WILCOM®

EMBROIDERY STUDIO e4.5

Release Notes

e4.5 - Nov 2022

What's new in ES e4.5?

The release of EmbroideryStudio e4.5 is minor in terms of version number but major in terms of new features and benefits it provides Wilcom customers. The theme of this release is 'falling in love with embroidery again'. Let your creativity flow with the exciting new stitch types and effects. Sequins too have received a lot of attention in order to exploit the cutting edge sequin placement capabilities of the latest machines and controllers.

Note: This update is intended for installation with any released version (already installed) of ES e4.5. It contains all improvements up to this release plus any previous updates.

What's new in ES e4.5.8?

The ES e4.5.8 software update includes the following improvements…

Software hanging when sending designs to Stitch Manager

A problem has been reported in relation to the **Auto Exit** option in **Stitch Manager**. When the option is enabled and the design doesn't get to

Stitch Manager in time, EmbroideryStudio subsequently hangs. The problem has been rectified with the current update.

Related topics

◀ Setting up machines for Stitch Manager
◀ Send designs to Stitch Manager

Old EMB designs showing black thumbnails

A problem has been reported in relation to the display of old EMB designs created in ES V9 or ES 2006. These designs appear in **File Explorer** or **Design Library** as black thumbnails. (The problem does not affect designs created in later versions of EmbroideryStudio and saved as an older EMB version (2006).) The problem has been rectified with the current update.

What's new in ES e4.5.7?

The ES e4.5.7 software update includes the following improvements…

Design thumbnails on MACs with M-series chips

A problem has been reported with the display of design thumbnails on MAC computers with M-series chips. They are not appearing properly even after upgrading RAM. The problem has been rectified with the current update.

What's new in ES e4.5.6?

The ES e4.5.6 software update includes the following improvements…

Corrupted machine file user settings

A problem has been reported when viewing machine files in **File Explorer**. User settings – view options, screen calibration, etc – can become corrupted. As a result, user settings along with any machine connections setup for **Stitch Manager** are lost. The problem has been resolved with the release of ES e4.5.6.

What's new in ES e4.5.5?

The ES e4.5.5 software update provides the following improvements…

General improvements
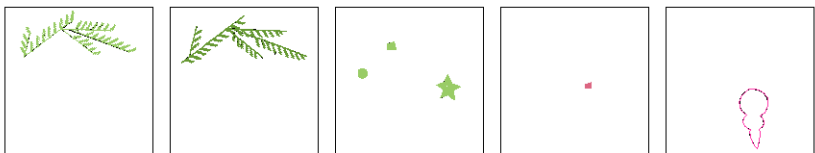
The ES e4.5.5 software update provides the following general improvements…

GEM thread chart

The GEM thread chart has been added to EmbroideryStudio and is available from the **Thread Charts** dialog.

Stop # returned to Color Film worksheet

Stop # information is useful when setting up threads on the machine. With the current update, Stop # information has been returned to the **Color Film** worksheet at top of the existing color slot number.

Editing issues

The ES e4.5.5 software update provides the following editing improvements…

Edit artwork using Paint disabled

A problem has been reported in relation to the 'Graphics > Edit Using >…' feature. This is being disabled on Windows 11 systems and the relevant option in the **Graphics** menu grayed out. The problem has been rectified with the current update.

Stitch generation in branched Column A

A problem has been reported in relation to stitch generation in branched Column A objects. Stitches with Raised Satin fill are not being generated in certain cases. The issue may also affect lettering objects utilizing Raised Satin. This problem has been resolved with the current update.

Branching producing unwanted trims/jumps

Another problem has been reported in relation to branching. EmbroideryStudio is producing unwanted connectors and trims. This problem has been resolved with the current update.
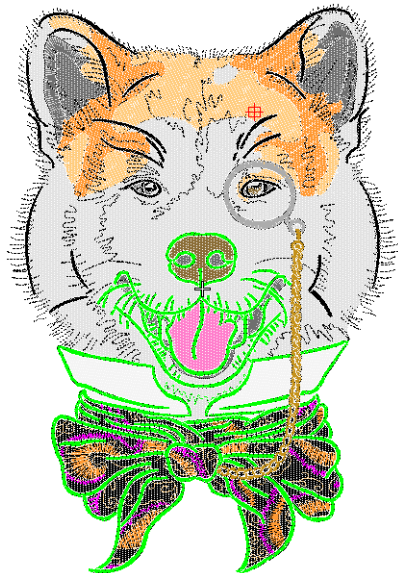
Offset objects in branched objects

A problem has been reported in relation offset objects in branched objects. The issue meant that the **Offset Outline** tool would fail to correctly recognize the outline of a branched object. With the current update, it now generates a much better outline:


Incorrect outlines
generated

Correct outlines
generated
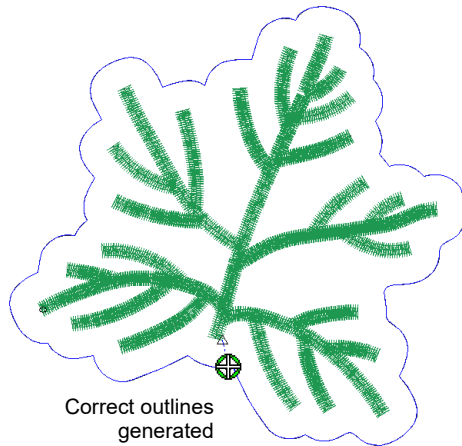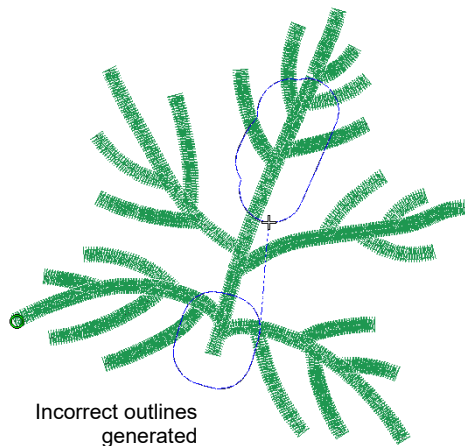
TBF machine file issues

The ES e4.5.5 software update provides the following TBF machine file improvements…

Color sequence in TBF files

A problem has been reported in relation to color sequence in TBF files. When exporting a design containing more than 72 color changes or stops, the color sequence is incorrect. This problem has been resolved with the current update which now allows up to 256 color changes. Note, however, TBF format has a limit of 256 color changes. If the design exceeds this, EmbroideryStudio will now display the following warning:
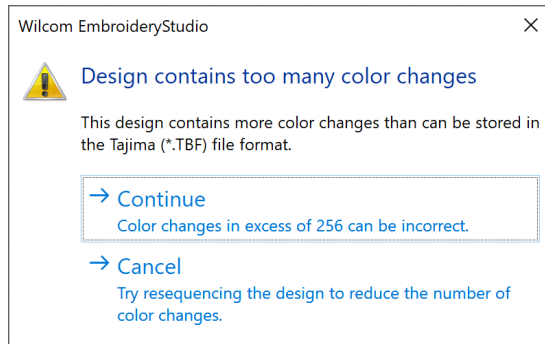

Tajima TBF connector color changes

A problem has been reported in relation to unwanted color changes in Tajima TBF files occurring half-way along the connector. The connector should appear in the color of the second object. This problem has been resolved with the current update.
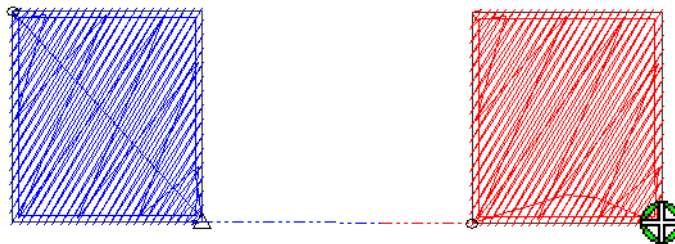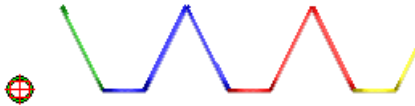

Missing data in TBF machine files

Two problems have been reported in relation to TBF machine files:

1. The software fails to insert trims between objects of different colors.
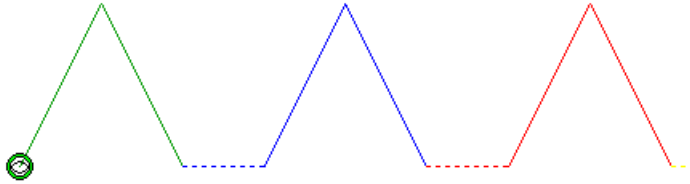
2. When loading a TBF file, the initial penetration is missing.

These problems have been resolved with the current update.

Team name problem with TBF machine files

A problem has been reported in relation to teamname designs utilizing TBF machine format. The issue here was that the exported machine file contained unwanted needle penetrations at each point where a stop was added between names. This problem has been resolved with the current update.

Other machine file issues

The ES e4.5.5 software update provides the following machine file improvements…

System crashes with JEF files

Problems have been reported when opening JEF files. System crashes occurred when invoking the **Open Options** dialog for JEF format designs, with or without object recognition activated. The problem has been rectified with the current update.

Trims in PES files

Problems have also occurred where additional jumps/trims are being inserted in exported PES files. This problem has been resolved with the current update.

A05 error sending designs with empty color code

A problem has been reported when loading U03 designs to new K-Series Barudan machines. The machine generates an A05 error and will not read

the design if the 'Code' field is left blank. This problem has been resolved with the current update.

Color #1 of 7

Color: Mix...

Code:
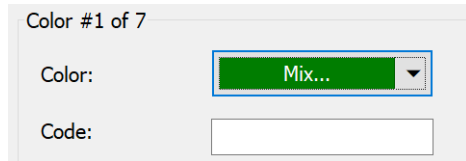
System errors

The ES e4.5.5 software update provides the following system improvements…

Problem with screen display

A problem has been reported in relation to screen display while running EmbroideryStudio. The screen may flicker or become disabled while remotely connected. The fault appears to happen randomly. This problem has been resolved with the current update.

Barcode scan failures

A problem has been reported in relation to barcode scan events utilizing EmbroideryConnect. The device generates an exception error and the barcode scan fails. This problem has been resolved with the current update.

Problems after leaving software idle for some time

Two problems have been reported in relation to leaving EmbroideryStudio idle for some time:

◀ A 'Sentinel LDK Error 85' may have occurred, after which the software crashes.
◀ A warning 'Unable to run software' may have occurred, after which the software is disabled.

Both problems have been resolved with the current update.

System crashes when sending designs to Stitch Manager

A problem has been reported when sending designs using Stitch Manager. This is causing software crashes on some systems. The workaround was to disable the auto-save function and delete all designs from the BACKUP folder. This problem has been resolved with the current update.

What's new in ES e4.5.4?

The ES e4.5.4 software update provides the following improvements…

Editing improvements

The ES e4.5.4 software update provides the following design editing improvements…

Moving Column C input nodes in Reshape mode

A problem has been reported in relation to Column C objects. In **Reshape** mode with the offset at 100%, moving the first input node becomes problematic. This problem has been resolved with the current update.
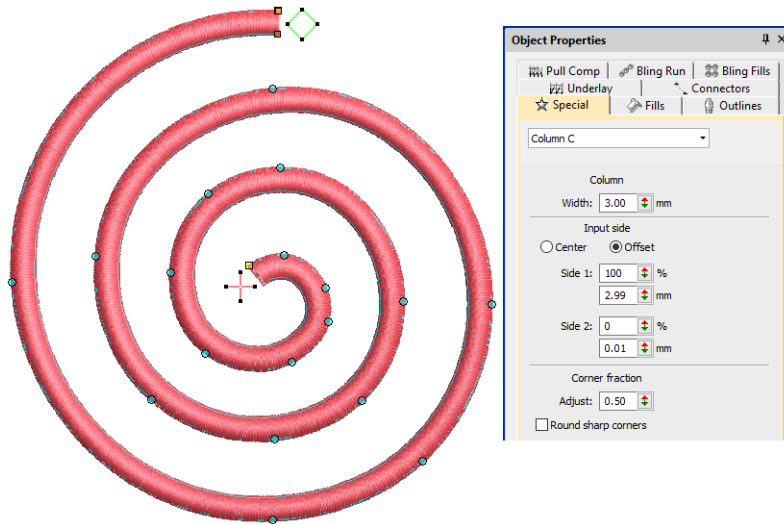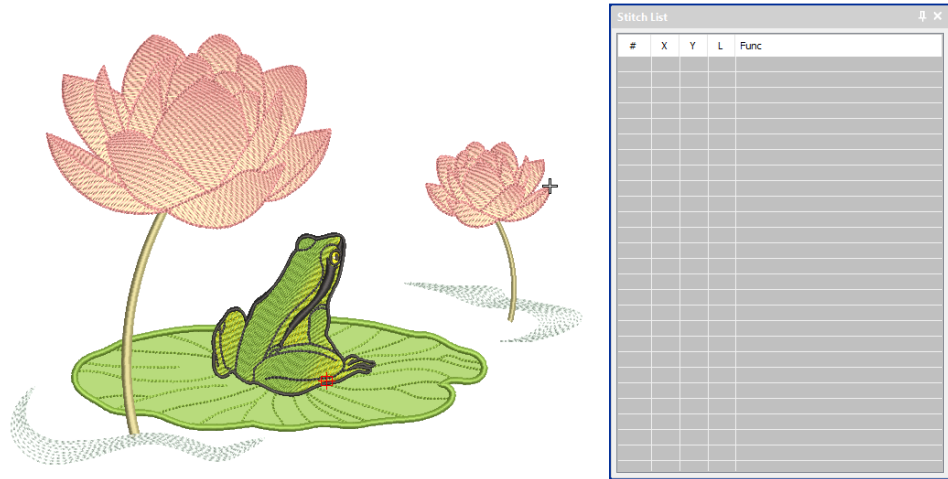

Related topics

◄ Reshape objects with reshape-nodes
◄ Reshape Column C objects

Stitch List display while digitizing

A problem has been reported with the **Stitch List** display. The list is not refreshing correctly while digitizing. This problem occurs when the

number of stitches is less than the number of rows displayed without scrolling. This problem has been resolved with the current update.
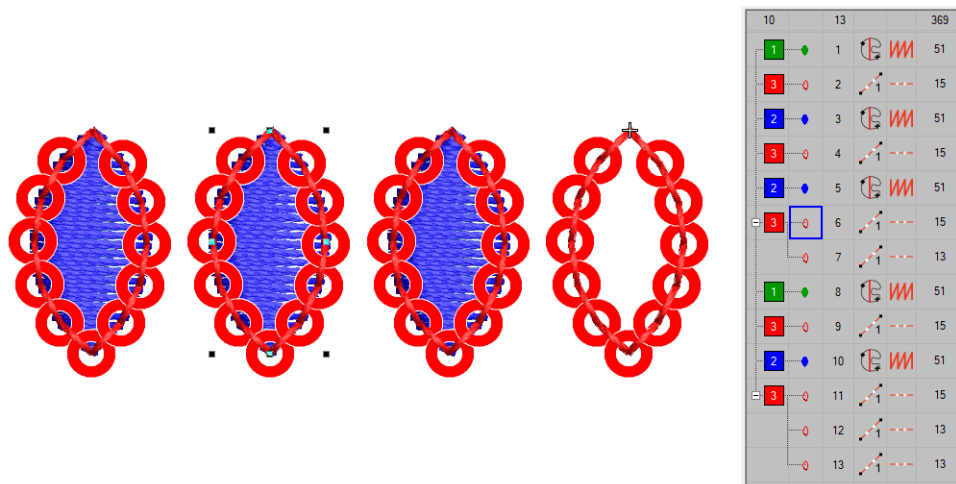

Related topics

◀ Select stitches with the Stitch List
◀ Edit stitches

Color sequence errors with duplicate twin-color objects

A problem has been reported when duplicating twin-color objects. Duplicate objects are misplaced in the color-object sequence. This problem has been resolved with the current update.

Related topics

◀ Sequencing embroidery objects

Start and end points in TrueView

A problem has been reported in relation to the visibility of start and end points in TrueView. At 100% zoom, Start and End points are slightly hidden. At large zoom factors, they disappear. This problem has been resolved with the current update.

Related topics

◀ Setting auto start & end

Sequin improvements

The ES e4.5.4 software update provides the following improvements in relation to sequins…

Changing machine formats while digitizing sequins

A problem has been reported when changing machine formats while digitizing sequin runs. This problem occurs after resizing a Sequin Run object or regenerating stitches after changing machine formats – e.g. Barudan FDR-II Twin Sequin. Pressing **Undo** can cause the object to disappear or crash the software. This problem has been resolved with the current update.
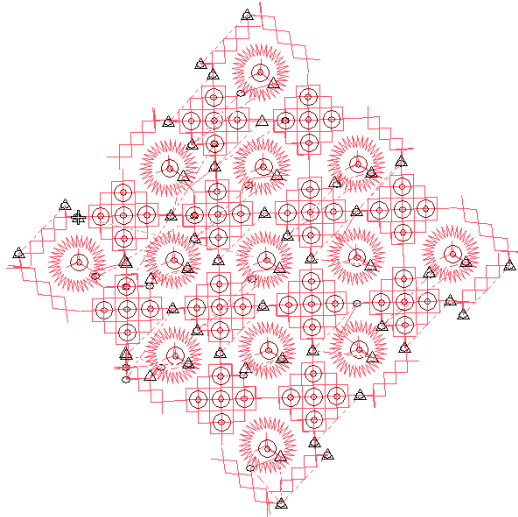
Related topics

◀ Embroidery machine formats

Unwanted trims added after sequins

A problem has been reported in relation to unwanted trims after sequin drops. When selecting a design and applying a sequin from the palette,

trims are added, stitches distorted, and stitching sequence broken. This problem has been resolved with the current update.
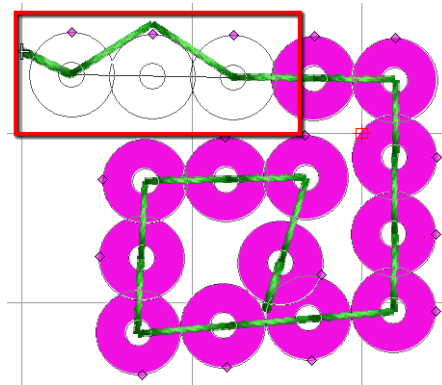

Related topics
- ◀ Visualizing sequin designs
- ◀ Editing sequin runs
- ◀ Editing sequin fills

Disappearing sequins when stitch editing

A problem has been reported when using **Stitch Edit** with sequin runs. Sequins disappear when stitches are reshaped. This problem affects sequin runs created with **Sequin Run Auto** as well as **Sequin Run Manual**. This problem has been resolved with the current update.
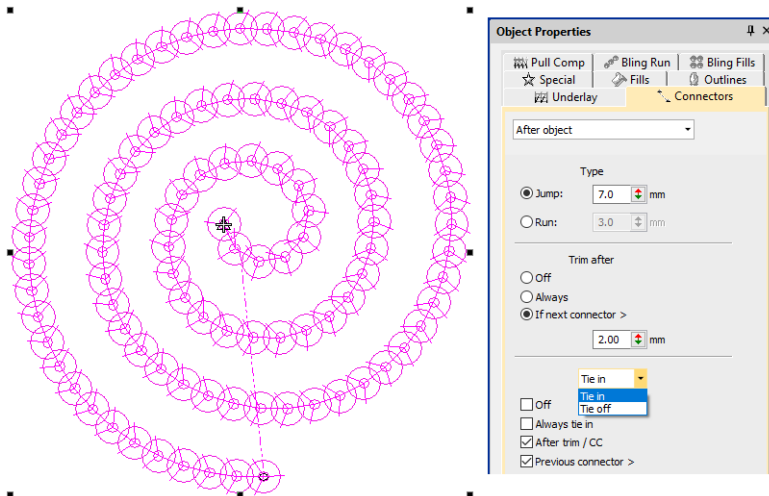
Assigning connector properties to Sequin Run objects

A problem has been reported when attempting to assign connector properties to Sequin Run objects. The **Object Properties** docker accepts new values but then reverts to the old ones. This problem has been resolved with the current update.

PES file improvements

The ES e4.5.4 software update provides the following improvements in relation to PES files…

Unwanted stitches in PES designs

An intermittent problem has been reported when exporting to PES file format. The software sometimes adds stitch runs from the center of the design. While the unwanted lines don't appear in EmbroideryStudio, they appear in stitchout. This problem has been resolved with the current update.
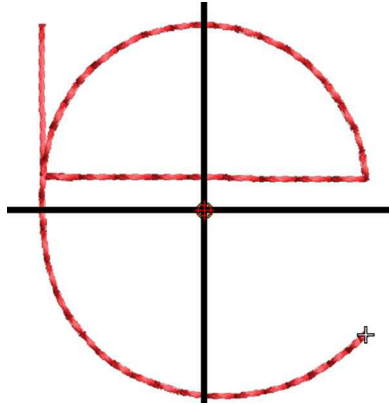
Unwanted penetrations at start of PES files

A problem has been reported with unwanted penetrations appearing at the start point of PES files. This occurs when the first stitch is within 12.7mm of the start point at the top-left of design extents. This problem has been resolved with the current update.

Related topics

◀ Machine files

◀ Exporting designs for machine

## Machine connection improvements

The ES e4.5.4 software update provides the following improvements in relation to machine connections…

Hoop lost after saving and reopening an EMB design file

In earlier versions, the hoop saved with an EMB design file could be lost after re-opening the design. As a result, the software fails to validate the

design size when the design is exported to machine formats. This problem has been resolved in e4.5.4.
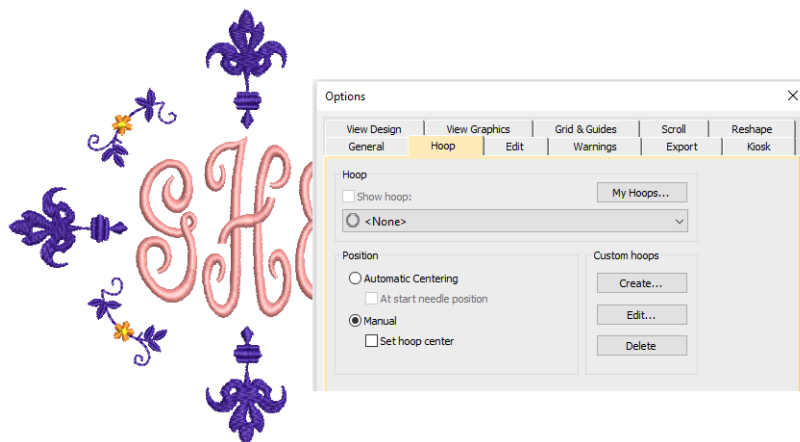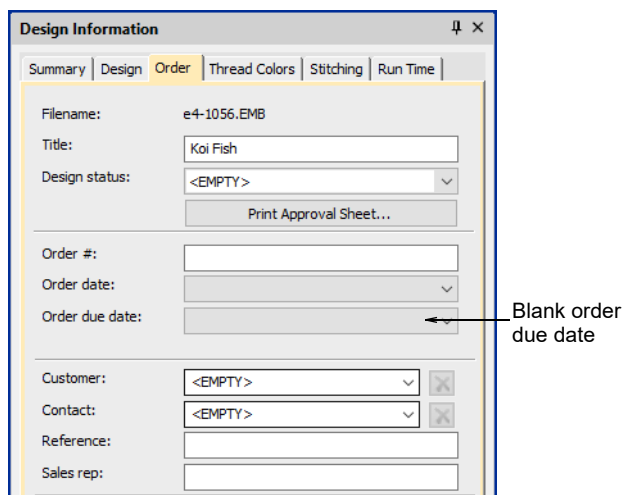

Related topics

◂ Machine files

◂ Exporting designs for machine

A05 error sending designs with empty 'order due date'

A problem has been reported when loading U03 designs to new K-Series Barudan machines. The machine generates an A05 error and will not read the design if the 'Order Due Date' field is left blank. This problem has been resolved with the current update.

Note: This is only an issue with Barudan's newest K-Series machines, which fully read all the extra data in the U03 file. Older Bardan models ignore the empty field.
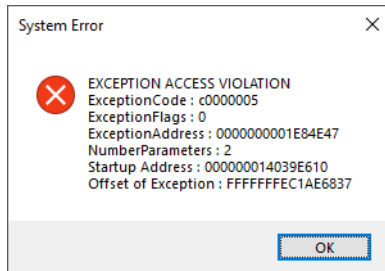
Related topics

◄ Sending designs to machine

Machine Manager crashes when invoking About box

Machine Manager crashes have been reported when invoking the **About** box. This problem has been resolved with the current update.
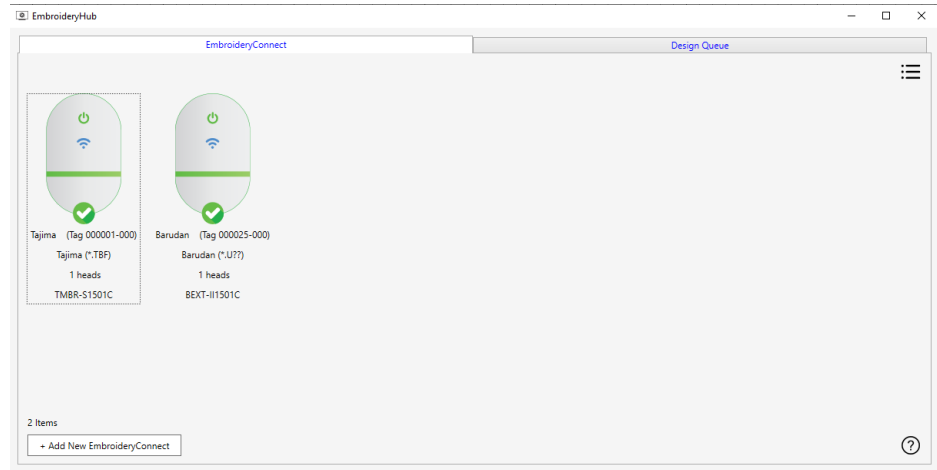

Related topics

◄ Sending designs to machine

EmbroideryHub crashes at network dongle user limit

A problem has been reported with EmbroideryHub while running it at the network dongle user limit. If too many instances of EmbroideryStudio are

running simultaneously, EmbroideryHub terminates without warning. This problem has been resolved with the current update.
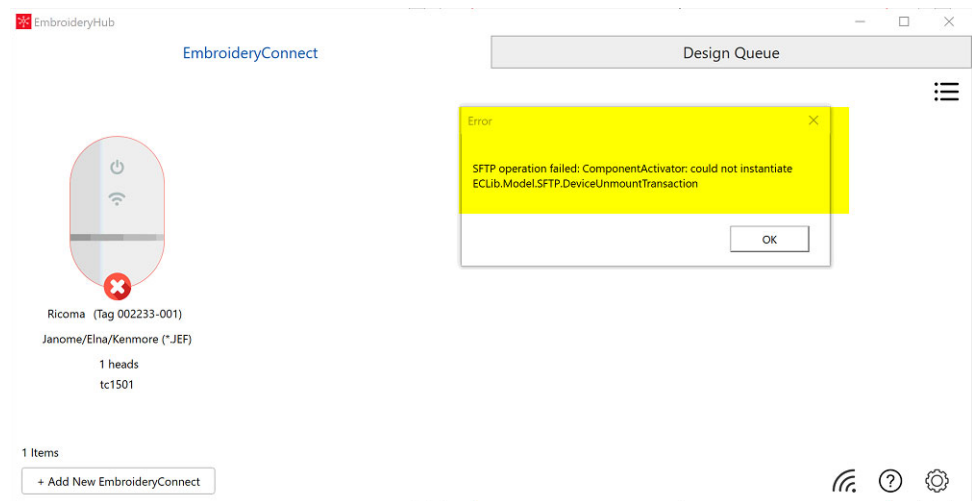

Related topics
◀ Network overview
◀ EmbroideryConnect setup

Failed SFTP operation in EmbroideryHub
A problem has been reported following the EmbroideryHub ES e4.5.1 R2 firmware update. EmbroideryHub fails to recognize the EC device. Deleting the device and setting up again appears to fix This problem but the device may fail to send designs. If it stops working, unplug, reconnect, and try again.

EC device firmware updates

The EC 1.1.0 firmware update (and all subsequent update files) is larger than the maximum device storage size of 32MB. This results in an error when trying to start the update process. This problem has been resolved with the current update.

⌿

Note: There is a new firmware update for the EC device. It is highly recommended to update your EC device firmware.

Lettering improvements

The ES e4.5.4 software update provides the following improvements to embroidery lettering…

Faux chenille fonts

It is possible to modify Stipple Stemstitch Fill settings for a dense coverage. Combined with a thicker thread type such as Madeira's Burmilana thread, it is possible to achieve a chenille effect. These dedicated fonts utilize this tested technique to create perfect faux chenille lettering. The latest release includes two new 'faux chenille' fonts – Vermicelli and Yale.

MS Mincho TTF conversion

A number of problems have been reported in regards to conversion of MS Mincho TrueType font. Some letters become bunched at the end of lettering objects. Where there is a mixture of Kanji and Kana (Katakana or Hiragana) characters, text spacing may be uneven. Uneven spaces can also produce overlapping text. Empty lines are ignored. These problems have been resolved with the release of ES e4.5.4.
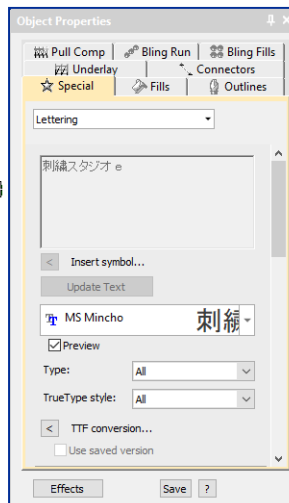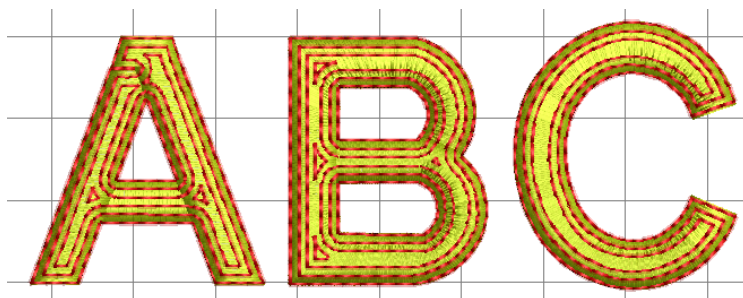

Related topics

◀ Converting TrueType fonts to embroidery

### Offsets/outlines around Block2 font

In earlier versions, unexpected results may occur when using offsets/outlines around Block2 font. This problem has been resolved with the current update.

New and updated thread charts

The ES e4.5.4 release includes many new and updated thread charts...

- New Glide thread chart
- New and updated Gunold thread charts – 16 in all
- New and updated Sulky thread charts – 15 in all
- Updated Setta Lumina thread chart
- Updated Robinson Anton SBP-10 Poly thread chart
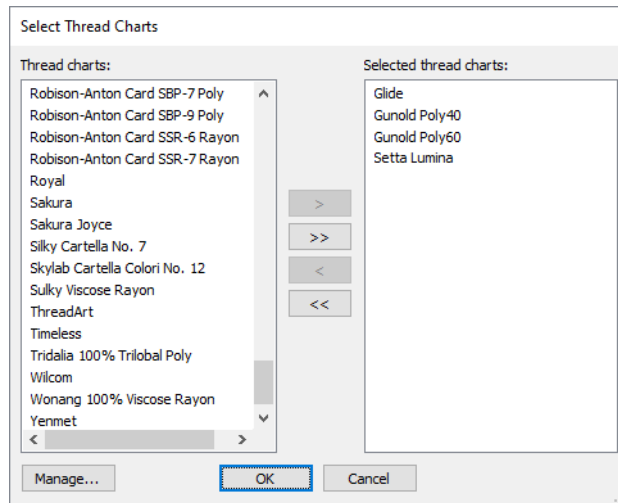
Related topics

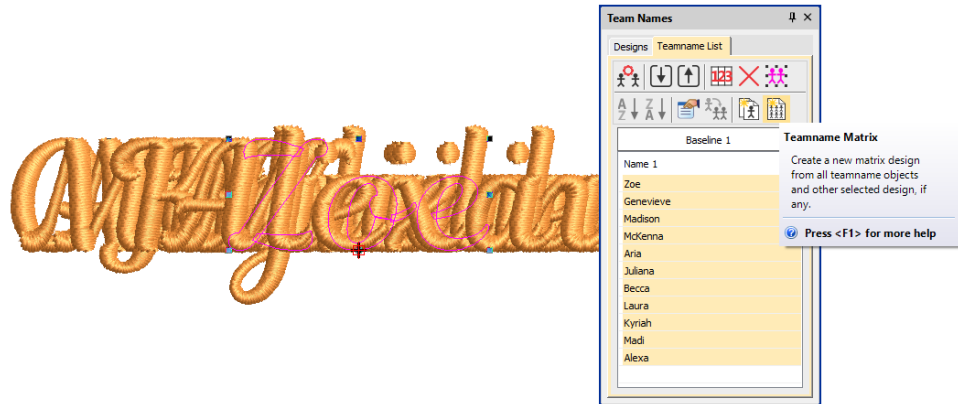- Assign thread colors

Other improvements

The ES e4.5.4 software update provides the following miscellaneous improvements…

Crash occurring with Teamname Matrix

An intermittent problem has been reported when applying **Teamname Matrix** to team names copied from the clipboard to **Quick Names**. This problem has been resolved with the current update.
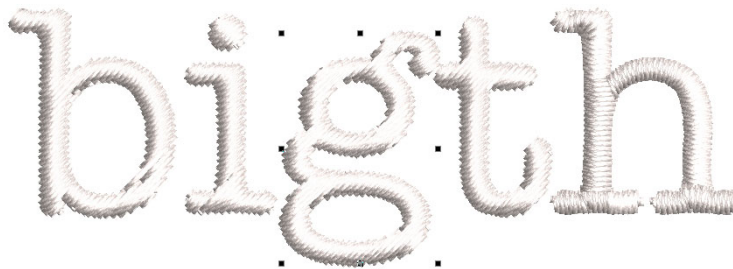

Related topics

◀ Create a matrix of designs

Auto-digitized stitch angles in complex fill objects

A problem has been reported in regards to **Auto-Digitizing** tools. Generated complex fill objects are frequently assigned a stitch angle of 45° rather than turning stitching. This problem has been resolved with the current update.
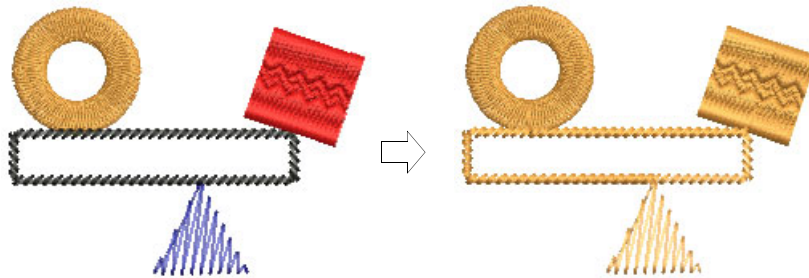

Related topics

◀ Auto-digitizing artwork

Branched objects containing Complex Fill

A problem has been reported where the software fails after generating stitches for branched objects containing Complex Fill. This problem has been resolved with the current update.
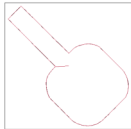
Related topics

◀ Automatic branching

Color film display when inserting Stops

A problem has been reported with thread color display in the **Color film** after inserting Stops. Additional boxes are added to the **Color Film**, one for each stop. This problem has been resolved with the current update.

Related topics

◀ Printing design reports

◀ Stop sequence options

Memory leaks

A problem has been reported in regards to 'memory leaks' causing sluggish system performance. This problem has been resolved with the current update.

What's new in ES e4.5.3?

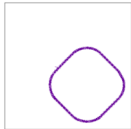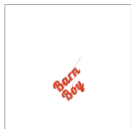The ES e4.5.3 software update includes the following improvements…

General improvements

The ES e4.5.3 software update includes the following general improvements…

Processing speed

EmbroideryStudio e4.5 provides significant speed improvements. Processing of large complex designs containing many objects is now up to 100 times faster. This is especially significant when processing large sequin designs.

Installation improvements

EmbroideryStudio e4.5 provides significant improvements when installing updates and upgrades in relation to:

◀ Merging of existing custom assets
◀ Merging of existing settings when choosing to merge earlier installed versions.

User-defined assets such as styles, bling, sequin palette settings, toolbar layouts, and so on, are now correctly carried across from ESe3 and earlier installations.

New and improved product elements

EmbroideryStudio offers a number of exciting new 'Elements' for Creativity and Specialty processes.

Element	1	2	3	4	5
Creativity					
1 ES Designing 2 ES Digitizing 3 ES Decorating 4 ES Editing 5 ES Lettering ● Included as standard ○ Modular 'element'					

Element		1	2	3	4	5
	Hand Stitch	Create hand-stitch effects which combine randomized spacing and stitch angles for a more organic look. Apply to satin, tatami, run, backstitch, and other stitch types.	●	○	○	–	–
	Maze Fills	Automatically fill large areas with double-spiral stitching that never crosses itself.	○	○	–	–	–
	Reef PhotoStitch	Convert photos into embroidered designs in seconds. Automatically fill large areas with open stitching reminiscent of a coral reef.	○	○	○	–	–
Productivity							
	EmbroideryConnect	EmbroideryConnect machine networking capability has had a complete overhaul in ES e4.5. See EmbroideryConnect networking for details.	●	●	●	●	●
Specialty							
	Sequins Advanced	Create embroidery files for single and twin-sequin dispensing machines. See Sequin improvements & new features for details.	○	○	–	–	–

1 ES Designing 2 ES Digitizing 3 ES Decorating 4 ES Editing 5 ES Lettering
● Included as standard ○ Modular 'element'

EmbroideryConnect networking

Wilcom's **EmbroideryConnect** network capability has just taken a giant leap forward with the new **EmbroideryHub** networking software and second generation **EmbroideryConnect** WiFi device. The concept

behind the EmbroideryConnect network is described by the following diagram…

Operator 'pulls' barcoded design to embroidery machine from design queue
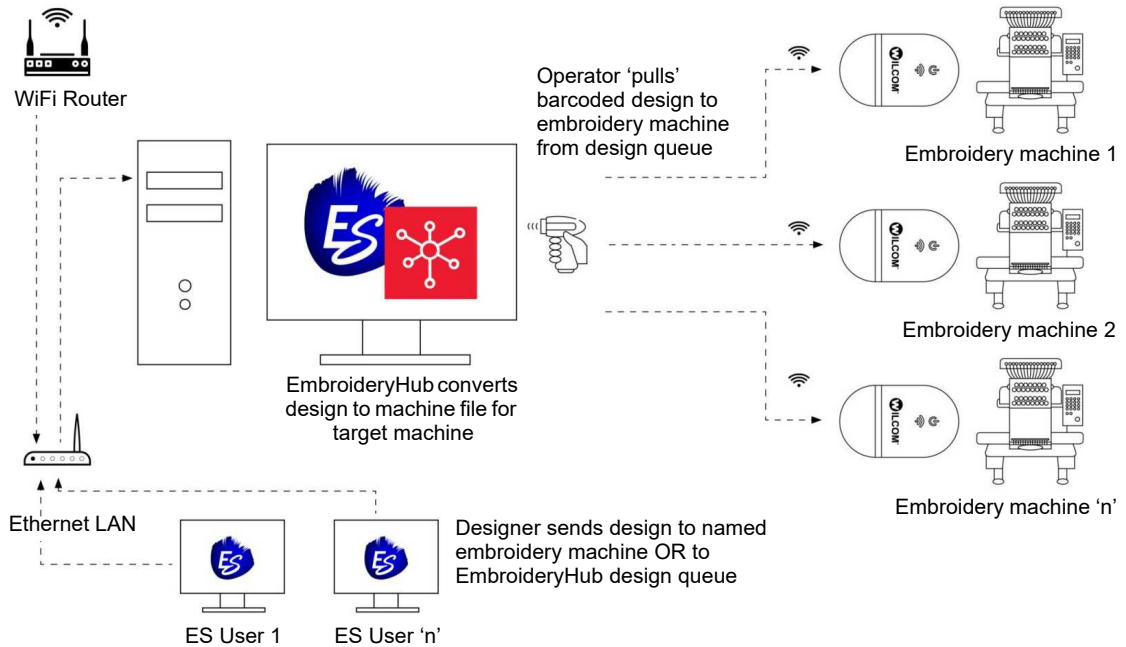
Embroidery machine 1

EmbroideryHub converts design to machine file for target machine

Embroidery machine 2

Embroidery machine 'n'

WiFi Router

Ethernet LAN

Designer sends design to named embroidery machine OR to EmbroideryHub design queue

ES User 1   ES User 'n'

EmbroideryHub

Quickly and easily send, scan, and queue your embroidery designs for production. EmbroideryHub software is included with the upgraded **EmbroideryConnect** element. See Machine Networking (Reference Manual) for details.

EmbroideryConnect

Now you can wirelessly manage and transfer embroidery designs from **EmbroideryHub** to the new second generation **EmbroideryConnect** WiFi device connected directly to your embroidery machines. Features include:

◀ Simple integration with your existing WiFi network.
◀ Color-coded LED light notifications.
◀ Barcode reader for super-fast design loading.

Sending designs to the EmbroideryConnect network

Use Standard > Send to EmbroideryConnect to send the current design to a named EmbroideryConnect device.

Use Standard > Queue Design to send the current design to the EmbroideryConnect design queue where they can be 'pulled' from the machine.

Once you have set up one or more EmbroideryConnect devices on your network, you have the choice of 'pushing' designs or 'pulling' them from the EmbroideryHub. The new **Send to EmbroideryConnect** button allows you to send a design to a named EC device. Alternatively, use the **Queue Design** to 'push' designs to a queue where they can be 'pulled' from the machine itself. See Sending designs to EmbroideryConnect (Reference Manual) for details.

Stitching improvements & new features

The ES e4.5.3 software update contains some exciting new stitch effects, with an emphasis on a more naturalistic, organic style of stitching, placing it at the cutting edge of contemporary embroidery digitizing. New features are summarized as follows...

New Hand Stitch

Use Stitch Effects > Hand Stitch to create hand-stitch effects which combine randomized spacing and stitch angles. Can be applied to satin, tatami, run, backstitch, and other stitch types.

Tired of perfect machine stitching every time? Fashion trends sometimes favor a more organic look which is very hard to achieve with current design tools. With the new **Hand Stitch** effect, you can easily and intuitively create hand-stitch effects which combine randomized spacing and stitch angles. This powerful new stitch effect can be applied to a

variety of stitch types, including satin, tatami, run, backstitch, and others. See Hand stitch effect (Reference Manual) for details.
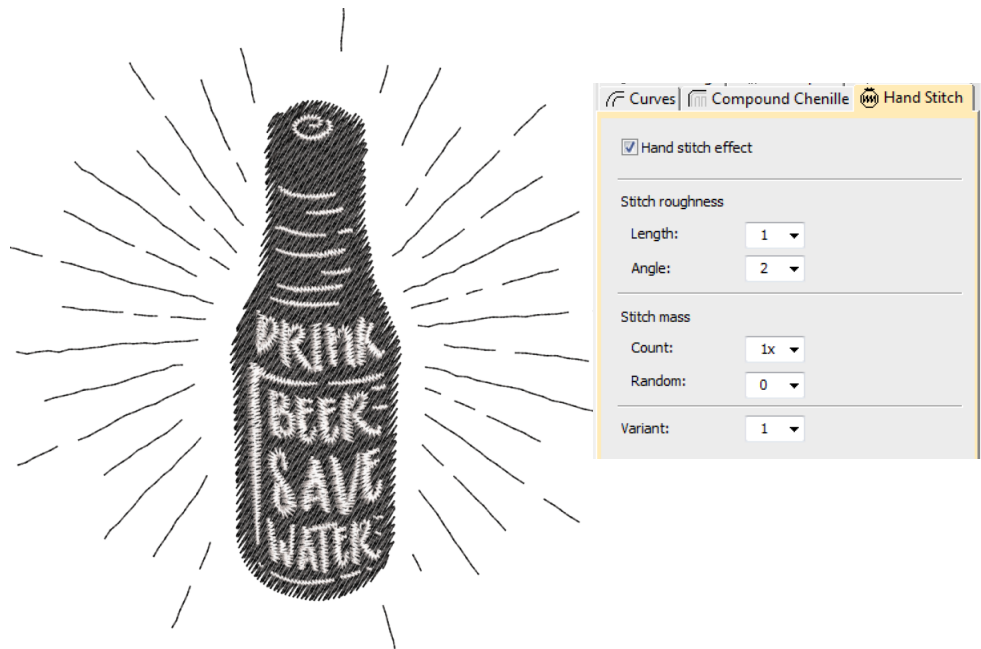
New Maze Fill

Use Fill Stitch Types > Maze Fill to create maze-like stitching that never intersects. Right-click for settings.

New **Maze Fill** offers a double-spiral stitch that **never** crosses or jumps over itself. Automatically fill large areas with this unique stitch type. See also Maze fills (Reference Manual).
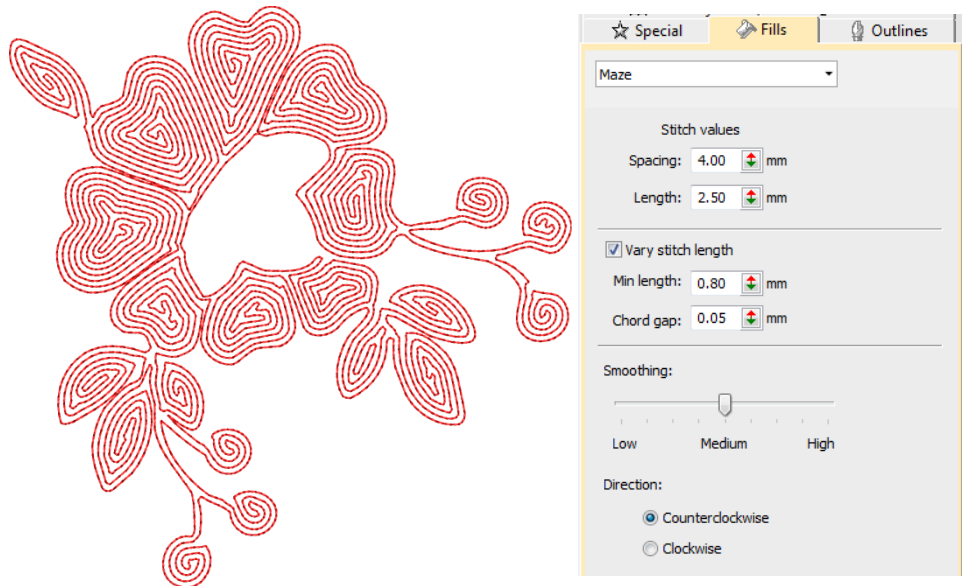
New Reef PhotoStitch

Use Auto-Digitizing > Photo Flash to create embroidery designs directly from photographs.

Use Auto-Digitizing > Reef PhotoStitch to turn photographs into a single embroidery field resembling a coral reef.

New **Reef PhotoStitch** expands on the **Photo Flash** auto-digitizing method to convert a photos into embroidered designs. Automatically fill large areas with open stitching reminiscent of a coral reef. Like **Maze Fill**,

this stitch never intersects itself. Adjust to the stitch resolution of choice. See also Auto-digitize with Reef PhotoStitch (Reference Manual).
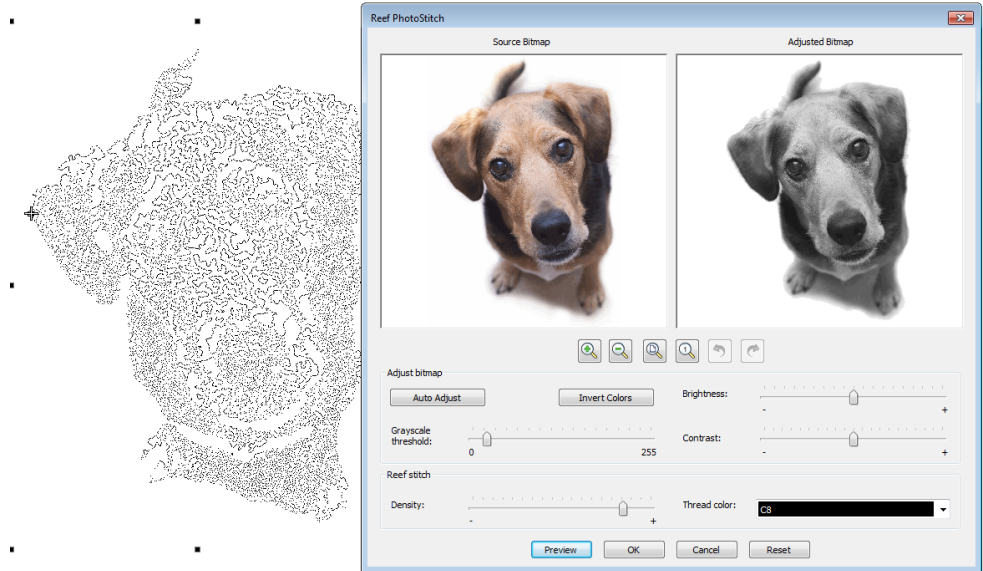
Auto-digitizing improvements

The ES e4.5.3 software update contains significant improvements in auto-digitizing capabilities.

Bitmap preparation

Bitmap preparation improvements have focused on the creation of logo-style designs for commercial decorators. Improvements include:

‹ Better sequencing
‹ Fewer color changes and trims

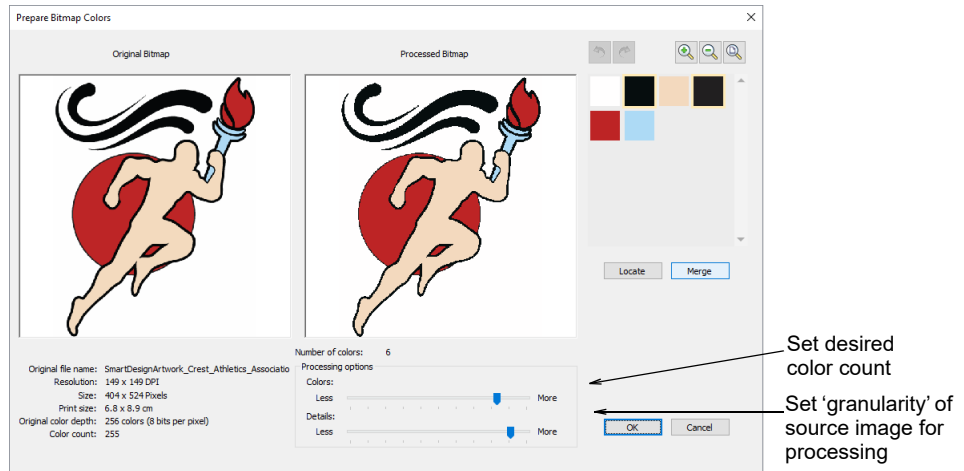◀ Improved color reduction

Set desired color count

Set 'granularity' of source image for processing

Stitch estimation

Again with and emphasis on the creation of logo-style designs for commercial decorators, ES e4.5.3 provides improvements in accurate stitch counts for quotes. This is to assist the growing trend (and cost) of outsourcing, as well as difficulties business owners and staff have in providing accurate estimates.

Sequin improvements & new features

The ES e4.5.3 software update also contains some exciting developments in sequin digitizing to exploit the cutting edge sequin placement capabilities of the latest machines and controllers. New features are summarized as follows...

Sequin stipple fill

Create variegated stipple fills automatically with single or multi-color sequin patterns. These can be reshaped and resized like any embroidery object. See Fancy sequin fills (Reference Manual) for details.
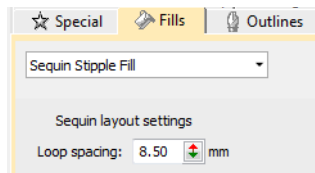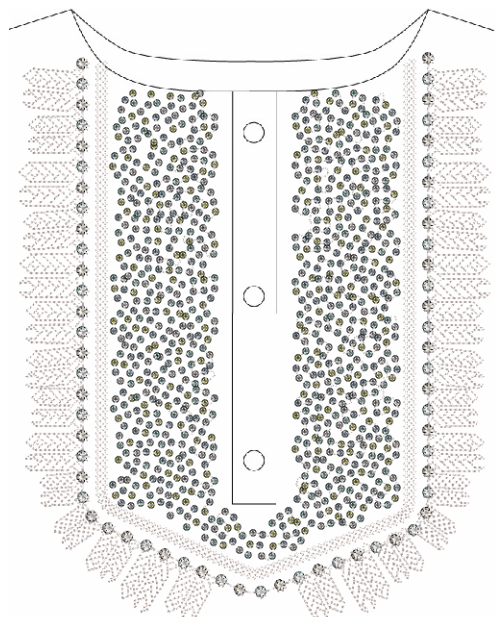
Flip sequins

> Use View > Flip Sequins to toggle between front and reverse sides of sequin runs and fills in reversible sequin designs. Define colors in the Sequin Palette Editor.

Flip sequins, also known as reversible sequins, are a color-changing effect which has become very fashionable. Beginning with children's wear, flip sequins have found a wide variety of applications, from reversible sequin shirts, pillow cases, bags, cases, note books, and more. Their use is very simple – swipe up or down to reveal the reverse side, with sometimes surprising effects. A simple pink sequined heart on a

plain T-shirt can suddenly turn purple at the touch. Reverse sequin use has also found its way into high fashion.

The software now allows you to define as many flip sequins as your machine will support, from as little as a single flip sequin, to 2-sequin, 4-sequin, 6-sequin or even 8-sequin devices. The **Flip Sequin** control allows you to visualize fills created with flip sequins. You can even design your own sequin and offset hole. See Visualizing sequin designs (Reference Manual) for details.
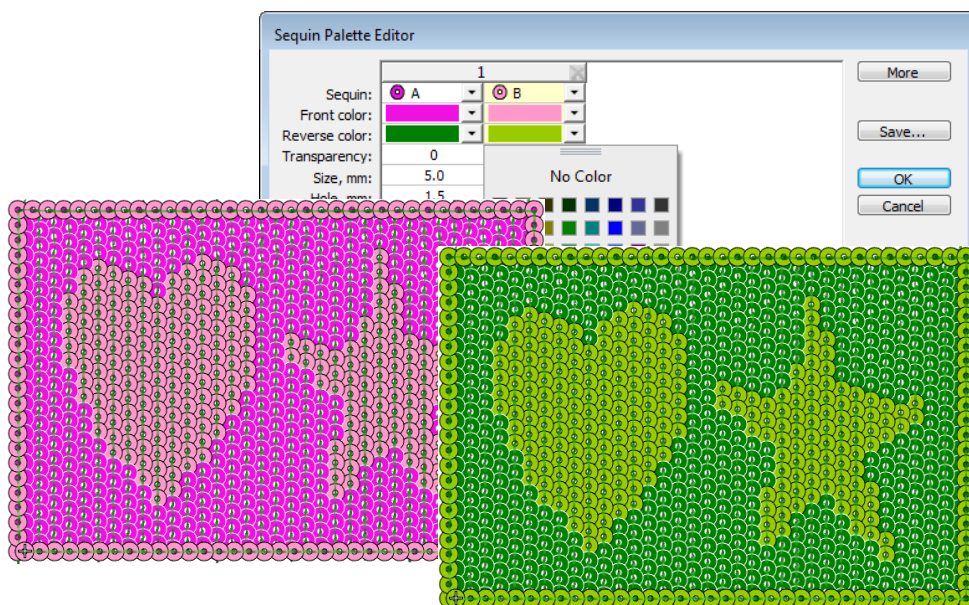
Multi-sequin support

EmbroideryStudio currently provides support for twin-sequin machines. However, Dahao machine controllers now support a much higher number of attached sequin devices. ES e4.5.3 provides multi-sequin support for

machines with 4-sequin, 6-sequin or even 8-sequin devices. See Setting up sequin palettes (Reference Manual) for details.

Click to add more devices

Define reverse colors and transparencies

Set number of sequins per device
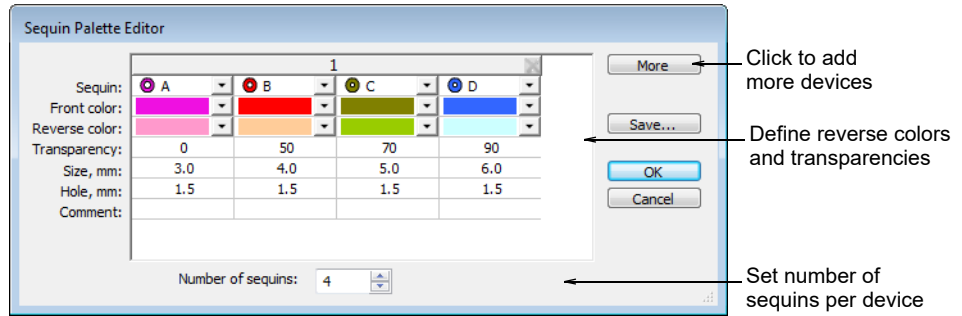
Machine capabilities

An increasing number of commercial machines can support various devices for additional decorative effects. The multi-sequin support now provided by ES e4.5.3 is designed to exploit the latest machine capabilities.

Multi-sequin dispenser

Double twin-sequin device with stacked sequin capability
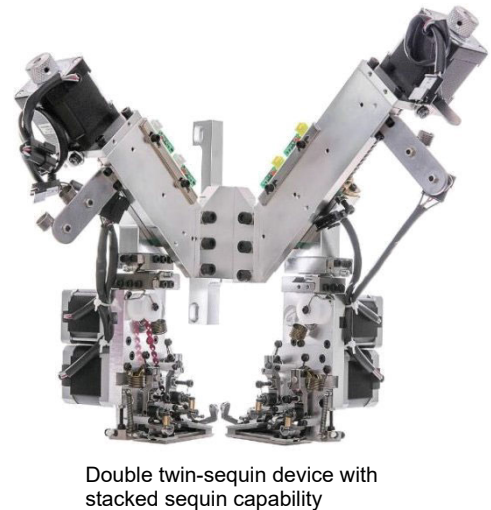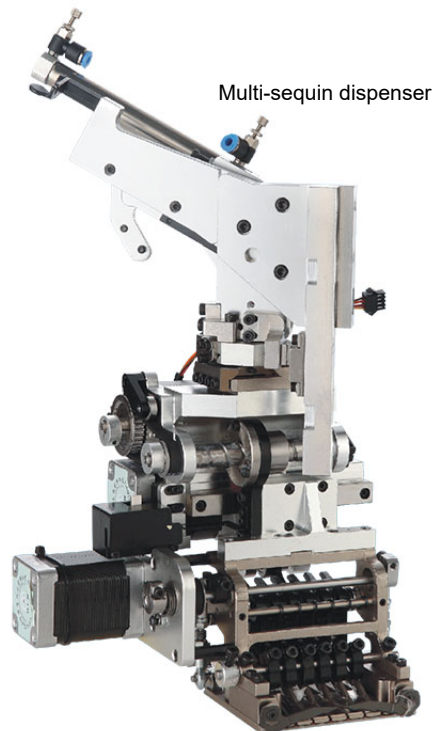
The main sequin device configurations include...

◄ Machines supporting one sequin per device. These feed only one sequin at a time.

◀ Machines supporting one or two devices per machine head, usually on first or last needles.

◀ Machines supporting twin-sequin devices with no stack feeding – e.g. Barudan FDR-II Twin Sequin, Tajima TBF, SWF Twin Sequin.

◀ Machines supporting twin-sequin devices or even double twin-sequin devices with stack feeding – e.g. Dahao.

◀ Machines supporting multiple sequins per device – four, six, eight, and possibly more sequins – with or without stack feeding.

Note: An increasing number of machines support multiple decoration types including sequins in combination with chenille, beading, cording, and others.

Machine formats

ES e4.5.3 supports the following sequin-capable machines:

Machine format	Sequin capability	File format
Barudan FDR-3	Twin	U??
Barudan FDR-3 Chenille Combination	Twin	U??
Barudan FDR-II Twin Sequin	Twin	U??
Barudan FDR-II Twin Sequin Chenille Combination	Twin	U??
Dahao	Multiple	DST (Dahao)
Schiffli	Single	ESS
SWF	Single	DST
SWF Twin Sequin	Twin	EBD
Tajima	Single	DST
Tajima TBF	Twin	TBF
ZSK	Single	ZSK

Sequin palette editor

In order to exploit multi-sequin machine capabilities, the **Sequin Palette Editor** has been updated as shown...
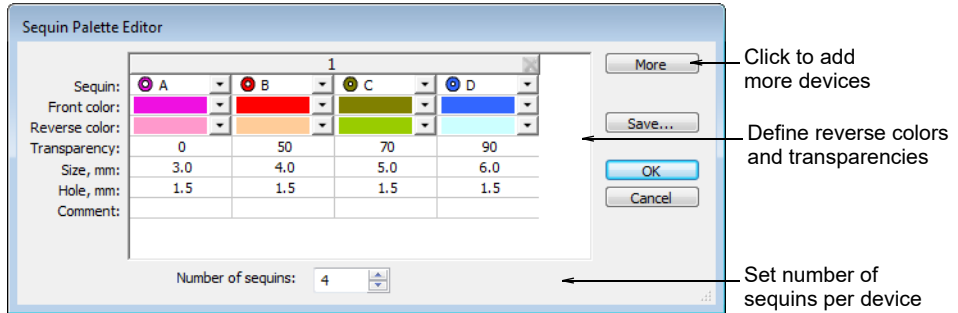
The following changes have been made:

‹ Up to 8 sequins per device can be specified.
‹ Colors can be defined for both front and reverse sides.
‹ A transparency factor from 0 to 90 can be defined for each sequin.

Set number of sequins per device. Sequin devices are normally attached to the first or last needle on the machine head. Sometimes both. (There may be multiple heads on the machine.)

Stacked sequins

|	
Use Sequin > Manual Sequin to digitize individual sequins.
Use Sequin > Sequin Run Auto to create a string of sequins along a digitized line according to current settings.
Use Sequin > Sequin Run Manual to manually digitize sequin-drops along a digitized line.

For those machines that support it, ES e4.5.3 allows you to define multiple sequin drops on the same needle. Fixing stitches are only

applied after all sequins have been dropped. See Stacked sequins (Reference Manual) for details.
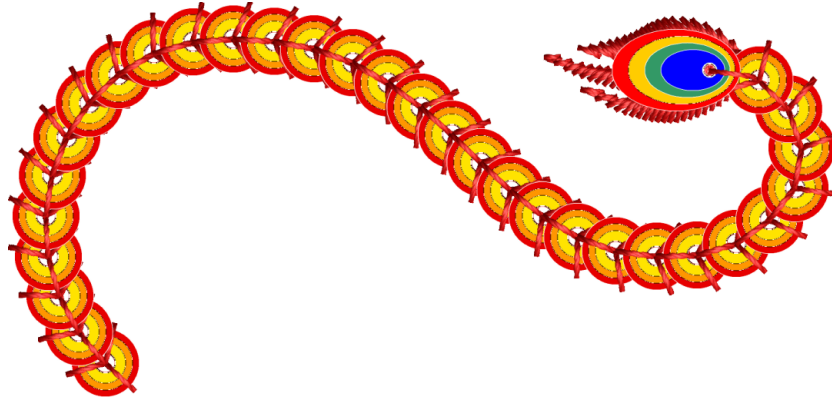
Stacked sequins can be used with **Manual Sequin** and **Sequin Run** digitizing methods. Permutations are automatically defined according to the sequin palette.
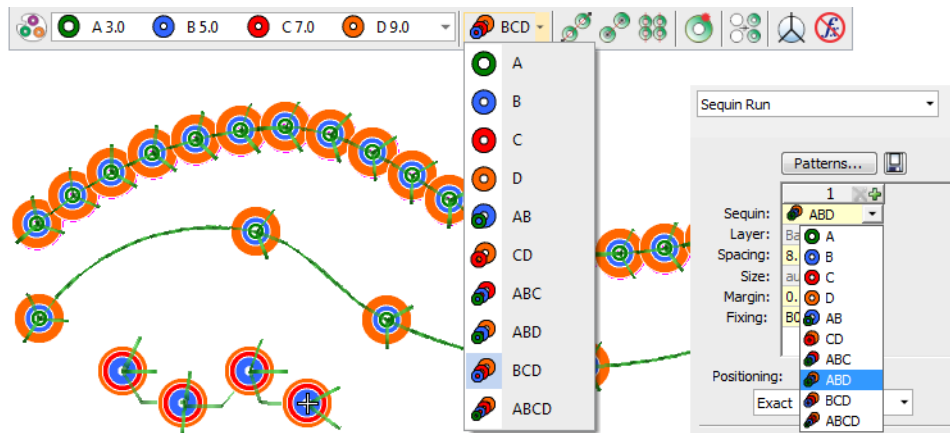
What's new in ES e4.5.2?

The ES e4.5.2 software update includes the following general improvements…

Installation crashes after accepting EULA

A problem was reported when running the ES e4.5 installation after accepting the 'Terms and Conditions'. The has been resolved with the release of ES e4.5.2.

Addition of Chinese Simplified interface

Simplified Chinese has been added to the main Wilcom ES e4.5.2 product interface.
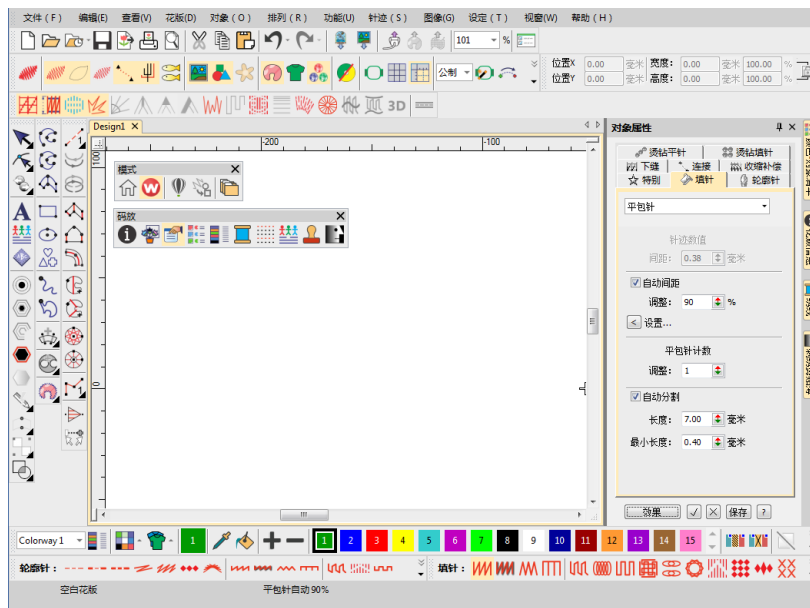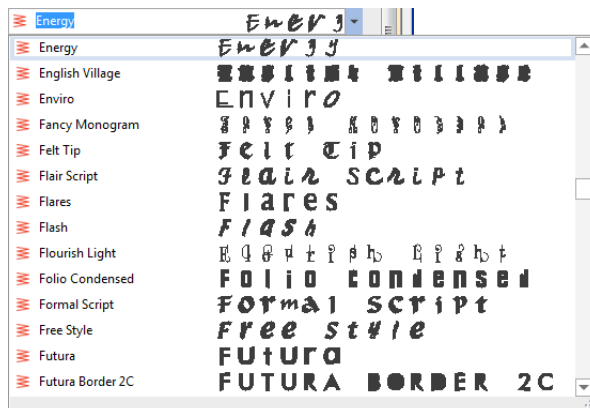

Setta Lumina thread chart

The Setta Lumina thread chart has been added to ES e4.5.2.

Font preview

There have been reports that the font preview is slow when opening the **Lettering** tab and scrolling through the font list. The problem has been resolved with the release of ES e4.5.2.
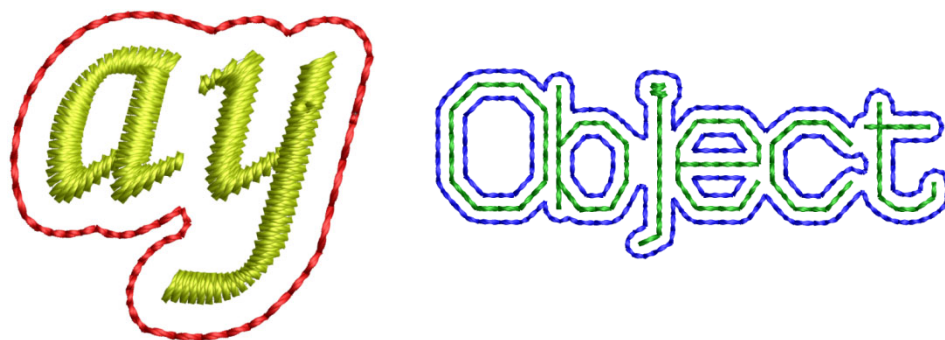
Offsets with lettering objects

There have been reports of offsets not being properly created in certain lettering designs, including objects created from simple outline fonts. The problem has been resolved with the release of ES e4.5.2. See also Generating outlines & offsets.

Break apart Japanese lettering

Problems have been reported when breaking apart Japanese lettering objects with the **Break Apart** tool. Native Japanese (ESA) fonts are being immediately broken into individual patches rather than characters. With the release of ES e4.5.2, lettering is correctly broken apart in stages – words, letters and then patches.
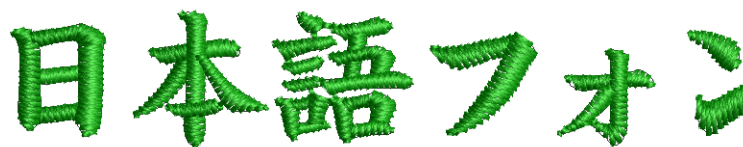
Regeneration of large manual sequin objects

Regeneration of large manual sequin objects can be very slow. When opening sequin machine files without object recognition, it can take a

long time to regenerate stitches. The problem has been resolved with the release of ES e4.5.2. See also Sequin Embroidery.
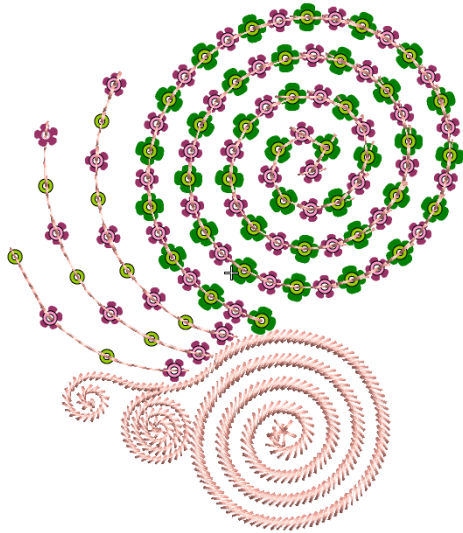
What's new in ES e4.5.1?

The ES e4.5.1 software update includes the following improvements…

General improvements

The ES e4.5.1 software update includes the following general improvements…

Integration of CorelDRAW 2019 & 2020

ES e4.5.1 is able to detect and integrate with CorelDRAW 2019 and CorelDRAW 2020.

Merging of custom assets from e4.0 and earlier to e4.5

Some custom assets and defaults are being lost when installing ES e4.5 over ES e4.0 and earlier versions. Asset classes affected include:

- Teamname template designs
- Teamname teams
- Kiosk designs
- Templates
- Applique fabrics
- Defaults
- Toolbar layouts
- Styles

This problem has been resolved with the release of ES e4.5.1. See also Asset Management (Reference Manual).

User interface languages

The user interface for EmbroideryStudio and EmbroideryHub is now available in the following languages:

- Czech
- Dutch
- German
- Spanish

- ◀ French
- ◀ Greek
- ◀ Italian
- ◀ Japanese
- ◀ Korean
- ◀ Portuguese
- ◀ Romanian
- ◀ Russian

Printed user guides

Printed user guides are now available from Amazon print-on-demand in the following languages:

- ◀ English
- ◀ Japanese
- ◀ French
- ◀ German
- ◀ Italian
- ◀ Spanish

New Beading Element

Element			1	2	3	4	5
	Beading	Provide support for beading devices. Four fixing methods are available: Upright, Laid, and Above or Below the run line.	○	○	–	–	–
1 ES Designing 2 ES Digitizing 3 ES Decorating 4 ES Editing 5 ES Lettering ● Included as standard ○ Modular 'element'							

With the release of this update, EmbroideryStudio e4.5 includes the new specialty **Beading** Element which provides support for beading devices, single and mulitple. See Bead Embroidery (Reference Manual) for details.
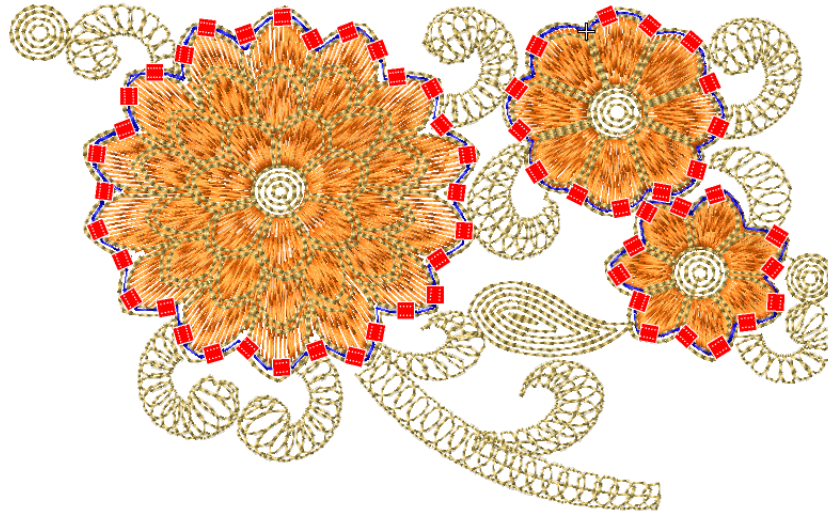

Fixing stitch support

Various layout methods are available on the machine. EmbroideryStudio supports the classic fixing stitch types – 'upright', 'flat', and 'sideways' – and others. See Bead fixings (Reference Manual) for details.

Upright

Flat

Sideways
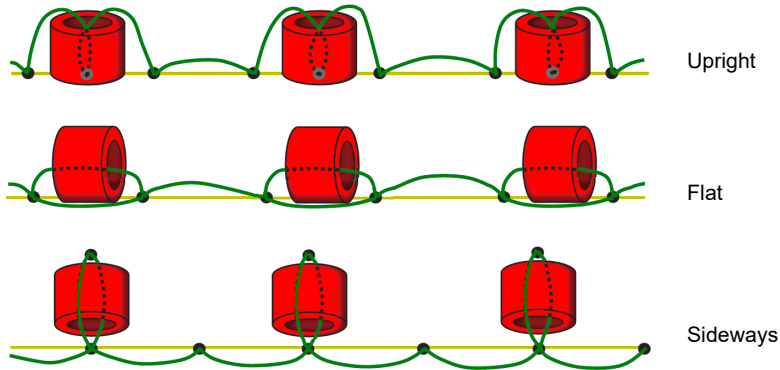
In addition to the classic fixing stitch types, the **Beading** feature includes a range of decorative fixing stitches for use in bead runs or individual bead drops. See Apply bead fixings (Reference Manual) for details.
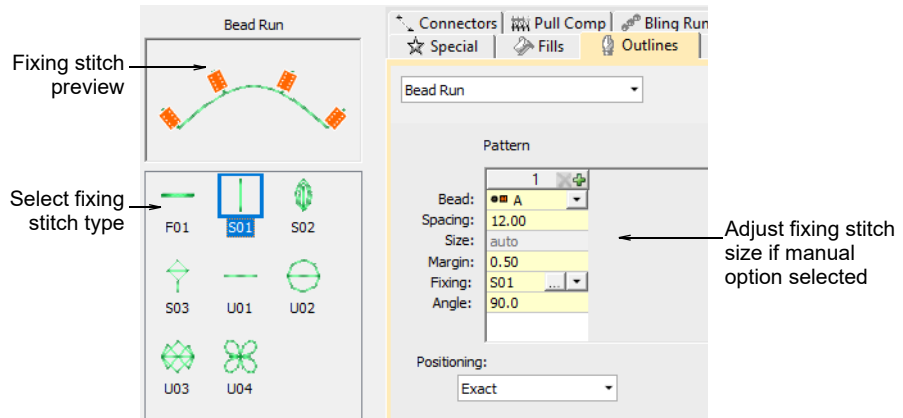
Tip: Before using the **Bead** tools, you need to choose a suitable machine format. Only some machine formats support beading – e.g. Tajima TBF, Dahao and SWF Twin Sequin. Refer to your machine manual for information about support for this type of decoration. See also Bead encoding & decoding (Reference Manual).

Dahao support

In support of Dahao's multi-sequin capabilities, EmbroideryStudio e4.5 provides the following support...

Quadruple sequins for Dahao machine format

The Dahao embroidery machine control unit is capable of quad sequins on a single needle bar. ES e4.5.3 now supports 'ABCD' on the first needle, and 'EFGH' on the last.

EmbroideryConnect networking

The ES e4.5.1 software update includes the following EmbroideryConnect improvements…

EmbroideryHub user interface languages

The EmbroideryHub user interface is now available in the same languages as EmbroideryStudio e4.5.

New shortcut keys for EmbroideryConnect icons

> Use Standard > Send to EmbroideryConnect to send the current design to a named EmbroideryConnect device.

> Use Standard > Queue Design to send the current design to the EmbroideryConnect design queue where they can be 'pulled' from the machine.

Shortcut keys have been added to support the new EmbroideryConnect icons:

◀ Send to EmbroideryConnect: **Shift+Alt+S**
◀ Queue Design: **Shift+Alt+Q**

### 'Space Available' for EC device sometimes shows 0MB

In some cases, when sending a design to an EC device, EmbroideryStudio e4.5 erroneously reports 0 MB available. This problem has been resolved with the release of ES e4.5.1.

Digitizing improvements

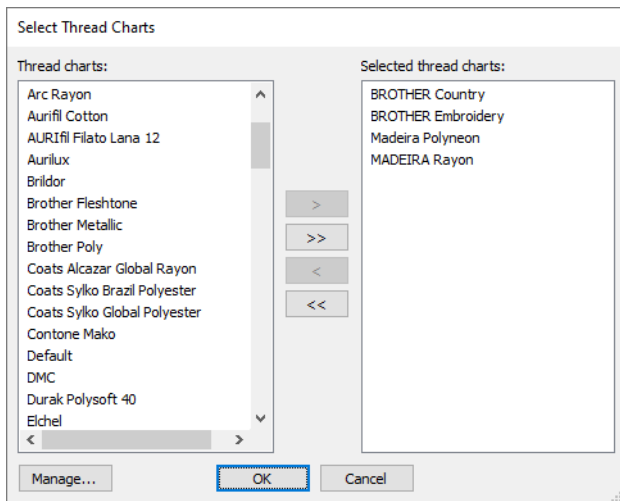The ES e4.5.1 software update includes the following digitizing improvements…

Outlines & offsets with vectors

The **Outlines & Offsets** feature now works with vector objects.
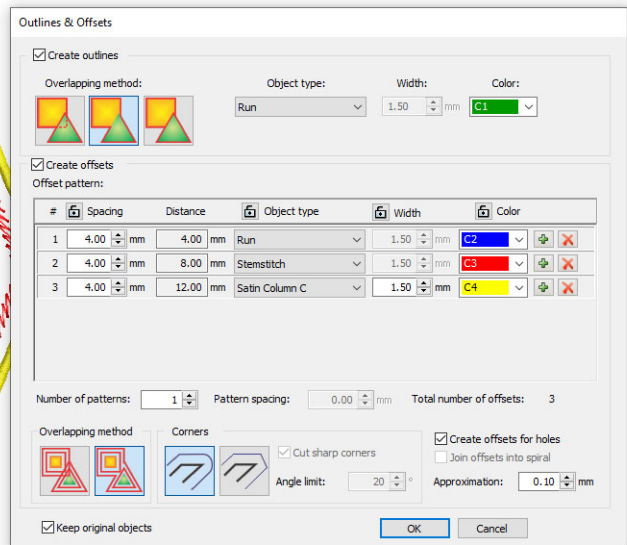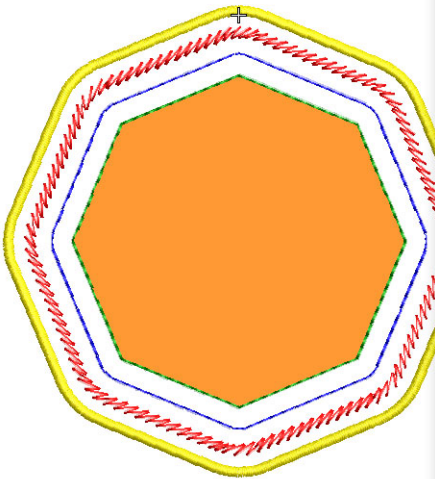
New thread charts

With the release of ES e4.5.1, four new thread charts are included – Madeira Polyneon, Madeira Rayon, BROTHER Country, and BROTHER Embroidery.

Thread chart colors unexpectedly turning to red and black

Problems have occurred in EmbroideryStudio e4.5 with thread chart colors turning to red and black shades following editing operations. This seems to have affected two Madeira charts in particular. The problem has been resolved with the release of ES e4.5.1.
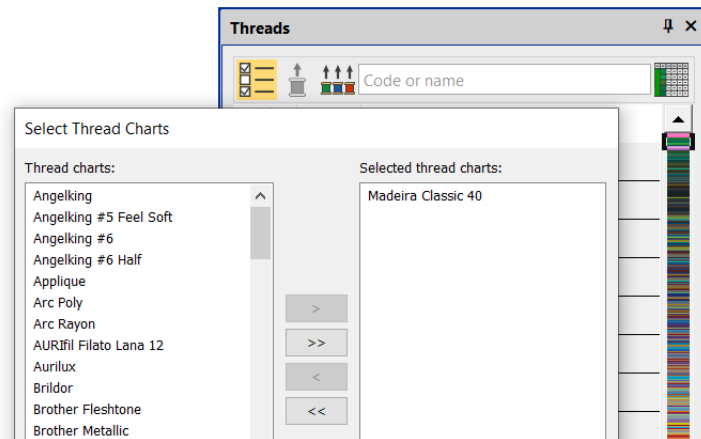
Auto-digitizing improvements

The ES e4.5.1 software update includes the following auto-digitizing improvements…

Branching of single objects in Smart Design

When using **Smart Design**, resultant single objects are being auto-branched unexpectedly. This problem has been resolved with the release of ES e4.5.1.

Segmenting of backgrounds in Smart Design

With certain designs, large backgrounds are being segmented unexpectedly, irrespective of values set in the **Smart Design** dialog. This problem has been resolved with the release of ES e4.5.1.

Unwanted stitch angles

Unwanted stitch angles are being added to some auto-digitized designs. This problem has been resolved with the release of ES e4.5.1.

Lettering improvements

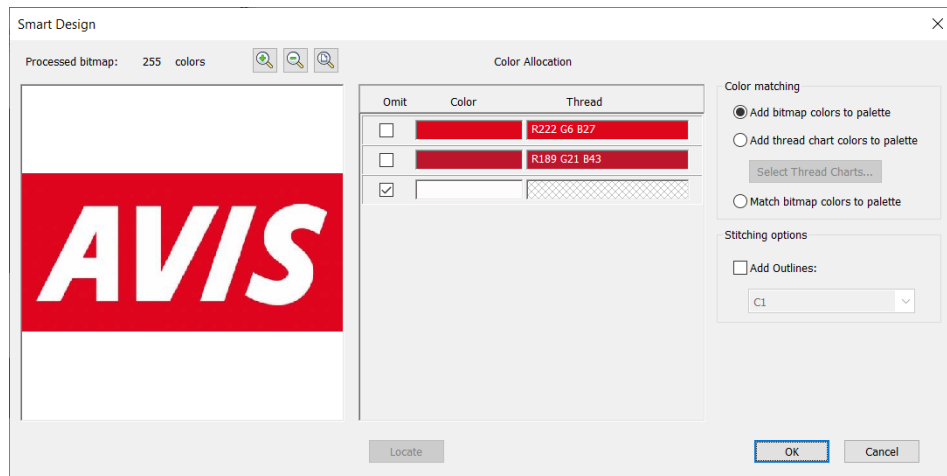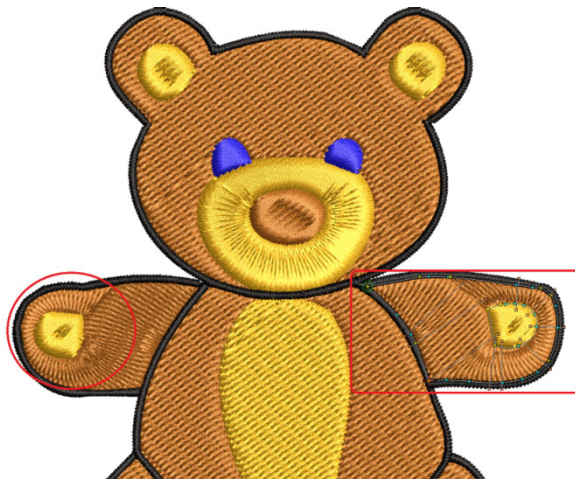The ES e4.5.1 software update includes the following lettering improvements…

Support for complex text layouts

ES e4.5.1 now provides support for 'complex text layout' (right-to-left) and non-European scripts including Arabic, Hebrew, and Thai.

With 'RTL languages' like Arabic and Hebrew, the order of characters is correctly rendered in the generated lettering objects. Complex text rendering is also supported in other languages which include combined characters. See also Select embroidery fonts (Reference Manual).

Ten (10) new fonts packaged

Ten (10) new fonts have been packaged with the latest update. These include:

◀ Albert
◀ Bounty
◀ Gypsy
◀ Lila
◀ Pastille
◀ Python Script
◀ Scope
◀ Spatial
◀ Vivid Script
◀ Yama

Last used font name remembered

The **Create Letter** dialog now remembers and displays the last selected font name. This is a useful productivity enhancement when creating multiple sets of new letters. The same details no longer have to be unnecessarily re-entered. See Create custom letters (Reference Manual) for details.


Click to create new font
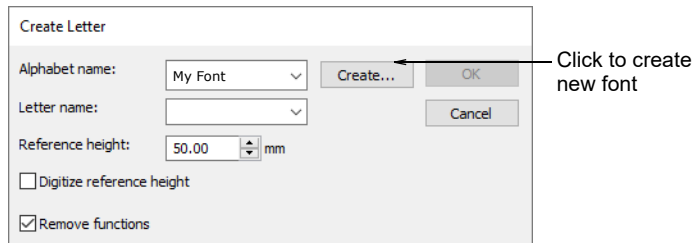
Editing names in Teamname List

Previously, when selecting a name in the **Teamname List**, it became editable. Now it remains highlighted and cannot be edited unless you double-click.

Double-click to edit
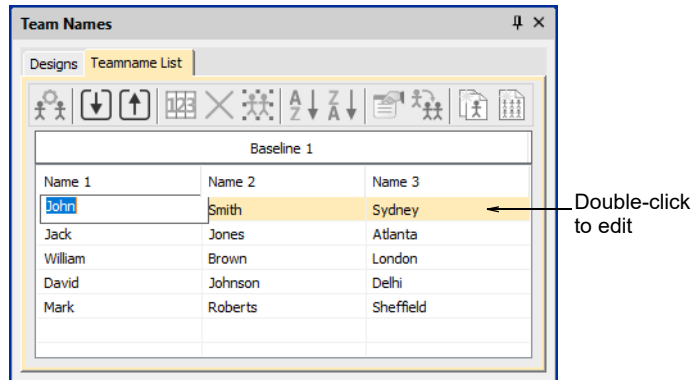
Changing stitch properties for lettering

With the latest release, you can preset object properties before adding members to your teamname list. This applies to both **Team Names** and other lettering objects. If you choose a fill that is not applicable to lettering, the system will default to the first applicable fill, usually Satin.


Preset object properties as preferred
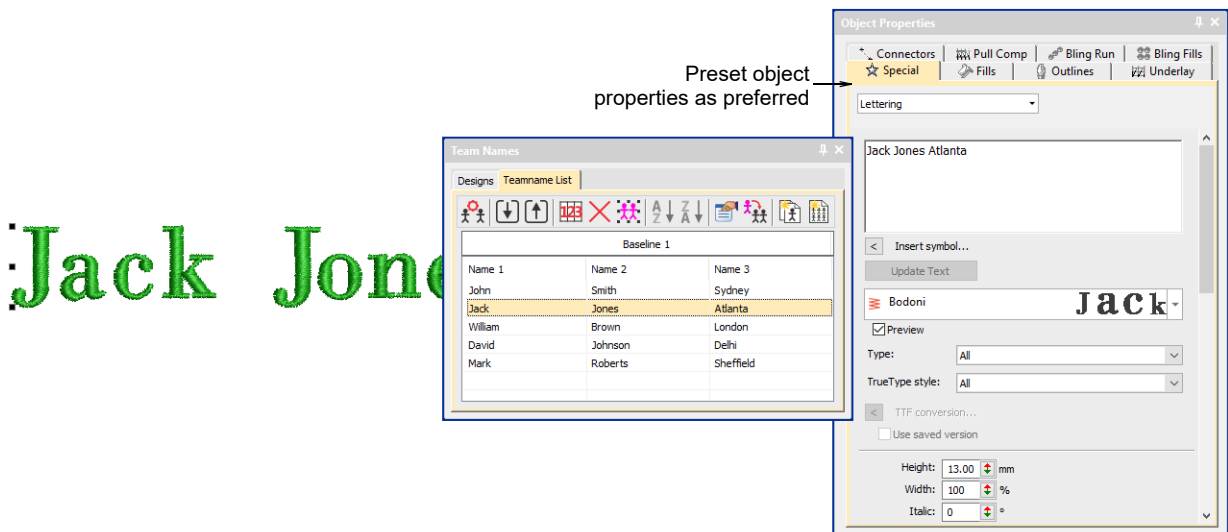
Sequin improvements

The ES e4.5.1 software update includes the following sequin improvements…

Multi-sequin export to machine file

Problems have occurred when exporting multi-sequin designs to DST file format for production. Multi-sequin objects are being exported with the one sequin type and same size sequin fixing stitch. This problem has been resolved with the release of ES e4.5.1.
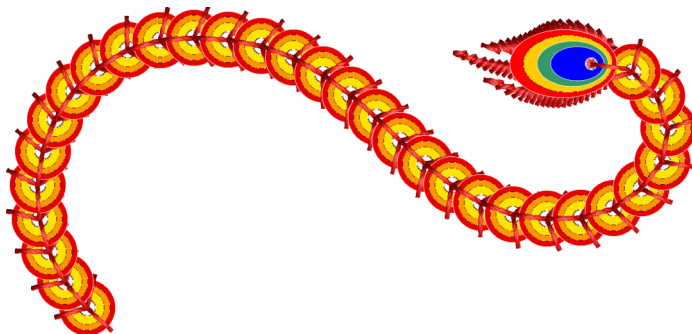
System & file improvements

The ES e4.5.1 software update includes the following improvements…

Unexpected crashes

Unexpected software crashes have occurred in EmbroideryStudio e4.5 when...

‹ Opening some DST, INB, and ESS designs
‹ Resizing certain EMB designs
‹ Using the **B** key to zoom onto selected areas.

The problem has been resolved with the release of ES e4.5.1.

PES file start and end points

A problem has been reported when outputting PES files from EMB. Auto start and end points are not being properly maintained, causing the design to be off center. This problem has been resolved with the release of ES e4.5.1.

SWF (EBD) file format

The Wilcom SWF file format has been updated to support the latest version of EBD. Accordingly, the SWF Twin Sequin machine format includes a new trim format setting. You can now output 'Trim' as 'Code'.

Format Trim as Code for EBD
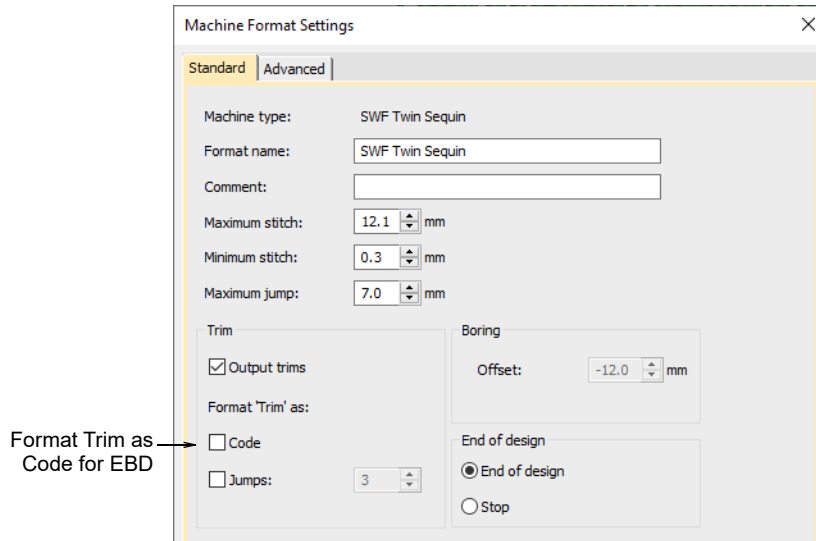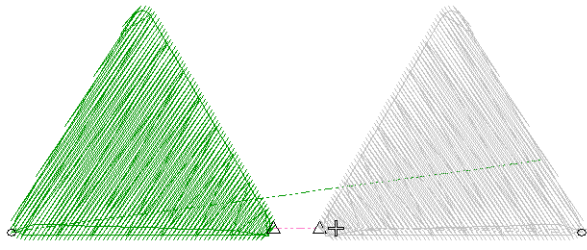
Auto-centering stitch cursor

Previously the stitch cursor always defaulted to the end of a design including start end connectors. With this release, the stitch cursor adjusts to the end of the last digitized object, not the auto-end point. If the object has a tie-off, the cursor jumps to the end of the tie-off instead of the beginning. All input methods behave the same way. Auto start and end symbols have been added – a green circle and a red cross. These are activated via **Options > View Design**.

Current cursor position

Auto start and end symbols on
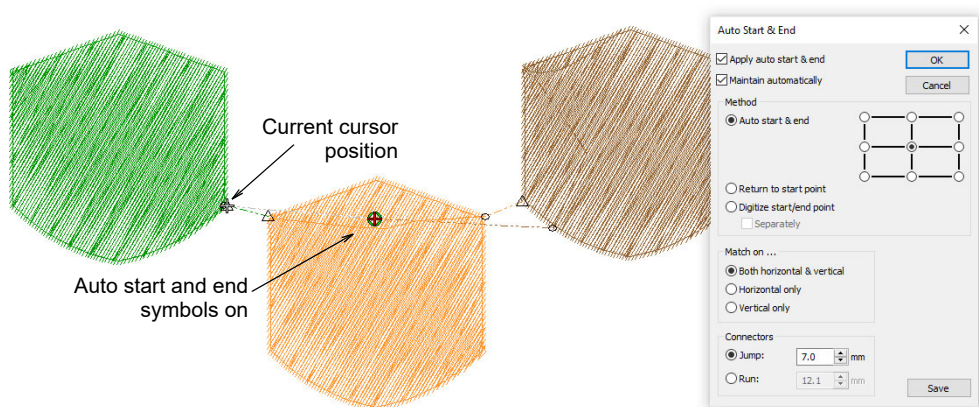
Jump functions in the Stitch List

When digitizing objects with large jumps, the **Stitch List** now correctly shows Jump functions.

#	X	Y	L	Func
515	0.78	1.03	1.29	
516	-0.09	-0.14	0.17	TieOff
517	0.09	0.14	0.17	(used)
518	-0.30	-0.40	0.50	(used)
519	0.30	0.40	0.50	(used)
520	-0.09	-0.14	0.17	(used)
521	0.00	0.00	0.00	Color (15) (empty)
522	6.39	-0.08	6.39	jump
523	6.39	-0.08	6.39	jump
524	6.38	-0.08	6.38	jump
525	6.38	-0.08	6.38	jump
526	6.38	-0.08	6.38	
527	-0.77	0.22	0.79	
528	-0.94	0.34	0.99	
529	0.94	-0.34	0.99	
530	0.77	-0.22	0.79	
531	-0.77	0.22	0.79	
532	-1.57	0.57	1.67	
533	-2.06	-0.06	2.06	