Function
Larger Embroidery Fields

**Z
SK**

ZSK STICKMASCHINEN

MADE
IN
GERMANY

Computerized Embroidery Machines MADE IN GERMANY

www.zsk.de



facebook.com/ZSK.Stickmaschinen



youtube.com/zskfilm

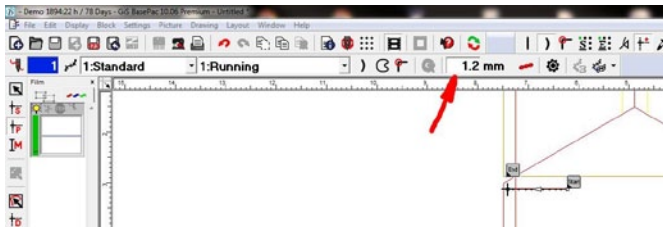


instagram.com/ZSK_Stickmaschinen

4. Lock Stitch

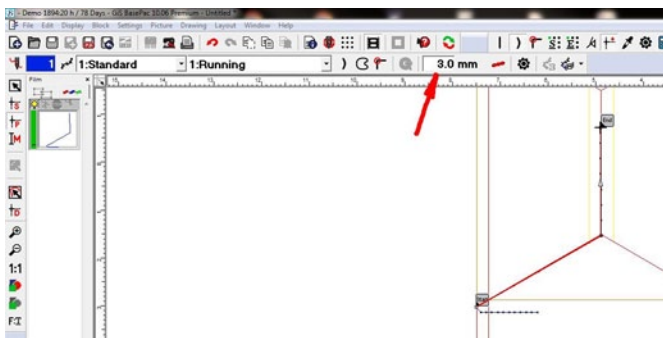
To set the start point of your embroidery select "Coordinate Mode" and use the "Running Line".

First you should create a "lock stitch" somewhere outside of the design or where it will be not be visible later. Set the stitch length for the "lock stitch" to 1.2mm, in any case not below 1.2mm! (see red arrow below)



5. Design

Change the stitch length of your real design or quilting to 3mm at least. Basically the stitches can be longer. Start digitizing the design.



When digitizing the design itself has been finished, create again a "lock stitch" and use the same settings as for the "lock stitch" at the beginning.

6. Safe

Save the digitizing file and export it as a TC file to embroider the new digitized design on a ZSK embroidery machine.

Machine settings

The thread tension for the upper thread must be set very taut, as sewing thread has a very smooth thread and would otherwise slip. This leads to an unclear embroidery image and possibly causes problems with the embroidery machine.

Depending on the material and the desired sewing effect, the needlepoint of the embroidery needle used is an important factor for a good embroidery. For example, when embroidering on leather with the wrong needle, the backstitch of the lockstitch can produce an undesirable sawtooth effect. For a clean and straight seam, special needles should be used here.

Tip: For ZSK embroidery machines, we recommend **DH 110** (Item No: 574.707) or **DH 90** (Item No: 574.709) needles as needed. These types are exclusive to the **ZSK STICKMASCHINEN!**

The bobbin thread tension needs to increase as well. With regular use of "thick" yarn, it is advisable to have a set of high-tension bobbin cases for a uniform embroidery pattern.

Tip: **ZSK STICKMASCHINEN** offers special **red anodised bobbins** (Item No: 573.210) to differentiate easily between thick and thin lower yarn.

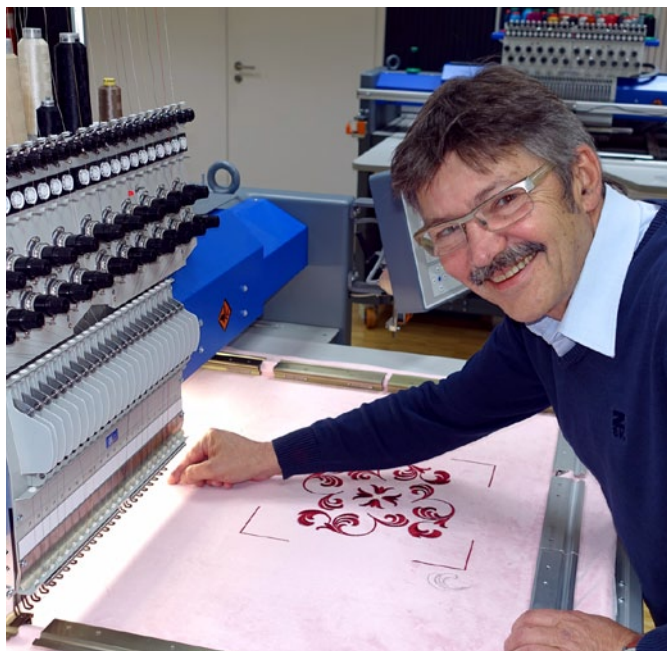
Please note: Of course, embroidery and sewing threads can also be used in one pattern. Please do not forget to provide the matching bobbin thread on the machine when changing the thread. ■

Contact Details

ZSK STICKMASCHINEN

email: software@zsk.de

JUBILEE 50 years in profession



Joachim Flassenberg's professional life began early at the age of just 13,5. After his training as a mechanical engineer (handicraft), he joined Carl ZANGS AG in 1972.

Until the bankruptcy of ZANGS AG in January 1984, Mr Flassenberg worked as a mechanic for Schiffli embroidery machines to small embroidery assembly.

He joined ZSK in 1984 as a mechanic in the small embroidery assembly department. He soon became a foreman there and trained as an industrial master craftsman. Later, in 1990, he became the department manager of the entire embroidery machine assembly department and in 2000 production manager.

This was followed by a career change in the years 2005 to 2013, but even during this time he remained loyal to the embroidery machine. Since 2013 until today, Joachim Flassenberg has been working for ZSK STICKMASCHINEN again as area sales manager BeNeLux and DACH.

Our congratulations and thanks for this lifetime achievement.

ONLINE PLATFORM ZSK Digitizing Academy



ZSK STICKMASCHINEN Digitizing Academy

for BasePac & EPCwin
ZSK Professional Embroidery Software

ZSK STICKMASCHINEN has been successfully selling the BasePac and EPCwin digitization software packages for over 20 years. Our software is based on the practical and creative needs of industrial embroidery.

This is complemented by individual or group training courses on site at our customers' premises or in the ZSK training centre in Krefeld, Germany.

We have now expanded this offer.

We recently started offering a new ZSK online platform on **YouTube: The ZSK DIGITIZING ACADEMY**

The new offer enables an uncomplicated entry into our software offerings. The ZSK DIGITIZING ACADEMY allows video-assisted learning in self-study with all the advantages: You learn just as your personal situation allows.

Visit us online at: youtube.com/ZSKDigitizingAcademy



COMPETITION

Economy in Transition



 **NRWirtschaft im Wandel**
Ein Wettbewerb für Unternehmen mit Zukunft

ZSK STICKMASCHINEN is a prize winner in the company competition "NRW-Economy in Transition".

ZSK STICKMASCHINEN is one of 11 outstanding companies that symbolize the structural change in the state North Rhine-Westphalia towards a future-oriented business location in an exemplary manner.

About the competition

Where once smoking chimneys and gray colliery settlements dominated the image of Germany's core economic region, a modern and diverse business location has been developing for decades.

The ongoing structural change in companies in all sectors demands and promotes creative corporate strategies, the use of new technologies and the dynamic adaptation of production conditions. This creativity becomes transparent through the competition "NRW - Wirtschaft im Wandel" and is intended to encourage imitation.



Well done ZSK STICKMASCHINEN!

More info at: bit.ly/NRWTransition

SPRINT

Quick Change System



Many companies often had additional machines for the short production of small orders. Small productions are mostly associated with changing between operating modes. Even if changing the operating modes on ZSK embroidery machines is quick and easy, we were looking to increase efficiency at this point.

With the Quick Change System, we developed a simple but ingenious quick-release device for quickly changing between the tubular and cap operating modes.

A basic system to be installed on the embroidery machine with quick-release clamps and additional adapters for cap drives and tubular mounts significantly reduces changeover times.

The system is only available for ZSK single-head embroidery machines of the series SPRINT for types 5, 6 and 7.

Parts

Quick Change Basic System	Part No.: 360.998.901
Quick Change Adapter	Part No.: 360.010.209

Contact Details

ZSK STICKMASCHINEN

email: parts@zsk.de

When I asked Walter Biegelbauer for an interview in May 2020, he answered: "An interview about my life at ZSK? We'll be finished in two minutes."

Well, it wasn't quite like that after all...

ZSK

— For a lifetime?!

Interviewed by Ute von Cranach



Walter Biegelbauer was born in Austria in 1952 and grew up there with two siblings. Even as a young man he was interested in technology and trained as a machine fitter. Since 1973 until today he has been working for Zangs and ZSK Embroidery Machines.

CARL

What brought you to Germany and to Krefeld of all places?

Walter Biegelbauer

After completing my apprenticeship, I decided to start my professional career in Germany and moved to Krefeld in 1973. I had chosen Krefeld because my aunt already lived there, who could offer me accommodation for the beginning and "starting help" for my professional career.

While looking for a job during a tour of Krefeld, I came across the Zangs company more or less by chance. I had no knowledge of weaving frames or embroidery machines at that time, but I applied for a job at Zangs. And I promptly got a job as a machine fitter in the assembly department and then built Zangs machines. What fascinated me right from the start was the technology surrounding the machines, the pleasant working atmosphere and the great freedom I was able to work with, until the company had to file for bankruptcy in 1983 despite full order books.

CARL

How did it continue? Who were your companions then and now at ZSK?

Walter Biegelbauer

After a short period of unemployment, I joined ZSK, the company newly founded by Mr Micheletti (Italy), Mr Walz (Germany) and Mr Sülmann (Germany), in February 1984. At the beginning the company consisted of 11 employees and now concentrated exclusively on the production of embroidery machines.

Together with Wolfgang Rudolph and Karl Helgert, the first step was to build shelves and storage facilities. In the next



Walter Biegelbauer - 1990

3 years I built standard embroidery machines. The market for embroidery machines was booming and we could hardly produce as fast as the machines were ripped out of our hands.

With the rapid growth in sales, the Quality Control (QC) department also grew and I moved to this department in 1987. Two years later, I was appointed to the company spokesman committee and later elected to the works council. I enjoyed the task as a works council member very much and I have carried out this activity for over 10 years in addition to my main job in QC.

Another long-time companion was Theo Friedrich, who was also 'company spokesman' and worked with me until he retired.

CARL

What inspired you about your work at QC?

Walter Biegelbauer

Here I was able to work very independently and the depart-

ment was very much appreciated and supported by Dr. Ostroff, who was my boss at that time. Among others, training courses were offered for the employees with the aim to achieve a better understanding of the components and functions of the machines.

This offer met with great interest and considerably promoted the know-how of the whole team.

CARL

What were your main tasks in QC and in which projects and successes did you participate?

Walter Biegelbauer

Our task was primarily the technical optimization of the machines. We were good, but wanted to achieve world class.

So a strict quality control was established. From now on, all machines had to undergo quality control before delivery, so they had to pass tests that were carried out with new intermediate and final acceptance protocols.

An audit station was also set up to randomly test the machines. Due to operational circumstances, I then took over the test room additionally. Since then, AWT (Application Engineering Team) and test room have been combined. And finally, I became head of the QC department.

CARL

What role did AWT play at that time?

Walter Biegelbauer

The AWT became more and more important and was strengthened accordingly in terms of personnel. In the meantime, a technical draftsman was also part of the team. We were directly subordinate to the management and consequently could work very independently. I remember very well the „birth“ of today's SPRINT series, which is the bread-and-butter line of ZSK. This was created solely in the AWT department.

CARL

How did the SPRINT series come about?

Walter Biegelbauer

In 2001, Dr. Zons - at that time the CEO of ZSK - wanted a small single-head machine to be developed as a table machine. An engineering office presented a prototype, but it didn't work like this. Therefore, we at AWT took over the project and developed the current SPRINT within a very short time. Within only six months we had already produced the first ten units in December 2001.



Walter Biegelbauer anno 2006

Now, the next step was to develop a frame for the new machine.

CARL

How important was this phase for you personally?

Walter Biegelbauer

I would say that the SPRINT period was my most important and most beautiful time at ZSK. We had a great team of four, who not only worked well together, but also had a lot of fun.

CARL

Who belonged to this 'team of four'?

Walter Biegelbauer

Helgert, Rudolph, Kirch and myself.

CARL

What other highlights in machine development were there for you?

Walter Biegelbauer

The J-machine, which we developed as a single- and two-head version, was developed by the Teetz company. At AWT, these single to eight-head machines were brought to series production in the years 1994-1995.

In 2002 the first 1,000 mm deep machine on J-basis was also developed by AWT.



ITMA 2007

The first W-head for laying ribbons and cords, as demanded by the fashion industry at that time, was developed after intensive development together with the engineering office Teetz about 20 years ago.

CARL

How and when did the era of technical embroidery systems begin for ZSK and for you?

Walter Biegelbauer

This era began about 17 years ago, when business with special machines was rather slow. At that time, our design department was to develop aircraft windows with carbon for an Italian customer whose core business was the laying of wire for seat heating systems.

This is how the first technical machine was built, and this is how we got into the subject of carbon laying.

CARL

What special projects and customer-specific developments did you accompany?

Walter Biegelbauer

We developed the Roll2Roll system about 14 years ago together with a customer who only produces seat heaters -

with automatic tensioner and automatic cutter, and it became a fully automatic production machine.

Another German customer, who had already been working intensively with other technical embroidery machines for years, became aware of ZSK TECHNICAL EMBROIDERY SYSTEMS and came to Krefeld for test runs with our machines. The subject was also wire laying.

After successful test runs, this company completely transferred to the ZSK technology. With more than 10 of our technical embroidery systems in use, they are nowadays mainly laying carbon, but also processing wire for seat heating systems.

CARL

What did the fall of the German Wall mean for ZSK and for you?

Walter Biegelbauer

Right after the fall of the German Wall, our sales representative and me started to visit our customers there twice a year. The main focus in Eastern Germany is shuttle embroidery for table linen and curtains. My task was the sales support in addition to the installation and maintenance of the machines and customer training.

CARL

What particular success in Eastern Germany do you remember, Mr. Biegelbauer?

Walter Biegelbauer

We were in contact with a very interesting company. However, getting started there was extremely difficult and protracted - and we had a lot of arguing. But in the end we were successful and what finally convinced the customer was our shorter retrofit times for small series.

CARL

Which countries did you travel to in your ZSK period? And is there a special trip, a special event that you remember with pleasure?

Walter Biegelbauer

Over the years I have travelled a lot in Europe, USA, Turkey, China, and Brazil. And yes, this 'special trip' took me to Brazil in 2014, at the time when the Soccer World Cup was being held there.

My trip was planned to take just one week during which our representative and me were to visit an important potential customer. In Frankfurt I boarded with 2 suitcases and all the documentation for our customer visit. I arrived in Sao Paulo on time. Unfortunately alone - as it soon turned out - without my suitcases, which probably had taken a different route to some other destination!?

What can I do now? I asked myself.

First of all, I had to go and declare the loss of baggage at the airport. Next, keep hoping that the luggage will turn up the next day.

Our representative was convinced that a customer visit doesn't make any sense without the documentation and suggested, for now we have to sit and wait for the luggage - or for a wonder.

Optimistically, I checked the arrival of my luggage every morning with the airport - like a fixed daily ritual. But also like a fixed ritual I got the same negative answer 'Nada' on the second day.

After I had already bought the most necessary things in the city yesterday, namely a set of fresh laundry, I went to the same department store again today. Cost sensitive as I am, I just bought another single set of laundry, because I was sure tomorrow my suitcases will arrive.

The whole week passed like this in the flight - just no luggage from Germany turned up. Thus no customer visit could be done and consequently, I had to extend my whole trip.

My daily trip to the department store to buy laundry had already become a fixed ritual likewise my daily checks with the airport. In the meantime, we had also found out that a



2014 - Sao Paulo, Brasil



At techtextil 2019 - Frankfurt am Main

beach life with Caipirinha and barbecues isn't too bad. And finally, there was also the Soccer World Cup. Our representative invited me to a soccer game, under the condition that we all wear a T-shirt in the Brazil colours. I agreed and got a nice T-shirt which just was at least 2 sizes too small for my body and I felt quite uncomfortable in my tight green-yellow outfit – as you might see in the photo. Nevertheless, the soccer game was exciting and we had a great time together.

But on the other hand, still we had to finish our project with the customer before the end of the second week, even without documents. It turned out to be a long and tough meeting, but finally successful since we could convince the customer to buy the offered machine.

We also achieved another success as my two lost suitcases arrived on the last day before my return. Well, I bought a good stock of Brazilian laundry in the past days for which I now needed new suitcases. So finally I returned to Germany not just with the two but with four suitcases - and with many good memories of a happy time and a successful business deal.

CARL

What is your favourite country in your career? And the private one?

Walter Biegelbauer

Professionally, it is definitely Italy, because I am enthusiastic

about the Italian way of life, the food and drinks, the team there and our Italian customers.

My private favourite country to travel to is of course Austria, my home country.

CARL

What fascinates you about technical embroidery?

Walter Biegelbauer

The variety of applications and the complex requirements.

I have been working in the field of technical embroidery for 15 years now. I would describe myself as a source of inspiration, and also kind of a production supervisor. When we are preparing a technical embroidery machine for transport in Krefeld, whether for a customer or for a trade fair, I'm always there during loading and follow the process until the machine has finally left the yard.

CARL

What about the private person Walter Biegelbauer?

I was born in Austria, and in 1978 I married a "born-and-bred" woman from Krefeld. We have a son and live in Krefeld.

CARL

Mr. Biegelbauer, where are you going on vacation?

Walter Biegelbauer

Vacation trips usually go south and usually end up in Austria, my home country. And apart from that, it's quite nice also in Krefeld. For my wife it is a must to be able to see the Krefeld church tower, otherwise she is not happy. And she claims that I always have to be able to see the ZSK company to be happy. (Smiles)

CARL

And finally, what plans do you have for your time after ZSK?

Walter Biegelbauer

I am still in the 'discovery and decision phase'. My wife certainly has more concrete plans for the future yet, but I'm not sure whether they necessarily coincide with mine ... (Smiles)

Contact Details

ZSK STICKMASCHINEN

Your Contact:

Mrs. Ute von Cranach

email: ute.voncranach@zsk.de



Control Unit T8 / T8-2

More Barcodes to load designs

At CARL Spring 2019 we described the loading of designs via network using barcodes. Due to the numerous positive feedbacks to this article, we have extended this method with additional barcodes.

Requirements

- **Barcode scanner with USB-access.**
With the machine off, connect the scanner to the back of a USB port on the T8 control unit. If necessary, set the scanner to "Add return".
- **T8-2 Release 004 / 24.06.2019 or later**
Only available for machines with MCP31 and MCP35.
Download the latest T8 Software-Updates at:
www.zsk.de -> "Service" -> Downloads

Note: To use this feature, you must slightly change the settings of your T8. A how-to is described at **CARL Spring 2019** on page 48-50.

Barcode

Barcodes for the embroidery design can be generated and printed by BasePac 10 and EPCwin.

Loading from internal memory

Scan the bar code **a2**



The directory of the internal memory is displayed.

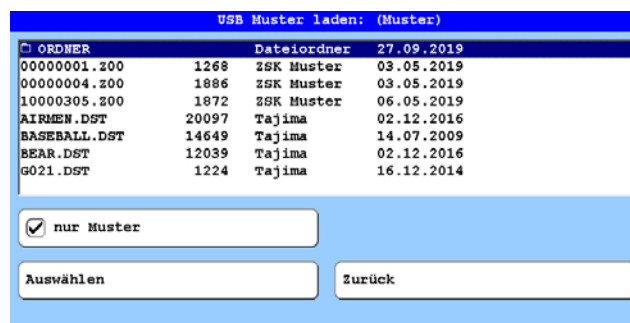


Loading from USB device

Scan the bar code **a4**



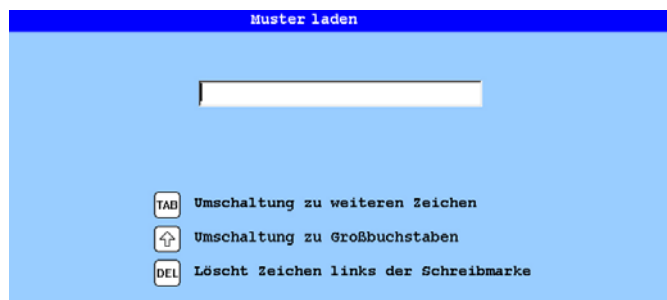
The directory of the USB device is displayed e.g.



Then scan the barcode **a7** to display the loading dialog



Then scan the barcode for the design e.g.



Then scan the bar code for the design e.g.

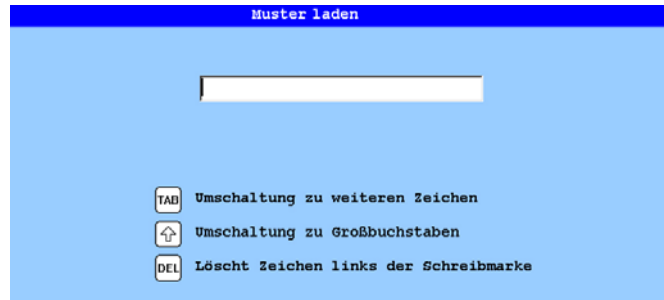


The design will be loaded and assigned to the embroidering process

Then scan the barcode **a7** to display the loading dialog



Then scan the barcode for the design e.g.



Then scan the bar code for the design e.g.



The design will be loaded and assigned to the embroidering process

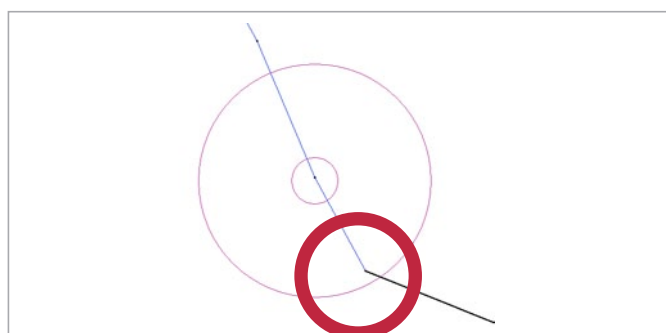


BasePac 10

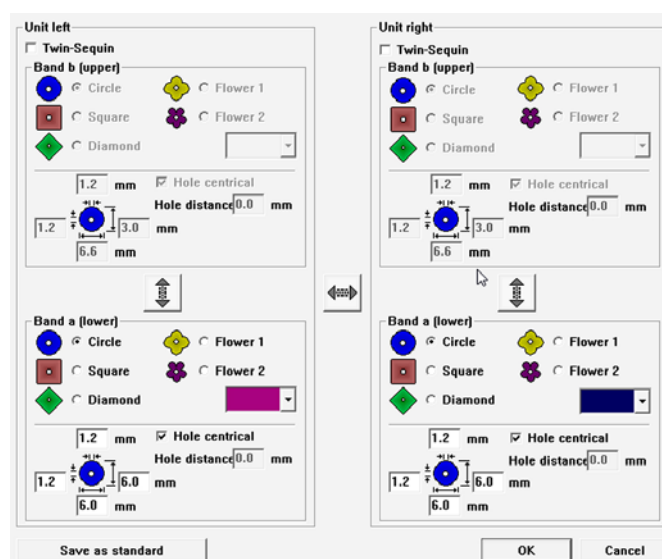
How to create a Sequin Design by Britta Sanders

Define size and shape of the sequin first

Before you start with your design, define shape and size of your sequins. This way you can already check on your screen that no stitch will be in the way of the sequin. If you change it at a later stage, make sure and double check that no stitches hit the sequin.



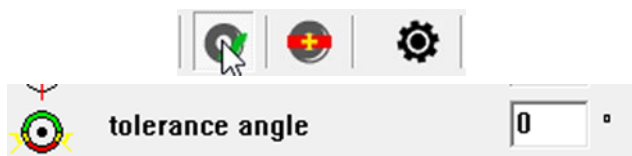
The lower stitch will hit the sequin, when you see this on your screen.



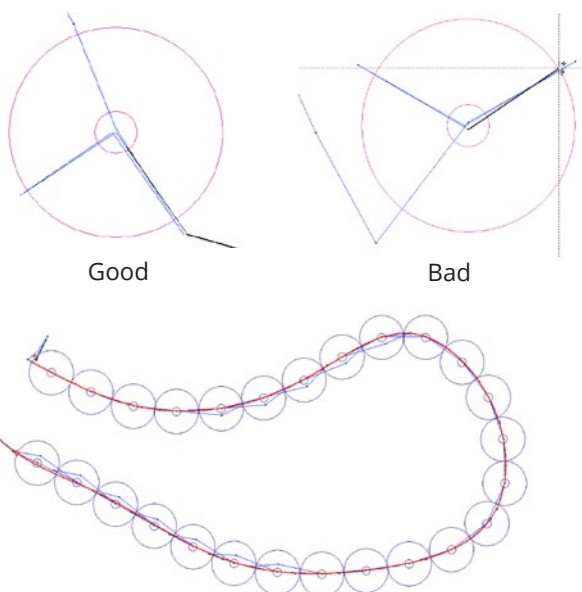
Setup mask for the definition of sequins.

Where is your last stitch before the sequin?

The last stitch has to be "above" the sequin, so that it is in the back the moment the sequin is placed. That means: Do not rotate sequin designs, if you for example prepare a sequin design for caps, already do the digitizing upside down. In the automatic programs you can set a so called "tolerance angle" at:



It adds some pick up stitches to the right position to make sure that the last stitch is always placed accordingly.

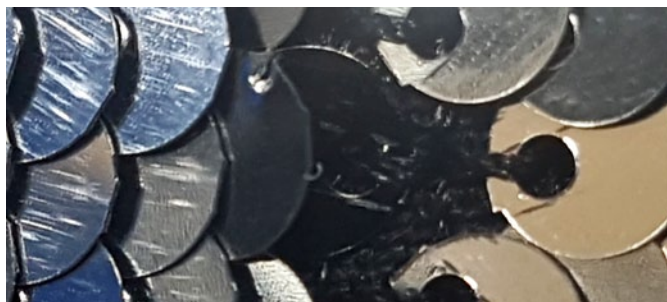


Decide first where you start to fill your object with sequins. Hanging sequins are placed from bottom to top. In BasePac Premium you are able to change the start point of an object with

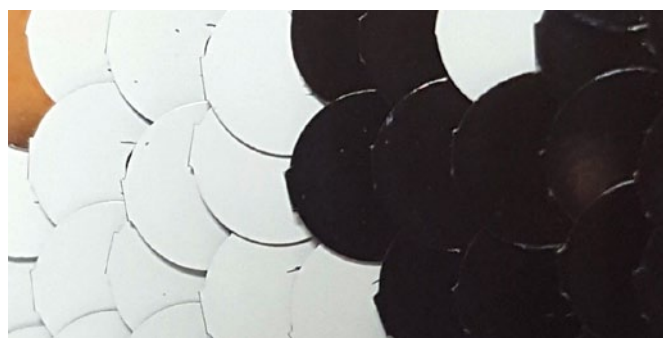


Take a look at the machine

Pay attention when you do the test stitch. Do the sequins "jump off"? If it is always the same sequin causing trouble, recheck your digitizing.

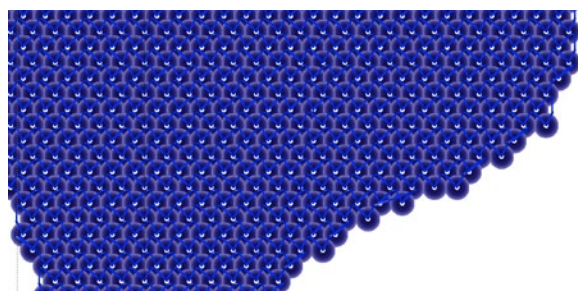
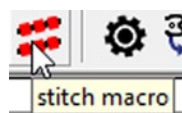


Are there "fishes" instead of round sequins? Reset your sequin device. The sequins were pushed forward too far.



Use automatic programs

BasePac Professional has an automatic sequin line program. If the sequin program does not offer your preferred fixing method or if you want to fill an area with sequins, create your own macro with a sequin and use the Macro function



Start your own sequin projects now

BasePac Premium allows you to place sequins individually and to activate twin sequin devices.

If you upgrade to the Professional package it allows you to place sequins on a line and to fill areas with the Macro function.

You can upgrade your ZSK machine to a sequin device now. It starts from one sequin device on needle 1 or the most left needle. You can load your machine with up to 3 Twin sequin devices allowing you to make designs with 6 different sequin sizes and shapes. Ask your local distributor for prices or contact us on the next show.

This and further info will be on our different training platforms: ZSK Academy or our BasePac Tutorials on Youtube.

Contact Details

ZSK STICKMASCHINEN

email: software@zsk.de



Professional Digitizing Service

Luiz Vitor Mendes was born in Blumenau, a city in Southern Brazil founded by a German community. Vitor started embroidery in 1994, working as an operator in one of the largest embroidery companies in the city. After a couple of years, he wanted to broaden his knowledge in order to start a business of his own.

Vitor explains: "I already understood how embroidery should work, all that remained to do was to learn how to create it. So, I learned embroidery digitizing just by myself."

So in 2001, he started working together with a friend, providing embroidery and development services. After just 2 years, he founded his company Vitordigitizing and began to provide his services to clients outside Brazil, and entered the American market. Mainly through social networks, Vitor managed to win new customers and became more and more popular. In 2017, he started his own website to market his services even more professionally.

At a machine fair in the city, he began to investigate in new machines and thus contacted different machine manufac-



turers. As he states: "From all these manufacturers, ZSK was different. They showed great interest in me although my business was still quite small at that time. I got the best service from them, and they treated me like a family member from the very start and I am proud to be part of the ZSK community".

What's special?

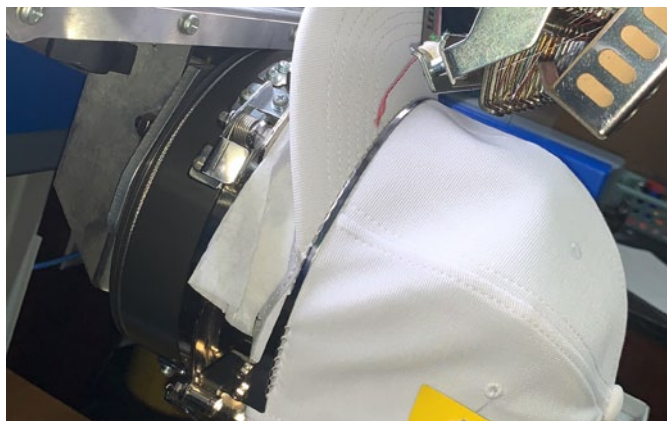
Vitor's designs range from classic embroidery to innovative styles. His expertise comprises complex designs using different techniques such as sequins, beads, laser cutting as well as creations with 3D embroidery.

Step by step HAC design

Today Vitor shows us how to create unique cap designs with the ZSK Hot Air Cutter and 3D Puffy Foam.

Step 1

Place the cap in the ZSK cap frame. Make sure it is centred at the middle seam and that there are no wrinkles around the clamp.



Step 2

Lay the material which you want to cut with the HAC device loosely on top of the cap.



Step 3

Fix the material onto the cap with a running stitch (app. 2mm stitch length) on any of your needles. Make sure that the line is inside the later cutting line, so that it is not cut away in the next step.



Step 4

Switch to the needle with HAC device (needle on the far left). It should now be activated. The cutting line is programmed by a running stitch with extremely short stitches (app. 0.5mm). Please note: Temperature of the HAC device and speed of the machine are key to the quality of the cut. So if you are not happy with your cutting line, check both settings. For example, thicker material tends to need higher temperatures or slower machine speeds.



Step 5

The cutting line should be outside of the fixing running line. Once the complete cutting line is done, the surplus material can simply be pulled off.



Step 6

Now place the puffy foam on top. For better grip the edges can be fixed with some cellar tape. However, as soon as the first stitches are placed, the puffy should be already fixed. Lift the pressure foot very high.



Step 7

Now place the stitches on top of the foam.

Use a high density for your design, so that the stitches perforate the foam sufficiently.



Step 8

After the machine stopped, pull off the surplus puffy.



Step 9

Cover the cutting edge with some satin stitch border to give the whole design a clean look.



Contact Info

Vitordigitizing

Telephone: +1 954 889 6764

Email: vitor@vitordigitizing.net



SPECIAL DIGITIZING OFFER

I offer digitizing from a simple text to a complex design or 3D puffy foam design. All files are created manually and will be hand digitized.

Get 50% off on your first 2 orders! *

*The offer expires 6 month from first order date.



Quicktext easily adds names to an existing stitch file, making it ideal for embroidering emblems or patches. The true performance of the solution can be seen when used on ZSK multi-head embroidery machines with head selection.

The design's common embroidery element, such as a company or club logo, is produced simultaneously and timesaving on all heads of a ZSK multi-head embroidery machine. After that, the individual names added with Quicktext are automatically embroidered at the selected position with the unique ZSK Head Selection embroidery head by embroidery head.

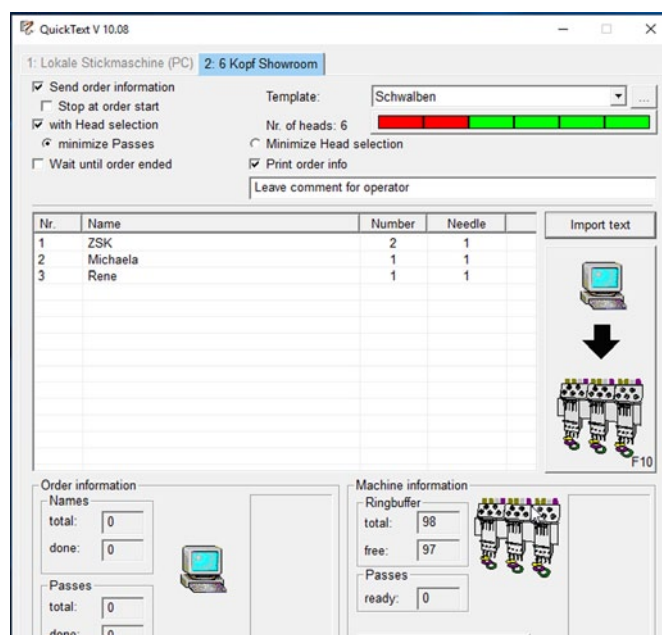
So, Quicktext is a really excellent embroidery solution for individualization and really time-saving on ZSK multi-head embroidery machines with head selection. But of course we wanted to do it better.

Quicktext is now better than ever.

The problem of working really efficiently on multi-head embroidery machines: The wishes and requirements of people for clothing and hat sizes or colours are as diverse as their names.

Our simple solution: Let the operator know in advance which embroidery head will process a certain individual order from a series of identical embroidery designs.

Now, the developed Quicktext creates automatically a print-out containing information on the location of each individ-



The input window of Quicktext at BasePac 10.

ual order related to a name. An additional comment field offers space for individual information for the operator, e.g. for clothing sizes.

The Quicktext solution with Head Selection is part of BasePac Professional and above.

Contact Details

ZSK STICKMASCHINEN

email: software@zsk.de



Back in 2018 at the last ZSK Open House we were proud to present a complete new way to expand your design possibilities on your ZSK embroidery machine – the bead device.

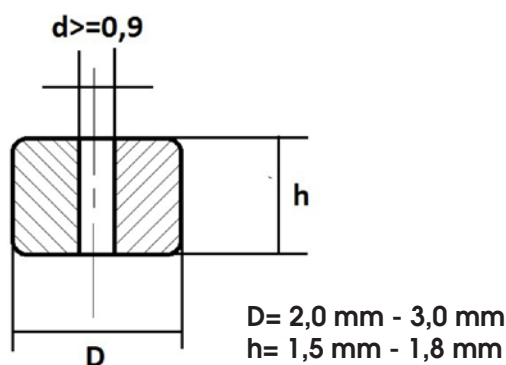
Soon after, the twin bead device was introduced. The question remains how to digitize a good bead design. The following article leads you through the development of such a design with help of our new EPCwin 7 bead feature.

Why EPCwin for your ZSK machine?

- Superior stitch calculation with accuracy of 0.1mm
- Supports automatic bead on line and bead on area fill
- Detailed parameter settings for perfect results
- Carries code for twin bead device
- 3D simulation of beads according to placement style
- Constant development and support close to our customer needs
- High compatibility between ZSK software and machine due to in-house development
- Test runs under realistic conditions for perfect results

Before you start

Take exact measurements of the beads you are going to embroider. Thanks to the “bucket” solution of the ZSK bead device, ZSK can embroider flat beads as well as round beads which is a unique feature that only ZSK offers. Important measurements are height, width and hole size of the bead.



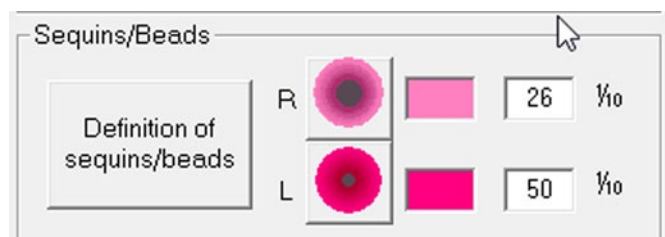
Now if you have all your necessary values you can start your EPCwin7 and open a new page.

Also make sure that you can tick the boxes below:

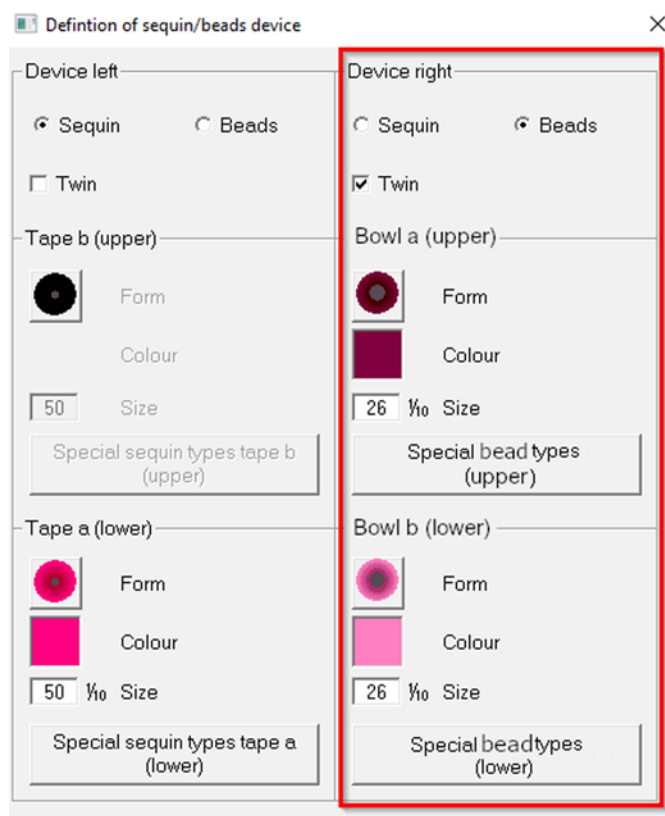
- You have a ZSK (Twin) bead device
- The device is set up according to the bead size
- The correct thread is used with the correct tension
- You use the correct needle size

Set up size and shape of bead

First of all, the size of the bead has to be defined in the design head. Here you will see the button "Definition of sequins/beads". Open with a double click.



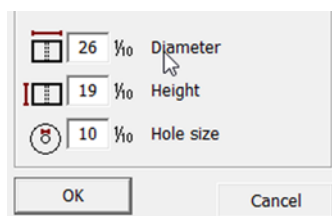
In the following example a twin bead device is attached to needle No.1, the right device. Here the icon "Beads" is activated. In that dialog you can now also define colour and diameter of your beads.



Under "Special bead types" further measurements for upper and lower bead can be entered.

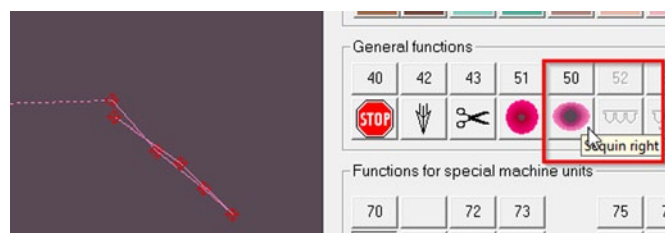
Enter the measurements of your beads here and confirm with OK or Enter.

Now that exact measurements are defined you can start digitizing and you will always see if the needle hits the bead.



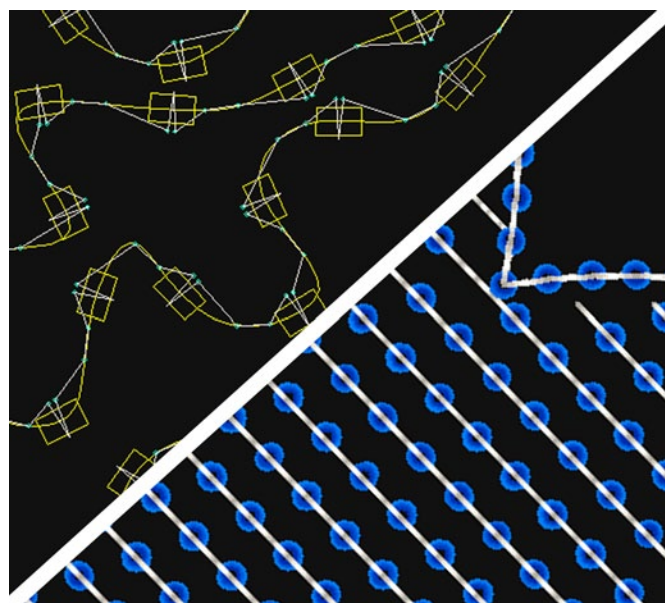
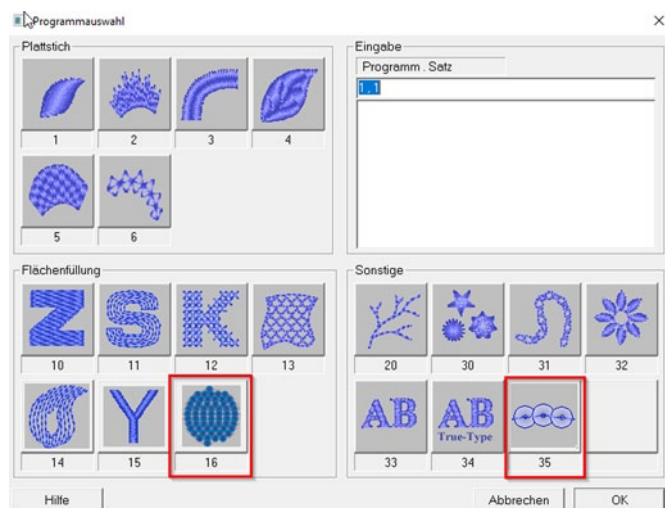
Start digitizing

If you know about digitizing sequin designs, you are already half an expert on digitizing beads.



Set the first stitches manually for fixing the thread to the material. Afterwards press F12 and activate your bead device. In our case, it is the "sequin right" command.

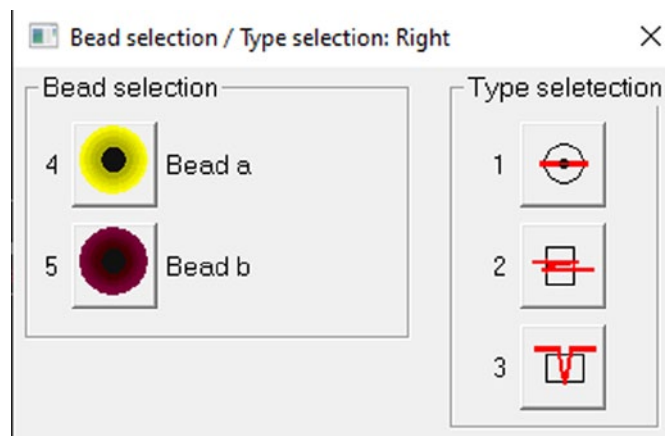
Once the command is activated, the beads can be placed individually by a double click or with help of our automatic programs. Program 16 allows to fill an area with beads or sequins, whereas program 35 places beads or sequins on a line.



3 styles of bead placement

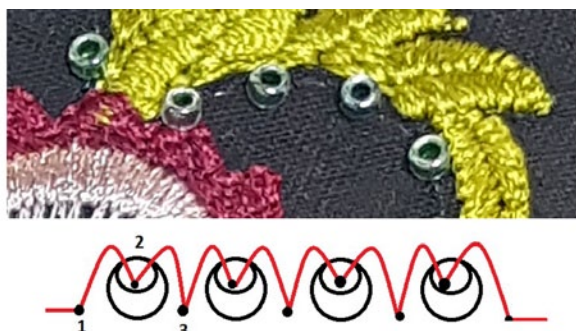
There are three different ways to place a bead.

While being in the manual bead mode (outside of any automatic program) F9 can be pressed to change the way of fixation or to choose between upper and lower bead. The icons already show which way the beads would be placed.



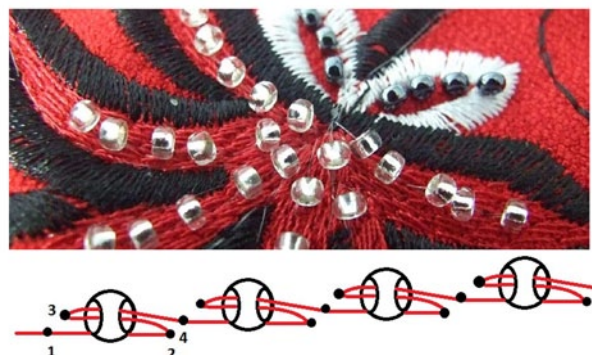
The different types are described below:

Type 1



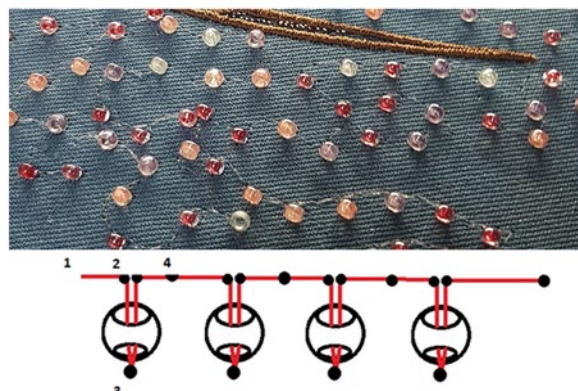
With type one the bead is placed like a sequin, showing the hole to the top. If you use the automatic programs, it is important, that the stitches are long enough so that the needle does not hit the bead. It should have at least the length of the bead's diameter. Also stitch No. 3 has to be long enough before stitch No. 1 is placed for the next bead.

Type 2



For stitch type No. 2, the beads are placed vertically to the running line. Important is, that the fixing stitch for the bead comes from the right hand side. So if the line goes from left to right, stitch No. 2 is necessary to start from the correct side. The length should slightly exceed the height of the beads so that they have a bit of space to move after falling over.

Type 3



The programming for type 3 is comparable to hanging sequins. The beads are placed parallel to the reference line. Important here is, that stitch No. 3 is far enough away from stitch No. 2, so that the bead has a bit of space to "breathe". This so called overstretch value can be set up in the parameters of the running program, as well as the fill program, recommended value is 0.6mm. ■

Contact Details

ZSK STICKMASCHINEN

email: software@zsk.de

Service Tool I Maintenance Tool



Like any other machine, ZSK embroidery machines require regular maintenance. This enables excellent embroidery results on a regular basis and, in many cases, could have prevented a machine failure.

In addition to the simple routine work such as cleaning and oiling, which every machine operator has to master, there are more specialized setting and maintenance work. These should only be carried out by trained technicians and experts. Failure to do so can seriously damage your machines.

We recommend the following tools for technicians and experts for the most common special adjustment and maintenance work on ZSK embroidery machines.

Parts

Rig Pin 136° (128°)	Part No.: 601.005.914
Locking Device 70°	Part No.: 601.005.952
Needle Height Taker	Part No.: 601.001.844
Adjusting Device Needle Height	Part No.: 601.003.206
Adjusting Pin Needle Height	Part No.: 601.001.614

Contact Details

ZSK STICKMASCHINEN

email: parts@zsk.de

Service Tool II T8 Remote Control



The maintenance of ZSK embroidery machines and devices such as beads or sequins requires that the embroidery machine is repeatedly started and stopped for testing. This is usually done via the T8 control unit and the sub-controls that are regularly present between the embroidery heads. These control units are easy to use and meet most requirements.

A Technician who have to service many machine heads with many devices will appreciate to have the new ZSK start/stop remote control at his fingertips. The T8 remote control saves time and enables the focused work.

The start-stop remote control of the T8 is wired and connected to the rear of the T8 via a D-Sub connector. The T8 and all other panels on the machine can also be used in parallel as usual.

Parts

T8 Remote Control	Part No.: 396.221.005
-------------------	-----------------------

Contact Details

ZSK STICKMASCHINEN

email: parts@zsk.de

Pier Paolo Scotti

– a legend in the ZSK world in Italy



Pier Paolo Scotti

Mr. Pier Paolo Scotti, historical figure and key mainstay for the ZSK world in Italy, has developed the industrial embroidery sector with passion, tenacity and dedication.

It is difficult to sum up in a few lines the personality of a person, whose collaboration has been lasting for 52 years. Considering his versatility and the several stories one could write a book.

Let us immediately say that his watchword was work. He was passionate about his work and as a riddler the more a deal was complicated and the more he amused himself, this last verb described his attitude very well!

He was a point of reference in this sector for a lot of people, even today, customers still remember him with admiration and acknowledge his competence, willingness and helpfulness, he always reserved for everyone, both for beginners in embroidery, and for experts in the embroidery market but he was always looking for advice on how to improve. His sales policy has never been a bite and run, but a constant support to customers with useful suggestions so that they can grow their business. He was altruist; he had even cre-

ated a finance company to provide long-term financing for those in trouble. For many people, Mr. Scotti was not just the ZSK sales representative, but also a consultant and later a friend to turn to, trusting in his experience. Many “customer friends” during his long career still remember him with esteem and much affection.

He was already working for several years in the wholesale trade of articles for haberdashery, when he definitely entered the Zangs/ZSK world in 1967, just at that time that the company Micheletti SAS was looking for an agent. Scotti responded to this job offer and soon began the partnership. The results were immediately positive and the machines sale took off, especially in Val Seriana (Bergamo), where it was tradition to embroider bedspreads for the bridal trousseau. He was often present in that area and then gradually began to expand his business in Veneto, Tuscany, Sicily, Puglia and so on, until he covered the whole Italian market.

Scotti had his own ideas, but he was able to listen to criticism and to take into account customers’ suggestions, this character trait is as rare as important.

Above all, he knew how to seize opportunities, so when it was possible to embroider on knitwear, Carpi became his second home. At that time, many German embroidery manufacturers had their machines, that produced and embroidered in Italy, and the number of sold machines shoot up.

He was full of new ideas that he collected from customers and drew inspiration from them. He experienced the technical machines development, from mechanical ones for linen to electronic ones with one or more needles. This certainly made him the most competent person for our sector.

Another point to highlight is the creation of the market of used machines. When he started his collaboration with Micheletti and even more so when he became a partner for his merits, he created the used machines market. When he sold a new machine, he was ready to take back an older model, which was then completely overhauled and resold.

In the meantime, the company had expanded and had seven technicians. They came on Monday to the office, collected spare parts, replaced in the previous week and gave



One who knew his way around!

their feedbacks about customer service on embroidery machines. Scotti realized that it was necessary to train technicians on site, in order to be faster and cheaper on the market. He gradually created with his partner Mr. Micheletti a network of branches all over the country, where you can buy thread, accessories, spare parts, and ask for technical support; each branch had its own salesperson, who followed the area under their supervision.

Words to Pier Paolo Scotti / Parole a Pier Paolo Scotti

Mr. Scotti was an exceptional salesperson.

What made him unique was his innate sense of honour and the word given; we had with him a personal and trusting relationship even before the business one.

His priority was customer satisfaction, and we always felt that he was able to listen to, to follow and satisfy us.

Seriousness, competence, professionalism and respect were his hallmarks: he never said a word out of place, not even towards competitors; this is nowadays a rare behaviour.

Humour and friendliness also made him special. He was always ready for a joke, even when his health got worse and there was no reason to joke, "At least my head is okay," he said.

We miss you, Mr. Scotti!

Adriana e Giuseppe

ADRIANA RICAMIFICIO di Bascio S. & C. SAS
Camalò di Povegliano (TV)

Il Sig. Scotti era un venditore d'eccezione.

A renderlo unico era il suo innato senso dell'onore e della parola data, un rapporto personale e di fiducia ancor prima di quello commerciale.

La soddisfazione del cliente era la sua priorità, ed è così che ci siamo sempre sentiti: ascoltati, seguiti, soddisfatti.

La serietà, la competenza, la professionalità e il rispetto erano i suoi tratti distintivi: mai una parola fuori posto, nemmeno nei confronti della concorrenza. Un comportamento raro al giorno d'oggi.

A renderlo speciale erano anche l'ironia e la simpatia. Lui, con la battuta sempre pronta, anche in momenti in cui la salute non suggeriva nulla di simpatico. "Almeno la testa è a posto", diceva.

Ci manchi signor Scotti!

Adriana e Giuseppe

ADRIANA RICAMIFICIO di Bascio S. & C. SAS
Camalò di Povegliano (TV)



Successful together for ZSK: Mr. Sobizack, Mr. Scotti, Mr. Micheletti

In 1989, Mr. Scotti founded ZSK Italia Spa, which exclusively deals with the sale of machines and programs.

At the beginning, Mr. Scotti visited customers in all regions, so for better or worse he followed all the customers. Thanks

to the help of his team, who he managed and advised on problems and sales opportunities, Mr. Scotti later focused on the northern area with particular attention to Lombardy and Piedmont, an area with many embroiderers.

He was a person who never stood still, and his mind ran even faster than his car, that never stopped for visiting customers. His passion for his work and for the embroidery world has always accompanied him even in the last months of his life, when because of a bad illness, he often had to stay in hospital, but even from there, he kept in touch with customers and actually closed a deal by telephone.

Always positive, cheerful and optimistic a great example for all of us, he taught us to never give up!!

Very many thanks, to our dear Mr. Scotti, who has been one of the most successful sellers in the world history of ZSK / Zangs, since he, alone, sold the largest number of embroidery machines (Zangs/ZSK). ■

The memories of Mr. Paolo Scotti are mainly related to my childhood, spent largely breathing the scent of fabrics, playing with threads and the noise of embroidery machines was a familiar song for me.

It was the distant 70's, when many craft activities, like ours, started, those born in the garage of the house. These were family businesses, where everyone actively participated without having timetable or holidays. Enthusiasm was the only leitmotif.

Mr. Scotti was a constant presence in the business growth of our activity, from the beginning with my parents and then always present in the generational shift.

His ability to be close to a company, to believe in the entrepreneur as a person, his ability to be at customer's side, not only in easy moments but especially when difficulties were pressing, he knew how to infuse enthusiasm, give support and demonstrate it in a tangible way.

I remember the relationship of mutual respect with my father Vito. Their handshake as the only commitment and guarantee, me a small child and them two BIG men.

Thank you Mr. Scotti!

Antonino Bascio
Nino Ricami Srl – Villorba (TV)

I ricordi che riguardano il Sig. Paolo Scotti sono soprattutto legati alla mia infanzia, passata in gran parte a respirare il profumo dei tessuti, a giocare con i fili e il rumore delle macchine ricamatrici era per me un canto familiare.

Erano i lontani anni 70, quelli della partenza di tante attività artigianali come la nostra, quelle nate nei garage di casa. Imprese familiari in cui tutti si partecipava attivamente senza orari e senza festività. L'entusiasmo come unico filo conduttore.

Il Sig. Scotti è stato una presenza costante nella crescita professionale della nostra attività, fin da subito con i miei genitori e poi sempre presente nel passaggio generazionale.

Lo ha contraddistinto il suo saper essere vicino all'impresa a credere nell'imprenditore come persona, la sua capacità di essere al fianco del cliente, non solo nei momenti facili ma soprattutto quando le difficoltà sono state stringenti, sapeva infondere entusiasmo, dare sostegno e dimostrarlo in modo tangibile.

Ricordo il rapporto di stima reciproca con mio padre Vito. La loro stretta di mano come unico impegno e garanzia, io un bambino piccolo e loro due uomini GRANDI.

Grazie Sig. Scotti!

Antonino Bascio
Nino Ricami Srl – Villorba (TV)

It's getting hard for me both to describe the relationship, I had with Mr. Paolo, and to remember an episode or a single detail.

Actually for me he has always been an important reference point, I would say crucial in my working life, far beyond themes about embroidery: for anything or for any problem I knew that I'd find in Paolo a word, a suggestion, a solution, all with "good vibes" that I have only found in a few people,

You knew that with him you were always safe!!!

I also remember when we shared our time together, we used to talk about our families, our lives and the dearest loved ones, I discovered a man for whom life had not reserved only joys.

Then I remember lunches and dinners together, when we discussed and shared our passions as motors, finance, real estate.... and after all he told me one of his funny jokes.

In short, a professional all-round man with whom I had the honor and pleasure to spend a 30-year-old piece of life that I will always keep in my heart.

One last thing... I would like to remember Mr. Paolo with a sentence that I always used to say when I had to introduce him to people, still imagining that he was a little embarrassed and flattered: "Paolo Scotti, the man who "invented" industrial embroidery on clothing in Italy! "

Gianni Bessegato
Tessilservice Srl – Quinto di Treviso (TV)

Before that ZSK became such a company, shortly after the economic recovery that characterized Italy after the war, we learned about the perseverance and tenacity of a particularly motivated Zangs agent, this agent was Paolo Scotti.

We could tell a lot of stories, many of them about our passion for motors, but , it is fair to remember when the young Mr. Scotti put all his efforts to sell us the first Zangs embroidery machine: this goal was the result of countless business trips from Milan to Bondeno, covering hundreds and hundreds of miles that led him to get what he wanted.

Since then, the relationship with Paolo has always been great: he was helpful, fast and resolute, to such an extent that we found and reached commercial agreements even just through a simple phone call, where all trust and esteem that had grown over the years were shown.

Paolo Cappelli
Cappelli Ricami Srl – Bondeno (FE)

Descrivere il rapporto che ho avuto con il Sig. Paolo, ricordando un episodio o un singolo particolare, mi diventa difficile.

In realtà per me è sempre stato un punto di riferimento importante, direi fondamentale nella mia vita professionale anche al di là delle cose tecniche: qualsiasi cosa o problema sapevo di trovare in Paolo una parola, un consiglio, una soluzione, il tutto con una positività che ho riscontrato in poche persone, con lui sapevi di essere sempre al sicuro!!

Ricordo inoltre anche i momenti di confidenza passati a raccontarci delle nostre vite, delle nostre famiglie, dei nostri affetti, scoprendo un uomo al quale la vita non aveva riservato solo gioie.

E poi pranzi e cene insieme a discutere e a condividere passioni quali motori, finanza, immobili.. il tutto condito con qualche sua 'ultima' barzelletta

Insomma un uomo a tutto tondo con il quale ho avuto l'onore e il piacere di condividere un pezzo di vita lungo 30 anni, che porterò sempre con me.

Un ultima cosa...vorrei ricordare il Sig. Paolo con una frase che usavo sempre quando dovevo presentarlo a qualche persona, immaginando ancora quel suo sguardo un po' imbarazzato e un po' sornione: " Paolo Scotti, l'uomo che ha 'inventato' il ricamo industriale su abbigliamento in Italia!!! "

Gianni Bessegato
Tessilservice Srl – Quinto di Treviso (TV)

Prima che ZSK divenisse tale, poco dopo la ripresa economica che caratterizzò l'Italia nel dopoguerra, imparammo a conoscere la perseveranza e la tenacità di un rappresentante Zangs particolarmente motivato: si trattava di Paolo Scotti.

Tra i tanti aneddoti che potremmo raccontare, accomunati anche dalla passione per i motori, ci sembra giusto ricordare l'impegno che mise l'allora giovane Sig. Scotti nel venderci la prima macchina marchiata Zangs: un obiettivo frutto di innumerevoli trasferimenti da Milano a Bondeno, formato da centinaia e centinaia di Km che lo portarono ad ottenere quello che voleva.

Da allora, il rapporto con Paolo è sempre stato splendido: disponibile, veloce e risoluto, tanto da permetterci di trovare accordi commerciali anche solo attraverso una semplice telefonata, nella quale andava a confluire tutta la fiducia e la stima cresciuta negli anni.

Paolo Cappelli
Cappelli Ricami Srl – Bondeno (FE)

We entered the world of work and entrepreneurship thanks to Mr. Scotti, who in 1997, when banks did not provide financing for new business, he believed in us by granting us credit and allowing us to start our business as embroiderers. We still remember, when in a difficult period, he came to us in the evening of 23th December to help us preparing the paperwork for tax advantage.

He was our mentor, both for work and personal advice.

What impressed us about him was when he congratulated us on our activity and made us feel important, even when we were just small embroiderers at the beginning of our business.

Dario Ardizzone
A.B.C. CONFEZIONI E RICAMO SNC – Tronzano Vercellese (VC)

Siamo entrati nel mondo del lavoro e dell'imprenditoria grazie al Sig. Scotti, che nel 1997, quando le banche non davano finanziamenti per nuove imprese, lui ha creduto in noi concedendoci credito e permettendoci di iniziare la nostra attività di ricamatori. Ricordiamo ancora, quando in un periodo di difficoltà, venne da noi la sera del 23/12 per aiutarci a preparare le pratiche per ottenere un'agevolazione fiscale.

Era il nostro mentore, sia per consigli lavorativi che personali.

La cosa che ci colpiva di lui erano i complimenti che faceva alla nostra attività facendoci sentire importanti, anche quando eravamo solo un piccolo ricamificio agli inizi della nostra attività.

Dario Ardizzone
A.B.C. CONFEZIONI E RICAMO SNC – Tronzano Vercellese (VC)

In the arid working relationship and in all these years that I have dealt with Paolo, I have been able to appreciate the remarkable faculty of lightening with great touch and with great joy, perhaps ending up with a joke, the various labor disputes that normally take place even in the best families (because the ZSK in these 39 years is also a family for me)

We will miss you Paolo

Sauro Scuppa
Clary Ricami S.R.L. UNIPERSONALE

Nell' arido rapporto di lavoro e nei vari anni che mi sono relazionato con Paolo, ho potuto apprezzare la notevole facoltà di alleggerire con grande tatto e con grande allegria, magari finendo con una barzelletta, le varie controversie di lavoro che normalmente avvengono anche nelle migliori famiglie (perché la ZSK in questi 39 anni per me è anche una famiglia)

Ci mancherai Paolo

Sauro Scuppa
Clary Ricami S.R.L. UNIPERSONALE

"In over 30 years, a relationship of esteem had been created, I mutual believe, which went beyond the working sphere.

Paolo's visits, always welcome, involved my whole family.

Always jovial and optimistic, with him it was a pleasure to discuss, both in negotiations and in any other topic.

We remember his ability to be professional in work, always maintaining a pleasant irony. "

Favaro Fiorino
EMMEGI RICAMI Srl

"In oltre 30 anni si era creato un rapporto di stima, ritengo reciproca, che andava oltre l' ambito lavorativo.

Le visite di Paolo, sempre gradite, coinvolgevano tutta la mia famiglia.

Sempre gioviale ed ottimista, con lui era un piacere discutere, sia nelle trattative che in qualsiasi altro argomento.

Ricordiamo la sua capacita' di essere professionale nel lavoro, mantenendo sempre una piacevole ironia."

Favaro Fiorino
EMMEGI RICAMI Srl

We wanted to send a greeting to Paolo, we have known him for 30 years, he was the first person to believe in us, he has always believed in us and thanks to his help we have become the embroiderers we are.

The news of his death left a great void, he was a point of reference.

When he called us to visit us it was always a great pleasure to welcome him and to have lunch together, he always told us new jokes and there was talk of his great passion for watches.

He has always encouraged us to create new embroidery creations and to look for new customers; it was infact just last year we were able to acquire very important customers. When we closed these contracts, I looked up and I thanked him, because I'm sure he looked at me and I'm sorry I could not share with him our successes.

You have been and always will be like the North Star, a guide for us embroiderers.

He was a good, wise and very talented person, a successful entrepreneur but more than anything else he was a Sir with a capital "S", as there are no more.

We'll miss you.

Siracusa Andrea e Siracusa Salvatore
Idea Ricamo Srl

Volevamo mandare un saluto a Paolo, lo conosciamo da 30 anni, è stata la prima persona a credere in noi, ci ha sempre creduto e grazie al suo aiuto siamo diventati il ricamificio che siamo.

La notizia della sua scomparsa ha lasciato una grande vuoto, era un punto di riferimento.

Quando ci chiamava per venirci a trovare era sempre un grande piacere poterlo accogliere e poter pranzare insieme, ci portava sempre nuove barzellette e si parlava della sua grande passione per gli orologi.

Ci ha sempre spronati a creare nuove lavorazioni, a cercare nuovi clienti, e proprio l'anno scorso siamo riusciti a prendere clienti molto importanti, a contratti chiusi ho guardato su e l'ho ringraziato, perché sono sicuro che mi guardasse e mi dispiace non aver potuto condividere con lui i nostri successi.

Sei stato e sarai sempre come la stella polare una guida per noi ricamatori.

Era una persona buona, saggia e di grande talento, un imprenditore di successo ma più di tutto era un Signore con la S maiuscola, come non ne esistono più.

Ci mancherai.

Siracusa Andrea e Siracusa Salvatore
Idea Ricamo Srl

Contact Details

ZSK STICKMASCHINEN

Your Contact:

Mr. Walter Schreiber

email: walter.schreiber@zsk.de

SPRINT

New Magnetic Belt Frame



This new hoop for ZSK series SPRINT was developed for applications like ribbons, sashes, mattress handles, dog leashes, judo / karate belts, straps and many other similar products.

As a special feature, the frame is equipped with strong magnets for quick and easy clamping. The frame offers a maximum embroidery area of 90mm / 3.6" in depth and 200mm 7.9" in width. It can be used to embroider individual motifs or to pull through the material for longer designs.

Measuring scales are attached to the left and right for precise alignment.

In addition, we offer a helpful pull-out service table for the series SPRINT, on which, for example, rolls of material can be stored.

Parts

Magnetic Belt Frame

Part No.: 270.010.723

Service Table

Part No.: 360.010.913

Contact Details

ZSK STICKMASCHINEN

email: parts@zsk.de

400 / 495 Arm Spacing

Dual Orientation Hoop



Our valued supplier of plastic frames with the patented extra, ALLIED INTERNATIONAL, has sent us a new frame: A dual orientation embroidery hoop for ZSK embroidery machines with arm spacing 400mm and 495mm.

This versatile dual orientation hoop can be used both horizontally **and** vertically, depending on the sewing field and arm spacing of your embroidery machines!

The dual orientation feature allows you to use this extra large jacket back sized hoop with a wider range of garment sizes. This is essentially 2 hoops in 1!

The dual orientation hoop is part of the well-known remium Allied Grid-Lock series and offers an embroidery field of 300mm x 400mm / 12" x 16" or 400mm x 300mm / 16" x 12"

Parts

PAGL Dual Orientation Hoop

Part No.: 376.010.999

Contact Details

ZSK STICKMASCHINEN

email: parts@zsk.de



Legals

Editor (V.i. S. d. P.)

Holger Bien
ZSK STICKMASCHINEN GmbH

Magdeburger Str. 38 - 40
47800 Krefeld
Germany

Tel.: +49 2151 444 0
email: zsk@zsk.de
www.zsk.de

Contributions

We welcome your contribution to the ZSK customer magazine Carl, but please understand that we accept no liability for unsolicited manuscripts, data carriers and visual material.

Image Sources

Page 12/13	Esther Hoyer, Germany	Page 30/31	Albrecht Bender, Germany
Page 14/15	Material ConneXion, USA	Page 36/37	Reiner Knochel, Germany
Page 16/17	Material ConneXion, USA	Page 38/39	Reiner Knochel, Germany
Page 18/19	Pixel-Shot, Shutterstock.com	Page 48	Andrey Popov, Shutterstock.com
Page 22/23	Rühl Leder, Germany	Page 52	Vitordigitizing, Brazil
Page 24/25	Rühl Leder, Germany	Page 53/54	Vitordigitizing, Brazil
Page 27	Rühl Leder, Germany	Page 56 (top)	Nantex, Vietnam
Page 28/29	Albrecht Bender, Germany		

All other images are the property of ZSK STICKMASCHINEN.
No part of this publication may be reproduced without prior written approval of ZSK STICKMASCHINEN GmbH, Germany



COMING SOON!

SPEED **2020 rpm**

EMBROIDERY SPEED BEYOND THE KNOWN



ZSK STICKMASCHINEN
Embroidery Evolution Made In Germany

www.zsk.de



facebook.com/ZSK.Stickmaschinen



youtube.com/zskfilm



instagram.com/ZSK_Stickmaschinen