

LOCACRYSTAL · EDITION 2.0 · 2026

# LOCA Application Manual.

乐卡 · 水钻辅料应用手册

*A practical guide to applying rhinestone accessory materials to footwear, bangles, garments, and fashion accessories.*

把水钻辅料应用到鞋、手镯、服装、时尚配件的实用指南 · 给采购商、工厂和产品开发人员。

SEVENTEEN YEARS OF CRAFT · PUJIANG & YIWU, CHINA ·  
EDITION 2.0 · MAY 2026

## Application success depends on five things working together.

应用是否成功 · 取决于五项变量同时配合

*A rhinestone material is not a finished product. It becomes a finished product on a buyer's line — under a specific heat-press, on a specific fabric, with a specific glue, by a specific operator. Five variables decide whether the result holds.*

水钻辅料本身不是成品。它在客户的产线上 · 在特定的热压设备下 · 贴在特定的面料上 · 用特定的胶 · 由特定的操作员完成 · 才变成成品。结果好不好 · 取决于五项变量同时配合。

### 01 · Material

材料

The receiving fabric or surface. Cotton, polyester, silk, leather, PU, TPU, PVC, acrylic, metal — each behaves differently under heat and pressure.

承接材料 · 棉、涤、真丝、皮革、PU、TPU、PVC、亚克力、金属 · 各自在热和压下的反应不同。

### 02 · Temperature

温度

Heat-press temperature must activate the adhesive without scorching the receiving fabric. A 10°C swing can be the difference between a permanent bond and a sample-day disaster.

热压温度要既激活胶膜 · 又不烧到面料。10°C 的偏差 · 就是永久粘合和打样翻车的距离。

### **03 · Pressure**

压力

Press pressure transfers the stone field onto the substrate. Too little and stones float; too much and stones embed or fabric puckers.

压力把钻面转移到承接面。压力不够·钻浮起·压力过大·钻陷入或面料起皱。

### **04 · Adhesive**

胶膜

Hot-melt activates under heat. 513 double-sided is pressure-sensitive. Sew-on uses no adhesive. The choice depends on the receiving material and on whether the application will see heat in production.

热熔胶在加热下激活·513 双面胶靠压力激活·缝制不上胶。选哪种·看承接材料·也看产线后续会不会经受加热。

### **05 · Workflow**

工艺路径

Where in the line the rhinestone gets applied. Before cutting, after cutting, after sewing, on a finished piece — each position has its own failure modes.

水钻在产线上哪个阶段上贴。裁前、裁后、缝后、成品上·每个位置都有自己的失败模式。

THE NON-NEGOTIABLE RULE

**Always sample on the buyer's actual material before bulk.**

No catalog spec, no application parameter, no factory recommendation replaces a sample test on the buyer's actual production fabric, with the buyer's actual heat-press, under the buyer's actual line conditions. This manual gives starting guidance. The buyer's sample test gives the final answer.

没有任何目录规格、应用参数、工厂建议·能替代用客户实际生产面料 + 客户实际热压设备 + 客户实际产线条件做一次打样测试。本手册给的是起点参数·客户打样测试给的是最终答案。

This manual is built from seventeen years of running rhinestone accessory production inside the same Pujiang factory. The parameters are starting guidance, not absolute guarantees. The rules apply to every product line LOCA makes.

本手册基于乐卡浦江工厂十七年水钻辅料生产经验整理·给出的参数是起点指引·不是绝对保证。规则覆盖乐卡现在所有产品线。

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03 · PRODUCT SYSTEM

EIGHT PRODUCT LINES

## All eight start from a stone, a base, and a way to bond them.

八条产品线 · 起点都是钻、基底、与把两者结合的工艺

*LOCA produces eight product lines, grouped by base structure. Crystal Mesh is the upstream material — most other lines either share its flexible adhesive base or extend it with a fabric back and an inner core.*

乐卡有八条产品线 · 按基底结构分组。水钻胶网片是上游材料 · 其他大部分产品线 · 要么共用它的柔性胶底 · 要么在它的基础上加布底 + 内层延伸出来。

GROUP A · FLEXIBLE ADHESIVE BASE · 柔性胶底

**CM**

### **Crystal Mesh.**

水钻胶网片

Upstream material. Stones set on flexible adhesive. Sheet, roll, or sample piece.

上游材料 · 钻设在柔性胶底上 · 出片、卷、样片。

**DL**

### **Diamond Lace.**

水钻胶条

Backless rhinestone trim, 2 / 3 / 4 / 5 rows, same flexible adhesive base.

无背钻条 · 2 / 3 / 4 / 5 排 · 同样的柔性胶底。

**SP**

## **Shoe Patch.**

鞋花

Die-cut motif patches with flexible adhesive. Footwear-specific shapes.

模切图案钻贴 · 柔性胶底 · 鞋类专用形状。

GROUP B · FABRIC BACK + INNER CORE · 布底 + 内层

**DR**

## **Diamond Rope.**

水钻抽条

Fabric-backed continuous trim, selectable inner core (cotton / EVA / PVC / PU / TPU), 4-8 rows.

布底连续条带 · 内层可选 (棉 / EVA / PVC / PU / TPU) · 4-8 排。

**SU**

## **Shoe Upper.**

鞋面

Fully-formed rhinestone shoe upper. Cold-hot press + RF welding. Target 2026: 20,000 pairs/day.

整体成型水钻鞋面 · 冷热压 + 高周波焊。Target 2026: 20,000 双/天。

INDEPENDENT LINES · 独立结构

**BDS**

## **Bangle Diamond Sticker.**

手镯钻贴条

Multi-element bangle strip. Rhinestones + 0.8 mm electroplated steel beads. 3-20 mm width. Counted per strip.

多元素手镯条 · 水钻 + 0.8 mm 电镀钢珠 · 3-20 mm 宽 · 按"条"计。

**DF**

**Diamond Flower.**

钻花

3D sculptural rhinestone applique. Laser cut + heat press + hand-set stones.

50+ handcraft team.

3D 立体水钻贴花 · 激光裁 + 热压 + 手工设钻 · 50+ 手工团队。

**PVC**

**PVC Strip.**

PVC 亮条

Extruded PVC base with rhinestones. 1 / 4 / 10 / 14 rows. Target 2026: 50,000 m/day.

PVC 挤出基底 + 水钻 · 1 / 4 / 10 / 14 排 · Target 2026: 50,000 米/天。

For a glossary mapping buyer-side search terms (rhinestone trim, rhinestone sheet, rhinestone applique) to the LOCA product codes above, see the Buyer Vocabulary Guide.

需要把客户端搜索词 (rhinestone trim / rhinestone sheet / rhinestone applique) 对到上面乐卡产品代码的查表 · 见 买家词典。

**THE LOCA 12-ELEMENT MATERIAL LIBRARY · 乐卡 12 元素材料库**

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All seven non-PVC product lines above draw from the same 12-element material library — four families organised by element type. The exact mix in any finished product is selected from this library per order.

上面除 PVC 外的 7 条产品线 · 共用同一套 12 元素材料库 — 按元素类型分 4 大类。每张订单具体混排 · 都从这套库里挑。

**A · Rhinestone family**

水钻类 (5 元素)

Pointed-back · Flat-back · Hot-fix\* · Resin · Ceramic

尖底水钻 · 平底水钻 · 烫钻\* · 树脂钻 · 陶瓷

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**B · Glass shaped rhinestone**

异形玻璃钻 (1 + 2 sub)

Glass shaped (flat-back / pointed-back subtypes)

异形玻璃钻 (平底 / 尖底 子型)

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**C · Bead family**

珠类 (4 元素)

ABS · Pearl · Glass bead · Electroplated steel bead

ABS · 珍珠 · 玻璃珠 · 电镀钢珠

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**D · Claw setting family**

爪类 (2 元素)

Shaped claw setting · Claw chain

异形爪 · 爪链

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\* *Hot-fix rhinestone (烫钻 · also written as 平底烫钻 to emphasize structure) is a stone material with hot-melt adhesive already bonded to the back as part of the product spec — ship-ready · no separate backing step required. See Page 09 · BDS for the full element library breakdown.*

\* 烫钻 (也可显式写"平底烫钻") 是一种独立的钻材质 · 背面在出厂时已压好热熔胶 · 这层胶是产品规格的一部分 — 出厂即用 · 无需客户端再加胶。完整元素库参考 第 09 页 · BDS。

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## Which product line fits which finished product.

哪条产品线 · 适合做成哪类成品

*A starting reference. Each cell marked “•” means the product line has been actively used in that finished-product category. Empty cells aren’t exclusions — they mean the combination is uncommon or untested at scale.*

这是一份起点参考。打“•”的格子 · 表示该产品线在这类成品里有实际使用经验。空格不是禁用 · 只是该组合不常见 · 或没有大批量验证。

PRODUCT / 产品线	FOOTWEAR 鞋类	BANGLE 手镯	GARMENT TRIM 服装	BAG / ACCESSORIES 箱包饰品
<b>Crystal Mesh (CM)</b>	•	•	•	•
<b>Diamond Rope (DR)</b>	•	•	•	•
<b>Diamond Lace (DL)</b>	•	•	•	•
<b>Bangle Diamond Sticker (BDS)</b>	•	•	•	•
<b>Diamond Flower (DF)</b>	•	•	•	•
<b>Shoe Patch (SP)</b>	•	•	•	•
<b>Shoe Upper (SU)</b>	•	•	•	•
<b>PVC Strip (PVC)</b>	•	•	•	•

*If the application you’re planning isn’t in the matrix above, it doesn’t mean it can’t be done. Many custom projects sit between the standard categories; LOCA’s development team handles custom-fit work routinely.*

如果你计划的应用不在上表里 · 不代表做不了。很多定制项目落在标准类别之间 · 乐卡开发团队常态处理跨界订单。

HOW TO USE THIS MATRIX

**Read across by application, then down by stone quantity.**

If you're building a footwear collection: the Footwear column gives you five product lines that work (CM, DR, DL, DF, SP, SU, PVC). The next decision is volume: SU is fully-formed (highest unit cost, lowest factory labor on your end), SP is per-piece patches, CM/DR/DL are continuous materials that you cut and apply yourself.

举例 · 做一个鞋类系列: Footwear 这一列给你五条可行产品线 (CM / DR / DL / DF / SP / SU / PVC)。下一步看单件钻量 · SU 是整体成型 (单价最高 · 你工厂自己加工最少) · SP 是单片贴 · CM / DR / DL 是连续材料 · 你自己裁切贴。

## Material compatibility is starting guidance, not a guarantee.

材料兼容是起点指引 · 不是保证

*The table below maps common substrates against LOCA's primary application methods. "OK" means the combination is well-tested. "Test required" means LOCA has done it but the buyer's specific material grade matters more than the category. "Avoid" means the combination has a known failure mode.*

下表把常见承接材料 · 对上乐卡主要的应用方式。"OK" 表示组合已充分验证。"需要打样" 表示乐卡做过 · 但客户具体材料等级比类别本身更关键。"避免" 表示已知组合容易出问题。

MATERIAL	HOT-FIX (HEAT PRESS)	513 DOUBLE-SIDED (PRESSURE)	SEW-ON	NOTES
<b>Cotton</b>	OK	OK	OK	Standard heat-press settings work. Heavy cotton may need higher press time.
<b>Polyester (woven)</b>	OK	OK	OK	Mid-range polyester is the most-tested substrate. Glossy polyester needs lower temp to avoid surface mark.
<b>Silk / fine silk</b>	Test required	OK	OK	Silk organza can scorch at hot-fix temperatures. 513 or sew-on

<b>MATERIAL</b>	<b>HOT-FIX (HEAT PRESS)</b>	<b>513 DOUBLE-SIDED (PRESSURE)</b>	<b>SEW-ON</b>	<b>NOTES</b>
				preferred. Always sample.
<b>Leather (genuine)</b>	Test required	OK	Test required	Heat may dry the leather surface. 513 is the safe default. Test on a hidden patch first.
<b>PU (artificial leather)</b>	OK	OK	Test required	Standard PU bonds well with hot-fix. Avoid over-temperature on coloured PU.
<b>TPU</b>	OK	OK	Avoid	Heat-fix and 513 both work. Sewing through TPU weakens the membrane.
<b>PVC</b>	Avoid	OK	OK	PVC deforms under heat-press. Always use 513 or sew-on for PVC substrates.
<b>Acrylic / hard plastic</b>	Avoid	OK	Avoid	Heat warps. Stitching cracks the surface. 513 is the only viable method.
<b>Metal (rigid)</b>	Avoid	OK	Avoid	513 only. Surface must be clean and de-greased before application.

Three notes that apply across every row above:

三条贯穿全表的提醒：

1. **Material grade matters more than material category.** A “PU” can be a thin coating on cotton, a thick foam-backed sheet, or a synthetic leather. Each behaves differently under heat.
2. **Coloured / printed substrates need lower hot-press temperatures.** Pigment surfaces are heat-sensitive in ways the base material isn't.
3. **The buyer's heat-press machine matters.** Two presses at the same setpoint can deliver different actual surface temperatures. Calibrate before bulk.

1. 材料等级比类别更重要。同样叫 "PU" · 可能是薄棉布上的涂层、厚泡棉衬底、合成皮 · 各自在热下的反应不同。
2. 有印花 / 有色的承接面 · 热压温度要降。染料表面比基底材料对热更敏感。
3. 客户的热压设备本身有差异。两台设备同样设定值 · 实际表面温度可能差几度。量产前一定要校准。

DEFAULT WHEN UNCERTAIN

### **Reach for 513 double-sided.**

When the receiving material is unknown, heat-sensitive, or expensive to ruin (silk, leather, vintage pieces, dyed surfaces), the safe default is 513 double-sided adhesive. It activates under pressure, leaves no heat damage, and can be repositioned on the substrate up to the final press. Hot-fix is faster and more permanent — but only after confirmation that the substrate tolerates the temperature.

承接材料拿不准、不耐热、损坏成本高的（真丝、皮革、复古单品、染色表面）· 默认走 513 双面胶。压力激活 · 无热损伤 · 最后压贴前还可以重新摆位。热压更快、更永久 · 但必须先确认承接面能扛住温度。

06 · PRODUCT APPLICATION

CM · CRYSTAL MESH

## Crystal Mesh.

水钻胶网片

*The upstream material in the LOCA system. Stones set on a flexible adhesive base, supplied as sheet or roll, sized to either a re-processing factory or an end-product factory depending on what the buyer does with it next.*

乐卡体系里的上游材料。钻设在柔性胶底上·出片或卷·规格按"再加工辅料工厂"和"成品工厂"两类客户的下游用途分发。



*Hand-cutting Crystal Mesh from a finished sheet on the Pujiang craft floor.*

在浦江工艺车间·工人徒手把水钻胶网片从成型片上剪下

**PRODUCTION PARAMETERS · 生产参数**

**Hot-fix temperature**

热压温度

**180 °C**

<b>Press time</b> 热压时间	<b>15 seconds</b> 15 秒
<b>Pressure · hydraulic / electric press</b> 压力 · 液压或电动压烫机	<b>Medium</b> 中
<b>Pressure · manual press</b> 压力 · 手动压烫机	<b>Heavy</b> 重
<b>Adhesive film thickness</b> 胶膜厚度	<b>0.4 / 0.5 / 0.6 mm</b> 三档可选
<b>Stone range</b> 钻号范围	<b>SS2.5 - SS12</b> SS4 / SS6 是最常订规格

**STANDARD FORMS · 常规出货规格**

**SHEET SKUS · FOR END-PRODUCT FACTORIES**

片材规格 · 成品工厂直用

105 × 175	<b>SS6</b>
108 × 180	<b>SS6</b>
114 × 190	<b>SS6</b>
140 × 236	<b>SS4</b>
171 × 240	<b>SS4</b>
180 × 200	<b>SS4</b>
185 × 210	<b>SS4</b>

*Format: stone rows × stone columns · the outer film/sheet adds a small cutting margin on each side.*

格式: 钻行数 × 钻列数 · 实际胶膜外尺寸会比钻面稍大 · 留裁切余量。

**ROLL SKUS · FOR RE-PROCESSING FACTORIES**

卷材规格 · 再加工辅料工厂用

118 rows · 28 cm × 1 m	<b>SS6</b>
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172 rows · 28 cm × 1 m **SS4**

*Custom widths up to 50 cm available. Custom lengths up to 25 m available.*

最宽可定制到 50 cm · 最长可定制到 25 m。

## RECOMMENDED APPLICATIONS · 推荐应用

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### **Garment trim**

服装辅料

Cut to motif shape, hot-press onto bodice, panel, or sleeve.

### **Footwear decoration**

鞋类装饰

Vamp panels, sandal strap decoration, slipper top.

### **Bag & accessory faces**

箱包饰品

Full or partial-coverage stone fields on bag faces, clutches, pouches.

### **Custom motif development**

定制图案开发

Sample piece form · combined with [Diamond Flower](#) for 3D applique work.

## APPLICATION NOTES · 应用提示

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**Storage matters more than buyers expect.** Crystal Mesh has two storage failure modes that show up after shipment if conditions are wrong:

储存条件 · 客户最容易忽视的环节。水钻胶网片有两种储存失败模式 · 在收货后才显现：

- **Humid environment** — prolonged exposure causes the silver backing layer on each stone to detach. Stones then fall out of the glue field even before application.

- **Heat exposure** — high storage temperature softens the adhesive film. Stones drop from the field at the next handling.
- 潮湿环境长期存放 — 水钻背面的银层会脱落 · 还没开始应用 · 钻就先掉出来。
- 高温环境 — 胶膜软化 · 下一次搬动钻就脱落。

#### LOCA STORAGE RECOMMENDATION

### **Store sealed, cool, dry, ventilated.**

Keep Crystal Mesh in its sealed packaging until use. Storage location should be cool, dry, and ventilated — not a closed cabinet near a heat source, not a humid basement, not a tropical warehouse without climate control. If the buyer's warehouse has variable humidity or temperature, request shorter delivery batches and use within 60 days.

水钻胶网片在使用前 · 保持原包装密封。储存环境 · 阴凉、干燥、通风。不要放靠近热源源的密闭柜里 · 不要放潮湿地下室 · 不要放无温控热带仓库。客户仓储湿度温度有波动的话 · 建议小批量分批发货 · 60 天内用完。

#### COMMON PROBLEMS · 常见问题

### **Stones falling out of the glue field before application.**

应用前 · 钻就从胶面掉出来

**Cause:** prolonged humid storage detached the silver backing layer; or heat softened the adhesive.

原因：潮湿存放过久 · 银层脱落；或储存温度过高 · 胶软化。

**Fix:** retire the affected batch; verify storage conditions before continuing; request fresh material in sealed packaging.

处理：受影响批次报废；核查储存环境再继续；请乐卡补发密封包装新料。

### **Stones embed too deep into the substrate after press.**

压贴后 · 钻陷入承接面过深

**Cause:** pressure too high for the substrate, especially common on soft cotton, thin polyester, or fine knit.

原因：承接面承受不了该压力 · 软棉、薄涤、细针织最常见。

**Fix:** drop pressure one notch (heavy → medium, medium → light) and re-sample on the same fabric.

处理：压力下调一档（重 → 中 / 中 → 轻）· 同面料重打样。

**Adhesive does not bond — trim peels after first wash.**

胶没粘住 · 首次洗后条带脱落

**Cause:** temperature below 180 °C activation point; or press time below 15 seconds; or the substrate has a release-treated surface (silicone-coated polyester, water-repellent fabric).

原因：温度未到 180 °C 激活点；或热压时间不足 15 秒；或承接面有离型处理（涂硅涤纶、防水面料）。

**Fix:** verify press calibration; if substrate is suspected, switch to 513 double-sided adhesive (see Material Compatibility).

处理：校准热压设备；如怀疑承接面问题 · 切换 513 双面胶（见材料兼容章节）。

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07 · PRODUCT APPLICATION

DR · DIAMOND ROPE

## Diamond Rope.

水钻抽条

*Fabric-backed continuous rhinestone trim with a selectable inner core. The inner core decides everything downstream — drape, cutting, sewing, durability under wear. Pick the core first; the row count and width follow from the application.*

布底连续水钻抽条 · 内层可选。内层决定了下游一切 — 垂感、裁切、缝制、耐磨。先定内层 · 排数和宽度随应用场景决定。



*Ten dedicated machines run the Diamond Rope floor; daily output, 150,000 metres.*

10 台专机轮班跑水钻抽条 · 日均 15 万米

## INNER CORE SELECTION · 内层选择

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### **Width < 8 mm**

宽度 8 毫米以下

### **Cotton core**

棉芯 · 软、贴合曲面

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### **Width ≥ 8 mm**

宽度 8 毫米及以上

### **EVA core**

EVA · 挺括、能定型

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### **Wide / shape-holding pieces**

较宽 / 需要定型的款式

### **EVA core**

EVA · 撑得起形状

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### **Other cores available**

其他可选内层

### **PVC · PU · TPU**

按客户应用需求定制

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## HEAT TOLERANCE · 耐热性

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All standard inner cores tolerate **up to 350 °C for short exposures**, which is well above any hot-press temperature the trim will see in production (180 °C is standard). This makes Diamond Rope unusually forgiving in downstream processes — including secondary heat treatment, embossing, or hot-knife cutting at the buyer's end.

所有标准内层 · 都能承受 短时间 **350 °C** 高温 · 远高于生产线常见热压温度（标准 180 °C）。也就是说水钻抽条在下游工艺里非常宽容 — 二次热处理、压花、热刀裁切 · 客户端都能用。

## STANDARD WIDTHS · 常用宽度

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### **6 mm · full-stone**

6 mm · 满钻

Narrow accent on sandal strap, bracelet outline, garment neckline.

### **8 mm · full-stone**

8 mm · 满钻

Standard sandal trim, belt, bridal sash mid-width.

### **10 mm · full-stone**

10 mm · 满钻

Statement bracelet, wide belt, evening dress waistband.

### **12 mm · full-stone**

12 mm · 满钻

Showpiece trim, bridal cuff, footwear feature row.

Other popular variants beyond standard full-stone runs:

满钻规格之外的热销变体:

- **Laser paper S-curve + stone** — alternating mirrored laser paper and stones in an S pattern. Strong directional shimmer effect.
- **Numeric / pattern stones + rhinestone mix** — shaped stones interleaved with round rhinestones, popular in 3-row and 4-row formats.
- **3-row and 4-row formats** — the two most-ordered row counts across all widths.
- 镭射纸 S 型 + 钻 — 镜面镭射纸和钻交替排列成 S 形 · 强方向性反光效果。
- 数字 / 图形钻 + 水钻 混排 — 异形钻穿插圆水钻 · 3 排和 4 排款式最热销。
- 3 排和 4 排 — 所有宽度里订单量最高的两个排数档位。

## **RECOMMENDED APPLICATIONS · 推荐应用**

### **Footwear trim**

鞋类条带

Sandal straps, slipper bands, vamp accents, heel collars.

### **Bridal sashes / belts**

婚饰腰带

Bridal waistband, sash, evening gown trim — EVA core holds shape.

### **Bracelet wrap**

手镯包覆

Wrapping a metal cuff or leather strap base — cotton core stays soft.

## Garment binding

服装收边

Neckline binding, hem trim, sleeve cuff edging.

### APPLICATION METHODS · 应用方式

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Diamond Rope is the most-flexible product in the LOCA system in terms of attachment method. The same piece can be:

水钻抽条在乐卡体系里·是应用方式最灵活的产品。同一段水钻抽条可以:

- **Glued** — surface-bonded with appropriate adhesive for the substrate
- **Hand-sewn** — stitched through the fabric back, standard upholstery or beading needle
- **Machine-sewn** — industrial sewing through the back, away from the stone field
- **Combined** — sewn at the ends, glued in the middle, or vice versa
- 粘贴 — 根据承接面选合适胶水
- 手工缝制 — 缝穿布底·用标准家纺针或串珠针
- 机器缝制 — 工业缝纫机走布底·避开钻面
- 组合方式 — 两端缝、中间粘·或者反过来

### COMMON PROBLEMS · 常见问题

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#### **Adhesive peels from trim after a few weeks.**

胶在几周后从条带上脱落

**Cause:** the buyer pulled hard on the adhesive layer during application, separating the bond. Diamond Rope's glue is not designed for high-force peel resistance.

原因: 应用时用力拉扯胶层·把粘合层撕开了。水钻抽条的胶不是为抗剥离强力设计。

**Fix:** instruct line operators to press, not pull. If trim must be repositioned, lift gently with the trim direction, not against it. For high-stress placements (children's wear, athletic), use sewn application.

处理：告知产线·是压不是拉。需要重新摆位时·顺条带方向轻抬·不要反向。高应力场景（童装、运动）用缝制。

### **Stones falling from the trim during storage.**

储存期间·钻从条带上脱落

**Cause:** long-term humid storage. The same silver-layer detachment problem that affects Crystal Mesh also affects Diamond Rope.

原因：潮湿环境长期存放。和水钻胶网片一样的银层脱落问题。

**Fix:** seal in original packaging, store cool / dry / ventilated, use within 60 days of receipt for best results.

处理：保持原包装密封·阴凉干燥通风·收货后 60 天内用完最佳。

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08 · PRODUCT APPLICATION

DL · DIAMOND LACE

## **Diamond Lace.**

水钻胶条

*Backless flexible adhesive trim. Same hot-press protocol as Crystal Mesh — same temperature, same time, same press calibration. The buyer-facing difference is form factor: Diamond Lace ships in narrow row counts (2 / 3 / 4 / 5 rows), pre-shaped to be cut to length with scissors and applied directly.*

无背柔性胶底钻条。和水钻胶网片共用同一套热压参数 — 同温度、同时间、同压力校准。客户端的差别在于规格：水钻胶条出窄排数（2 / 3 / 4 / 5 排）· 出货时已成型 · 剪刀剪到需要长度直接应用。



*Diamond Lace gets tidied at a bench beside the running rope line.*  
水钻胶条在抽条产线旁的工位上整理·出一卷·收一卷

**PRODUCTION PARAMETERS · 生产参数**

**Hot-fix temperature**

热压温度

**180 °C**

同水钻胶网片

**Press time**

热压时间

**15 seconds**

15 秒 · 同水钻胶网片

**Pressure**

压力

**Medium (auto) / Heavy (manual)**

中 (自动) / 重 (手动) · 同水钻胶网片

**Row counts**

排数

**2 / 3 / 4 / 5 rows**

四档 · 按宽度选

**Cutting method**

裁切方式

**Scissors · cut to length**

剪刀按长度直裁

Crystal Mesh and Diamond Lace share the same flexible adhesive base. The split is about **shape pre-commitment**:

水钻胶网片和水钻胶条共用同一种柔性胶底。区别在于成型程度的预设:

- **Crystal Mesh** ships as a stone-filled field. The buyer cuts the motif shape out of the field. Cutting waste is part of the price.
- **Diamond Lace** ships as a pre-formed trim already shaped to row count and width. The buyer cuts only the length. Zero motif-shape waste.
- 水钻胶网片 出整片钻面 · 客户从片上裁出图案形状 · 裁切损耗算在价格里。
- 水钻胶条 出已成型的条带 · 已经按排数和宽度预成型 · 客户只裁长度。零图案损耗。

If the buyer needs a custom shape, use Crystal Mesh. If the buyer needs a continuous narrow trim, use Diamond Lace.

需要自定义形状 · 用水钻胶网片。需要连续窄条 · 用水钻胶条。

#### ROW COUNT SELECTION · 排数选择

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All four row counts (2 / 3 / 4 / 5) use the same flexible adhesive base. Choose by the visible width you need on the finished product. Scissors cut to length — no special tooling required.

2 / 3 / 4 / 5 四档排数 · 共用同一种柔性胶底。按成品需要的可见宽度选。剪刀直接裁长度 · 不需要专用工具。

For a deeper row-count walkthrough across all LOCA trim products, see the Row Count Guide.

需要乐卡全产品线排数对照 · 见 排数指南。

## RECOMMENDED APPLICATIONS · 推荐应用

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### **Garment neckline / sleeve trim**

服装领口 / 袖口

Narrow 2-3 row format runs straight along an edge.

### **Bag piping**

箱包嵌边

4-5 row format gives a defined edge line.

### **Shoe vamp border**

鞋面边线

Press-applied along the vamp seam line.

### **DIY / sampling layouts**

DIY / 打样

Cut + place + press — the simplest of the LOCA products for low-tooling production environments.

## COMBINATIONS TO AVOID · 不推荐的组合

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NOT RECOMMENDED

### **Rhinestone + steel bead on Diamond Lace.**

The Diamond Lace flexible adhesive base is not engineered to support steel beads alongside rhinestones in the same trim. For multi-element layouts that combine rhinestones with electroplated steel beads, use Bangle Diamond Sticker instead — it's the dedicated multi-element strip product.

水钻胶条的柔性胶底不是为"水钻 + 钢珠"混排设计的。需要水钻与电镀钢珠的多元素混排 · 用手镯钻贴条 — 它是专门的多元素混排产品。

Diamond Lace is the most-forgiving product in the LOCA system. The flexible adhesive base, simple cutting protocol, and shared parameters with Crystal Mesh mean failures are rare when the buyer picks the right width and row count for the application.

水钻胶条是乐卡体系里最容错的产品。柔性胶底 + 简单裁切 + 跟水钻胶网片共享参数 · 客户只要选对宽度和排数 · 失败率很低。

**Trim looks too wide / too narrow on the finished piece.**

成品上 · 条带显得太宽或太窄

**Cause:** wrong row count for the application. A 5-row Diamond Lace looks heavy on a delicate neckline; a 2-row looks lost on a wide belt.

原因：排数和应用不匹配。5 排水钻胶条贴在精致领口显重 · 2 排贴在宽腰带又显薄。

**Fix:** request a sample swatch in 2-3 adjacent row counts before bulk. Place each against the actual product and check visible width at intended viewing distance.

处理：量产前 · 请乐卡寄相邻 2-3 个排数的样片。贴到实际产品上 · 在预期观看距离下对比可见宽度。

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09 · PRODUCT APPLICATION

BDS · BANGLE DIAMOND STICKER

## Bangle Diamond Sticker.

手镯钻贴条

*The multi-element product in the LOCA system. Most BDS strips ship with a built-in self-adhesive backing — no heat press required — and combine rhinestones with a wide range of decorative elements selected per order. One strip equals one finished bangle.*

乐卡体系里的多元素产品。多数手镯钻贴条出货时已带自粘背胶 — 不需要热压 — 在水钻基础上 · 按订单选配多种装饰元素。一条 = 一只成品手镯。



*Steel beads being hand-set into Bangle Diamond Sticker at the multi-element bench.*

电镀钢珠在多元素工位上 · 一颗一颗压进手镯钻贴条

## PRODUCTION PARAMETERS · 生产参数

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<b>Application method</b> 应用方式	<b>Self-adhesive backing</b> 自粘背胶 · 撕贴即用
<b>Hot-fix required</b> 是否需要热压	No 否 · BDS 不走热压
<b>Width range</b> 宽度范围	3 - 20 mm
<b>Most-ordered widths</b> 最常订规格	<b>3 / 6 / 9 / 12 mm</b> 四档为主
<b>Counting unit</b> 计数单位	per strip (条) 一条 = 一只成品手镯

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## ELEMENT LIBRARY · 元素库 (LOCA 12 元素标准)

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BDS production combines elements from LOCA's 12-element standard library — the same library shared across all seven non-PVC product lines. What makes BDS the “multi-element” product is the breadth of combinations LOCA runs in a single bangle strip. Four families, twelve elements:

手镯钻贴条从乐卡 12 元素标准库中选配 — 这套库覆盖 7 条非 PVC 产品线。BDS 之所以是“多元素产品” · 在于乐卡在一条手镯条上能跑出的组合广度。四大类 · 12 元素：

### **A · Pointed-back rhinestone**

A · 尖底水钻

Pointed setting · highest brilliance through facet reflection.

### **A · Flat-back rhinestone**

A · 平底水钻

Flat setting · workhorse for trim and mesh applications.

### **A · Hot-fix rhinestone**

A · 烫钻 (平底烫钻)

Stone material with built-in hot-melt adhesive on the back · ship-ready · typically flat-back style.

**A · Resin rhinestone**

A · 树脂钻

Softer reflection · vibrant colours · lighter than glass.

**A · Ceramic stone**

A · 陶瓷

Matte / soft-finish stone · subtle texture · used as quiet accent.

**B · Glass shaped rhinestone**

B · 异形玻璃钻

Non-round glass stones (navette / baguette / marquise / teardrop) · flat-back or pointed-back sub-types.

**C · ABS bead**

C · ABS

Plastic bead · lightweight, colour-coatable, low cost.

**C · Pearl**

C · 珍珠

Faux pearl — glass or resin core · soft non-reflective accent.

**C · Glass bead**

C · 玻璃珠

Round glass bead · refractive but non-faceted.

**C · Electroplated steel bead**

C · 电镀钢珠

Hard metal accent · finish families: rose gold / black + gun / gold / silver.

**D · Shaped claw setting**

D · 异形爪

Metal claw setting in non-standard shapes · mechanical setting (no glue).

## **D · Claw chain**

D · 爪链

Continuous claw-set chain · holds stones under stress · alternative to adhesive-bonded trim.

Any element from this library can be combined with rhinestones in the same strip. Multi-element layouts are LOCA's signature in the bangle category. For the buyer-side terminology mapping of this library, see the Buyer Vocabulary Guide.

任何一种元素都可以和水钻在同一条上混排。多元素排列是乐卡在手镯品类里的特色。这套元素库的客户端术语对照 · 见 买家词典。

## **APPLICATION · 应用方式**

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The self-adhesive backing is pressure-sensitive. Application onto the buyer's bangle base:

自粘背胶是压敏胶。应用到客户的手镯基底上：

1. Position the strip along the bangle's outer surface
2. Press evenly along the length
3. Hold for a few seconds to ensure full bond contact
4. No heat required — pressure does the work

1. 沿手镯外表面定位条带
2. 沿长度方向均匀压贴
3. 保持按压几秒 · 确保胶面充分接触
4. 不需要加热 · 压力就完成粘合

The strip applies to most common bangle bases: metal frames, acrylic / plastic bangles, leather wrist straps, fabric-covered bangle bases. For a buyer-side guide to width tier selection, stone density, and bangle market context, see the Bangle Decoration Guide.

可贴到常见手镯基底：金属框、亚克力 / 塑料手镯、皮腕带、布面手镯。需要客户端宽度选择、钻密度、手镯市场背景的指南 · 见 手镯钻饰选型。

## STORAGE WARNING · 储存警告

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### SILVER OXIDATION

#### **Silver-plated elements need promptness or resin coating.**

Silver-plated steel beads and any silver-finish elements oxidize over time through air contact — especially in humid conditions. Two ways to handle this in production: (1) use silver-bead orders promptly after receipt and keep sealed packaging until use, or (2) request resin-coated silver elements at order time — the resin layer prevents air contact and significantly slows oxidation.

镀银钢珠和任何银面元素 · 长期接触空气会氧化 — 特别是潮湿环境下。生产端两种处理：  
(1) 含银珠订单尽快用完 · 使用前保持原包装密封；或 (2) 下单时指定树脂覆盖银面元素 — 树脂层隔绝空气 · 显著延缓氧化。

## COMMON PROBLEMS · 常见问题

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#### **Silver elements turning dull or tarnishing during storage.**

银面元素在储存中失光或发黑

**Cause:** oxidation. Silver-plated elements react with air, accelerated by humidity and time.

原因：氧化。镀银元素和空气反应 · 湿度和时间加速。

**Fix:** use within 30–60 days of receipt; seal in original packaging when not in use; for long storage planning, request resin-coated silver elements at order time.

处理：收货后 30–60 天内用完；不用时保持原包装密封；需要长储存的订单 · 下单时指定树脂覆盖银元素。

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10 · PRODUCT APPLICATION

DF · DIAMOND FLOWER

## **Diamond Flower.**

钻花

*Pre-shaped 3D rhinestone applique. Where Crystal Mesh, Diamond Lace, and the other trim products ship as continuous length, Diamond Flower ships as a finished single-piece motif. Laser cut, then pressed into dimensional form, then hand-set with crystals. One piece per placement. Nothing to cut to length, nothing to choose by row.*

预成型 3D 立体水钻装饰件。抽条类产品（水钻胶网片、水钻胶条这些）按米出货·钻花不一样·出货就是一片完整的成品 motif。先激光切割·再 3D 立体热压·最后手工嵌钻。每个位置贴一片。没有长度好裁·没有排数好选。



*Step 3 of Diamond Flower — every motif hand-finished before the press locks the shape.*

钻花工艺第 3 步 · 一件一件手工修整 · 完成后再次定型

## PRODUCTION PARAMETERS · 生产参数

### Process steps

工艺步骤

4-step: laser-cut → 3D heat-press → hand-set crystals → final shape-lock

4 步: 激光切割 → 3D 热压 → 手工嵌钻 → 二次定型

### 3D heat-press temperature

3D 热压温度

**220 °C**

高于平面 hot-fix 的 180°C · 用于立体成型

### 3D press time

3D 热压时间

**25-30 seconds**

25-30 秒 · 比平面 hot-fix 长 · 给立体定型时间

### Buyer application

客户端应用

Hot-fix (180 °C / 15 sec) OR sew-on OR adhesive-glue

烫钻 (180 °C / 15 秒) 或缝制或胶粘 · 客户选

### Size range

尺寸范围

3.5×4 cm to 9.5×9.5 cm

从 3.5×4 cm 小 motif 到 9.5×9.5 cm 大花型

### Custom development

In-house mold + pattern design

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**WHY DIAMOND FLOWER EXISTS ALONGSIDE TRIM PRODUCTS · 钻花 VS 抽条 / 网片**

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Trim products (Crystal Mesh, Diamond Lace, Diamond Rope) ship as continuous length and the buyer commits to motif shape at cutting time. Diamond Flower commits to motif shape at LOCA's production time — the laser-cut, 3D-formed silhouette is fixed before shipment.

抽条类产品（水钻胶网片、水钻胶条、水钻抽条）出货时是连续长度 · 客户在裁切阶段定 motif 形状。钻花的 motif 形状在乐卡生产阶段就定 — 激光切割 + 3D 成型的轮廓出货前已锁定。

The trade-off:

取舍：

- **Trim products:** maximum flexibility (any shape from one roll), but the buyer carries the cutting waste and shape-decision burden.
- **Diamond Flower:** zero cutting waste, zero shape-decision burden, three-dimensional visual lift that flat trim cannot match. Trade-off is per-piece cost vs per-metre cost.
- 抽条类：灵活性最大（一卷可裁任意形状）· 但裁切损耗 + 形状决策都由客户承担。
- 钻花：零裁切损耗 · 零形状决策负担 · 立体感是平面抽条永远做不到的。代价：按件计价 vs 按米计价。

For multi-piece couture or bridal layouts that need a specific recurring motif (butterfly, rose, star), Diamond Flower is the right choice. For continuous edge treatment, use a trim product.

高定或新娘类多片重复 motif 布局（蝴蝶 / 玫瑰 / 星形）· 选钻花。需要连续边线处理 · 选抽条类。

**Bridal hair pieces · tiaras**

婚饰头花 / 头饰

Pre-formed 3D motif sews or glues directly onto the base. No cutting required.

**Couture dress focal accents**

高定礼服焦点装饰

Single statement piece at neckline, waist, or shoulder. 3D dimension reads from a distance.

**Pageant · performance costume**

选美 / 表演服

Large motifs (7-9.5 cm) for stage visibility under lighting.

**Luxury bag · clutch accent**

奢侈包 / 晚宴包饰

Single focal motif on bag front. Hot-fix or sewn through fabric backing.

**Shoe vamp focal point**

鞋面焦点装饰

Pair-matched motif applied to vamp at production. Often combined with Crystal Mesh trim along the vamp edge.

**Customer-specific motif**

客户定制图案

Send design file (PNG / AI / sketch). LOCA mold workshop opens new die in 5-7 working days.

NOT RECOMMENDED

### **Cutting or trimming the Diamond Flower outline.**

The 3D heat-pressed structure depends on the exact die-cut silhouette. Trimming the edge after shipment compromises the dimensional form and exposes the unfinished base. If the buyer needs a different motif size or shape, request a new mold — do not modify the shipped piece.

3D 热压结构依赖精确的激光切割轮廓。出货后再裁边会破坏立体造型 · 同时暴露未处理的基底。需要不同尺寸或形状的 motif · 请乐卡重新开模 — 不要修改已出货的件。

### **3D shape flattens or distorts after storage.**

储存一段时间后 · 3D 立体感变扁或变形

**Cause:** stacking pressure (pieces piled flat under weight) or heat exposure (storage above 35°C softens the dimensional form).

原因：堆压（多片平放叠加受重）或高温（储存温度超过 35°C 让立体结构软化）。

**Fix:** store flat in single-layer trays with a divider sheet between layers; keep below 30°C; use within 6 months of receipt.

处理：单层托盘平放储存 · 层间加隔板；温度保持 30°C 以下；收货后 6 个月内用完。

### **A few hand-set crystals fall off during shipment.**

运输过程中 · 个别手工嵌的水钻脱落

**Cause:** Diamond Flower includes hand-set crystals as part of step 3 of the 4-step process. Hand-set bonding is strong but not laser-grade. Multi-piece cartons under shipping vibration may dislodge a small percentage.

原因：钻花 4 步工艺第 3 步是手工嵌钻 · 手工胶合强度高但不如激光级。多片整箱出货 · 运输震动可能让小比例水钻脱落。

**Fix:** LOCA includes 2-3% extra crystals (matching size + colour) in every bulk shipment of 500+ pieces. Use these to spot-repair on receipt before bulk application.

处理：乐卡每批 500 件以上的整箱出货 · 附送 2-3% 备用水钻（同尺寸同色）。收货后量产  
前用备用钻补点。

For a buyer-side guide on briefing a custom motif (what design files to send, what dimensions to specify, lead-time expectations), see [How to Brief a Custom Rhinestone Motif](#).

需要 motif 定制 brief 的客户端指南（设计文件格式、尺寸指定、lead-time 预期）· 见 [钻花定制 brief 指南](#)。

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## Shoe Patch.

鞋花

*Die-cut motif patches that share Crystal Mesh's flexible adhesive base. Same hot-press parameters, same application protocol — the only difference is shape pre-commitment. A Shoe Patch ships already cut to a specific motif outline, ready to press-apply onto the substrate.*

模切图案钻贴 · 共用水钻胶网片的柔性胶底。同样的热压参数 · 同样的应用流程 — 唯一区别是形状已经预成型。鞋花出货时已经按图案模切完毕 · 直接热压贴到承接面。



*Shoe Patch motifs being assembled at the LOCA brand-wall bench, the raw-stone library within arm's reach.*

鞋花 motif 在乐卡品牌墙工位组装 · 整面水钻原料库就在身后 · 伸手就到

#### PRODUCTION PARAMETERS · 生产参数

**Hot-fix temperature**

热压温度

**180 °C**

同水钻胶网片 / 水钻胶条

**Press time**

热压时间

**15 seconds**

15 秒 · 同 CM / DL

**Pressure**

压力

**Medium (auto) / Heavy (manual)**

中 (自动) / 重 (手动)

**Adhesive film**

胶膜

**0.4 / 0.5 / 0.6 mm**

同 CM 三档

**Form**

出货形式

**Die-cut motif patches**

已模切图案钻贴

*All hot-press parameters above are identical to Crystal Mesh and Diamond Lace — the three products share the same flexible adhesive base (Group A in the system overview).*

上面所有热压参数 · 跟水钻胶网片和水钻胶条完全一致 — 三种产品共用同一种柔性胶底（系统总览里的 Group A）。

#### **DIE OPTIONS · 模具选择**

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LOCA Shoe Patch ships with two die approaches. Both use the same flexible adhesive base — the die choice doesn't affect application parameters.

乐卡鞋花有两种模具选项。两种共用同一柔性胶底 — 模具选择不影响应用参数。

##### **Standard die library**

标准模具库

Pre-made die patterns covering common shoe motifs — flowers, butterflies, geometric stars, brand-safe abstracts. Lower cost, faster turnaround.

##### **Custom die-cut**

客户图样开模

Buyer supplies artwork. LOCA cuts a new die for the specific motif. Higher first-order cost (one-time die-making investment); subsequent orders use the same die at standard pricing.

#### **APPLICATION · 应用方式**

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Same as Crystal Mesh sheet-cutting protocol — except the cutting is already done at LOCA. The buyer positions the patch, presses at 180 °C for 15 seconds, and the patch bonds to the substrate. No special tooling required beyond a calibrated heat press.

同水钻胶网片裁切流程 — 区别是裁切工作在乐卡这边已完成。客户定位贴片 · 180 °C 热压 15 秒 · 贴片粘合到承接面。除标准热压设备外 · 不需要其他专用工具。

## RECOMMENDED APPLICATIONS · 推荐应用

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### **Sandals**

凉鞋

Vamp accent, strap motif, central feature.

### **Slippers**

拖鞋

Front panel decoration, single-motif accent.

### **Rainboots**

雨靴

Decorative panel on rubber surface (test compatibility first).

### **Sneakers**

运动鞋

Heel feature, tongue accent, side panel highlight.

### **Platform shoes**

厚底鞋

Front-cover statement motif, sole edge accent.

## COMMON PROBLEMS · 常见问题

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Few unique to Shoe Patch. The product inherits Crystal Mesh's flexible adhesive base, so any application failures are typically substrate-side — e.g., heat-sensitive coloured PU, glossy polyester requiring reduced temperature, water-repellent coatings preventing bond. See Page 05 · Material Compatibility for substrate-specific guidance.

鞋花自身少有独特问题。继承水钻胶网片柔性胶底·应用失败几乎都是承接面问题 — 比如有色 PU 不耐热、亮面涤纶需要降温、防水涂层阻碍粘合。承接面具体指引见 第 05 页·材料兼容。

For a deeper buyer-side guide on choosing between Shoe Patch, Crystal Mesh roll, or finished Shoe Upper for footwear projects, see Rhinestone Inputs for Shoe Factories.

需要鞋类项目里·鞋花、水钻胶网片卷、整体鞋面如何选择的客户端指南·见鞋厂水钻辅料选型。

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## Shoe Upper.

鞋面

*Finished shoe-upper component. SU sits downstream of every other LOCA product: rhinestone trim, motifs, and structural fabric all integrated into a complete vamp form before shipment. The shoe factory receives a piece that is ready to attach to a sole, and removes one entire production stage from its own line.*

鞋面成品组件。SU 在乐卡其他所有产品的下游 · 把水钻抽条、motif、结构布料整合成一个完整的鞋面型再出货。鞋厂收到的是可以直接装鞋底的鞋面 · 自己产线里少做一整道工序。



*Hand-finishing a gold-paved Shoe Upper sheet — one step before left and right get matched.*

金色满钻的鞋面正在手工修整·修完就进配对

## PRODUCTION PARAMETERS · 生产参数

### Process

工艺

Cold-hot press + RF welding + hand-finish

冷热压 + 高频焊接 + 手工修整

### Hot-press temperature

热压温度

**180-200 °C**

180-200°C · 按基材柔韧度调

### Cold-press cycle

冷压周期

After hot-press, 30-second cold cycle for shape-lock

热压后 30 秒冷压定型

### Size range

尺寸范围

Vamp bands 23×7.5 cm to 26.5×11 cm · full vamp forms up to 25×13.5 cm

鞋面带 23×7.5 到 26.5×10.5 cm · 整体鞋面 25×13.5 cm

### Pair matching

配对

Ships pair-matched (left + right) by default

出货默认配对 (左 + 右) · 单只可指定

### Production capacity

**Target 2026: 20,000 pairs/day**

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**WHY SHOE UPPER EXISTS ALONGSIDE TRIM PRODUCTS · 鞋面 VS 抽条 / 鞋花**

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A shoe factory has three ways to source rhinestone decoration. Buy raw stones and apply in-house. Buy LOCA trim products (Crystal Mesh, Diamond Rope, Shoe Patch) and integrate at its own factory. Or buy LOCA Shoe Upper, and remove the decoration step entirely.

鞋厂获得水钻装饰 · 三种方式。买原料水钻自己装。买乐卡抽条类产品（水钻胶网片、水钻抽条、鞋花）回厂自己整合。或者直接买乐卡鞋面 · 整道装饰工序外包出去。

- **Raw stones:** lowest material cost, highest labour cost, requires skilled application team.
  - **Trim products:** balanced cost, the buyer keeps the design decision but skips raw stone setting. Most shoe factories sit here.
  - **Shoe Upper:** highest per-piece cost, lowest labour cost on the buyer side. The shoe factory becomes a sole-and-assembly operation. Good for factories scaling fast or running rhinestone designs irregularly.
- 原料水钻：材料成本最低 · 人工成本最高 · 需要熟练应用团队。
- 抽条类：成本平衡 · 设计决策仍在客户手里 · 跳过水钻散件镶嵌。多数鞋厂在这一档。
- 鞋面：单件成本最高 · 客户端人工成本最低。鞋厂变成“鞋底 + 装配”模式。适合扩产快或水钻款式不规律生产的鞋厂。

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**RECOMMENDED APPLICATIONS · 推荐应用**

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**Women's sandal · vamp band**

女款凉鞋 · 鞋面带

Slim vamp band (23×7.5 cm) bonded to sole at shoe factory. Most common SU format.

**Wedding · bridal shoe**

婚鞋 / 派对鞋

Full vamp form (25×13.5 cm) with dense rhinestone paving. Ships as left-right pair ready for assembly.

**Party · performance footwear**

派对鞋 / 表演鞋

Triple-motif vamp bands (recurring focal motif ×3) for stage-light visibility.

**Cross-strap sandal**

交叉绑带凉鞋

Multiple narrow rhinestone straps assembled into a single cross-strap form before shipment.

**Flat sandal · slide**

平底凉鞋 / 拖鞋

Single-band rhinestone vamp on a flat sole base. Common for India and Middle East summer footwear.

**Heel-back panel accent**

鞋后跟装饰片

Smaller vamp segment applied to heel-back area as accent. Custom shape on request.

NOT RECOMMENDED

### **Sole assembly without sample-fit verification.**

Each SU shape is engineered to a specific shoe-last profile. Mounting onto a sole with a different last curvature can cause the vamp to wrinkle, gap at the toe, or pull at the heel. Always verify a sample SU against the production last before bulk assembly — LOCA sends one fit-test pair before every bulk order.

每款鞋面都是针对特定鞋楦轮廓做的。装到曲度不同的鞋楦上·会出现鞋面起皱、脚趾处漏空、后跟拉扯。量产装配前·务必拿样品鞋面试装在量产鞋楦上 — 乐卡每批整箱出货前都先寄一双试装样。

### **Pair-mismatch between left and right SU.**

左右鞋面尺寸 / 图案不对称

**Cause:** SU is hand-finished in step 3. Left-right pairs are matched during QC, but a small percentage of late-stage hand-finishing variation can occur in dense-pave designs.

原因: SU 第 3 步是手工修整。出货前 QC 已配对·但密集嵌钻款式可能在最后的手工修整阶段出现小比例左右差异。

**Fix:** on receipt, lay all pairs flat in a single layer and visually scan for mismatch. LOCA replaces any rejected pairs at no charge if reported within 14 days of receipt.

处理: 收货后单层平铺所有配对·目视检查不对称。14 天内反馈·乐卡免费替换不合格配对。

### **Vamp fabric pulls at the sole-bonding line during assembly.**

装配时·鞋面布料在鞋底粘合线处被拉扯

**Cause:** sole-bonding adhesive too aggressive, OR sole assembly pressure too high, OR last curvature mismatch (see Combinations to avoid above).

原因: 鞋底粘合胶太强·或装配压力太大·或鞋楦曲度不匹配(见上文"不推荐组合")。

**Fix:** reduce sole-bond adhesive layer by 20%; lower press pressure one notch; if mismatch persists, request SU last-profile matched to your specific sole at next order.

处理：鞋底粘合胶层减薄 20%；装配压力调低一档；如仍不匹配，下次下单时请乐卡按你的鞋楦轮廓定制 SU 形状。

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## **PVC Strip.**

PVC 亮条

*Extruded PVC base with rhinestones embedded directly into the strip. PVC Strip is structurally distinct from every other LOCA product — it's not a flexible adhesive sheet, not a fabric-backed trim, but an extruded continuous profile. As a result, its application method is also unique: natural latex bonding, not hot-press, not 513 double-sided.*

挤出 PVC 基底 + 水钻嵌入条带。PVC 亮条在乐卡产品里结构最独立 — 不是柔性胶片 · 不是布底条带 · 而是挤出连续型材。所以应用方式也独特：天然乳胶粘合 · 不热压 · 不上 513 双面胶。



*A bronze PVC profile coming off the Pujiang extrusion line.*  
古铜色 PVC 条正从浦江挤出线上下来

**PRODUCTION PARAMETERS · 生产参数**

**Application method**

应用方式

**Natural latex adhesive**

天然乳胶粘合

**Hot-fix compatible**

是否可热压

**No (PVC deforms under heat)**

否 · PVC 受热变形

**513 double-sided**

是否可用 513

**Not standard**

非标准 · PVC 挤出表面纹理不适配

**Row counts**

排数选择

**1 / 4 / 10 / 14 rows**

四档 · 客户自选

**PVC formulation**

PVC 配方

**Additive-free special formulation**

无添加特殊配方

**Production capacity**

Target 2026: 50,000 m/day

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**WHY EXTRUDED PVC INSTEAD OF FABRIC BACK · 为什么用挤出 PVC 而非布底**

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PVC Strip and Diamond Rope are different products, not variants of each other. The use-case difference:

PVC 亮条和 水钻抽条 是两种不同的产品 · 不是同一产品的两个变体。使用场景区别:

- **Diamond Rope (fabric back + inner core)** — used where the strip needs to drape, conform to curves, or be sewn into fabric assemblies. Soft and flexible.
- **PVC Strip (extruded continuous profile)** — used where the strip needs to hold shape, resist moisture, or apply to plastic / sandal / slipper bases where the substrate itself is rigid. Firm and shape-holding.
- 水钻抽条 (布底 + 内层) — 需要垂感、贴合曲面、缝进布制品 · 软而柔顺。
- **PVC 亮条 (挤出连续型材)** — 需要定型、防潮、贴到塑料 / 凉鞋 / 拖鞋等本身较硬的承接面 — 挺括有形。

A sandal strap, for example, often needs a rigid decorative trim that doesn't deform — PVC Strip's extruded profile delivers that. A bracelet sash needs softness and drape — Diamond Rope delivers that.

举例: 凉鞋带需要不变形的硬挺装饰条 — PVC 亮条的挤出型材正好。手链腰带需要软度和垂感 — 水钻抽条更适合。

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**APPLICATION · 应用方式**

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PVC Strip uses natural latex adhesive (天然乳胶) instead of hot-press or 513 double-sided:

PVC 亮条用天然乳胶 · 不是热压 · 不是 513 双面胶:

1. Apply natural latex to the substrate (or to the back of the PVC strip)

2. Position the strip along the application line
3. Press evenly along the length
4. Allow curing time per the latex specification (typically minutes, not seconds)

1. 把天然乳胶涂在承接面上（或涂在 PVC 亮条背面）
2. 沿应用线定位条带
3. 沿长度方向均匀压贴
4. 按乳胶说明等待固化时间（通常是分钟级·不是秒级）

Natural latex bonds well to PVC, plastic, and most rigid substrates common in footwear. Avoid heat exposure during the curing window — once the latex has cured, the bond is stable.

天然乳胶对 PVC、塑料、以及鞋类常见硬挺承接面粘合良好。固化期间避免加热 — 乳胶固化完成后·粘合稳定。

#### **ROW COUNT SELECTION** · 排数选择

---

All four row counts (1 / 4 / 10 / 14) use the same extruded PVC formulation. Row count is buyer-selected per application:

1 / 4 / 10 / 14 四档排数 · 共用同一种 PVC 挤出配方。客户按应用自选：

##### **1 row**

单排

Narrow accent line · simple finishing edge

窄边点缀 · 简洁收边

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##### **4 rows**

4 排

Standard sandal trim width

凉鞋常用条带宽度

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##### **10 rows**

10 排

Bold statement trim · slipper centerpiece

气势条带 · 拖鞋主装饰

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##### **14 rows**

14 排

Maximum visual impact · evening / decorative footwear

视觉冲击最强 · 晚宴 / 装饰鞋

---

ADDITIVE-FREE

**LOCA's PVC Strip uses a special additive-free formulation.**

This is relevant for buyers in markets with phthalate or plasticizer regulations — EU REACH, US footwear safety standards, certain Middle East import requirements. Specify your market's formulation requirements at order time so LOCA can confirm compliance before bulk runs.

这一点对有邻苯二甲酸酯 / 塑化剂法规的市场买家相关 — 欧盟 REACH、美国鞋类安全标准、部分中东进口要求。下单时把目标市场的配方要求写清 · 乐卡量产前确认合规性。

RECOMMENDED APPLICATIONS · 推荐应用

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**Sandal trim**

凉鞋装饰条

Most-common use case — rigid strap surface, decorative continuous trim.

**Slipper bands**

拖鞋饰带

Front-cover bands, vamp accents on slipper bodies.

**Footwear edge accents**

鞋类边线

Edge trim on rigid sole or hard panel surfaces.

**Wholesale / import trim**

批发 / 进口辅料

Sold by the meter for downstream factories doing their own application.

PVC Strip is operationally simple once the latex application is dialled in. Most issues come from substrate prep or latex application volume:

PVC 亮条乳胶用量调好之后 · 操作很简单。常见问题来自承接面准备或乳胶用量：

**Strip lifts at the edge after curing.**

固化后 · 条带边缘翘起

**Cause:** insufficient latex coverage at edges; or substrate not properly cleaned (oils, dust, release agents preventing bond).

原因：边缘乳胶涂布不足；或承接面未清洁干净（油渍、灰尘、脱模剂阻碍粘合）。

**Fix:** ensure latex covers the full strip back — especially the edges; degrease substrate with isopropyl alcohol before application.

处理：确保乳胶覆盖整个条带背面 · 尤其边缘；用异丙醇清洁承接面再涂胶。

**Visible glue line at the strip edge on finished product.**

成品上 · 条带边缘有可见胶线

**Cause:** latex application too generous — excess squeezed out during press.

原因：乳胶用量过多 · 压贴时被挤出。

**Fix:** reduce latex per-meter usage; apply in a thinner consistent layer; press more slowly to allow displacement before squeeze.

处理：减少每米乳胶用量；涂得更薄更均匀；慢慢压贴 · 给胶位移留时间。

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## **When something goes wrong — check this first.**

出问题时 · 先查这一页

*Cross-product symptom-to-cause-to-fix table. Most issues that show up after a rhinestone trim or motif application trace back to seven recurring causes: temperature, pressure, dwell time, surface prep, storage, fabric chemistry, or pair fitment. This page collapses diagnosis from a multi-day email round-trip to a one-page lookup.*

跨产品的"症状 → 原因 → 处理"对照表。水钻抽条或 motif 应用出问题 · 根因多数能追到 7 类反复出现的原因：温度、压力、时间、表面处理、储存、布料化学、配对装配。这一页把诊断从多轮邮件往返 · 压缩到一页查得到。



*The Pujiang main floor — every troubleshooting answer in this manual traces back to a station here.*

浦江主车间 · 本指南里每一条故障答案 · 都能在这里找到对应的工位

SYMPTOM → CAUSE → FIX · 症状 → 原因 → 处理

### **Rhinestones fall off after application.**

应用后 · 水钻脱落

**Likely cause:** hot-fix temperature too low (under 170°C), OR press time too short (under 12 sec), OR surface contamination (oil, dust, sizing chemical on fabric).

可能原因：烫钻温度太低（低于 170°C）· 或热压时间太短（少于 12 秒）· 或表面污染（油、灰、布料上的浆料化学）。

**Fix:** verify press calibration with thermometer (target 180°C); extend dwell time to 15 sec; pre-clean fabric surface with isopropanol wipe before application.

处理：用温度计校准热压机（目标 180°C）；延长热压时间到 15 秒；应用前用异丙醇湿巾预清洁布面。

### **Adhesive yellowing / discoloration after storage.**

储存一段时间后 · 胶层泛黄 / 变色

**Likely cause:** UV exposure during storage (sunlight on shelf), OR storage temperature above 30°C, OR shelf life exceeded (use within 6 months of receipt).

可能原因：储存期紫外线照射（货架受日晒）· 或储存温度高于 30°C · 或超过保质期（收货后 6 个月内用完）。

**Fix:** store in opaque packaging away from windows; keep storage area under 30°C; rotate stock first-in-first-out.

处理：用不透光包装储存 · 远离窗户；储存温度 30°C 以下；先到先用 FIFO 轮转。

### **Diamond Rope strap separates from fabric backing.**

水钻抽条与布底分离

**Likely cause:** inner-core selection mismatch for the application (cotton in a wet-environment use, EVA at extreme temperature, PU in heavy-flex motion).

可能原因：内层选型与应用不匹配（潮湿环境用棉芯、极温下用 EVA、高频弯曲用 PU）。

**Fix:** consult the DR application page for inner-core selection by environment (PART 07); re-order with corrected inner-core specification.

处理：参考 DR 应用页按环境选内层（PART 07）· 用正确的内层规格重新下单。

### **BDS strip wrinkles or peels at bangle curve.**

BDS 在手镯弯曲处起皱或脱粘

**Likely cause:** BDS width too wide for the bangle curvature (3mm and 6mm widths conform better than 12mm+); OR adhesive backing not fully activated by pressure during application.

可能原因：BDS 宽度跟手镯曲度不匹配（3mm 和 6mm 比 12mm+ 更顺曲度）· 或应用时压力没让自粘背胶完全激活。

**Fix:** for tight-curve bangles (under 6cm diameter), use 3-6mm widths; press firmly along entire strip length for 30 seconds; check page 09 for full BDS application guidance.

处理：紧曲度手镯（直径 6cm 以下）用 3-6mm 宽；沿整条 BDS 均匀按压 30 秒；详见 PART 09 BDS 应用页。

### **Diamond Flower 3D shape flattens during shipment.**

运输中 · 钻花立体形状被压扁

**Likely cause:** carton stacking during transit (too many pieces in one box, pressure on lower layers).

可能原因：运输中整箱堆压（一箱装太多·下层受压）。

**Fix:** request smaller-batch packaging (max 50 pieces per box for 7×7cm motifs and larger); place "do not stack" labels on cartons; see PART 10 for DF storage and care.

处理：申请小批量包装（7×7cm 以上的 motif·每箱不超过 50 件）；箱外贴"勿堆压"标签；详见 PART 10 钻花储存与维护。

### **PVC Strip yellowing or hardening within months.**

几个月内·PVC 亮条泛黄或变硬

**Likely cause:** formulation incompatibility (some markets require lead-free, phthalate-free PVC compliance), OR end-product exposure to extreme heat (car dashboard, sun-exposed shoe display).

可能原因：配方合规性（部分市场要求无铅、无邻苯 PVC）·或成品暴露在极端高温（车内仪表板、日晒鞋架）。

**Fix:** declare target market at order time (EU REACH / US CPSIA / India BIS); LOCA adjusts formulation to comply; for sun-exposed end use, request UV-stabilized PVC formulation.

处理：下单时声明目标市场（EU REACH / 美国 CPSIA / 印度 BIS）·乐卡按合规标准调整配方；日晒成品用途·请求 UV 稳定配方。

### **Shoe Upper left-right pair mismatch detected after receipt.**

收货后·发现鞋面左右配对不对

**Likely cause:** hand-finish stage 3 variation in dense-pave designs (see PART 12 SU common problems).

可能原因：密集嵌钻款式·第 3 步手工修整阶段的小比例左右差异（详见 PART 12 SU 常见问题）。

**Fix:** report mismatched pairs to LOCA within 14 days of receipt; LOCA replaces no-charge. Always inspect by single-layer flat lay before bulk sole-assembly.

处理：14 天内反馈不对称配对·乐卡免费替换。装鞋底前·单层平铺目视检查所有配对。

WHEN IN DOUBT

**Send a photo + product code to LOCA before scaling production.**

A clear photo of the symptom + product SKU / order reference + brief description of the application environment lets LOCA's technical team diagnose within one working day. Pre-bulk diagnosis saves orders of magnitude more than post-bulk remediation.

不确定时 · 量产前先发症状照片 + 产品 SKU / 订单号 + 应用环境简述给乐卡。技术团队 1 个工作日内诊断。量产前诊断比量产后补救节省一个数量级的成本。

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## Care notes for end customers.

### 终端消费者的成品维护说明

*Most rhinestone trim and motif applications hold for years under reasonable care. This page collects what LOCA asks its B2B buyers to pass down to their end consumers: a short list of do's and don'ts that prevent the avoidable failures (chemical exposure, machine wash, harsh storage) from coming back six months later as warranty claims.*

多数水钻抽条和 motif 应用 · 正常维护下能挺好几年。本页整理乐卡告诉 B2B 客户、再让客户传给终端消费者的几件事：简单的"该做和该不该做" · 能避免化学接触、机洗、储存不当这些可预防的失败 · 不会 6 个月后回头变成保修索赔。



*The Pujiang loading bay — pallets stage for export here, each one labelled, weighed, and checked against the same list.*

浦江装货平台 · 每一垛货都在这里上托 · 同一份清单 · 称重、贴标、过检

## STORAGE · 储存

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### Temperature

温度

Below 30 °C ideal; never above 40 °C

理想 30°C 以下；绝对不超过 40°C

### Humidity

湿度

40-60% RH; avoid extreme dry or extreme humid

相对湿度 40-60%；避免极干或极潮

### Light

光照

Store in opaque packaging; avoid direct sunlight

不透光包装储存；避免直射日光

### Stacking

堆压

3D motifs: single-layer flat with divider sheets. Flat trim: rolled loosely, not folded sharp.

3D motif: 单层平铺加隔板。平面抽条：松卷储存 · 不要锐角折

### Shelf life

保质期

Use within 6 months of receipt for best adhesion / colour stability

**PRE-APPLICATION CHECKLIST · 应用前检查**

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- **Surface clean:** wipe target fabric with isopropanol or clean cloth; remove sizing, oil, dust.
  - **Temperature verified:** check press calibration with thermometer; never trust dial alone.
  - **Sample test first:** run a 5-10 cm test piece on the exact target fabric; verify hold strength + colour stability before bulk.
  - **Pair-match (SU only):** verify left-right symmetry on flat surface before sole assembly.
  - **Spare crystals (DF only):** confirm 2-3% spare crystals received; spot-check for any shipment-loose stones.
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- 表面清洁：用异丙醇或干净布擦目标布面 · 去除浆料、油、灰。
  - 温度核对：用温度计校验热压机 · 不要只看刻度盘。
  - 先小样测试：在目标布料上跑 5-10 cm 试片 · 验粘合强度和色稳定 · 再量产。
  - 左右配对 (SU only)：装鞋底前 · 单层平铺验左右对称。
  - 备用水钻 (DF only)：确认收到 2-3% 备用钻 · 抽检有无运输松动。

**END-CUSTOMER CARE (PASS-DOWN NOTES) · 终端消费者维护 (传递说明)**

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**No machine wash**

禁机洗

Tumbling action loosens rhinestone bonds. Hand-wash gently with cool water and mild soap.

**No dry-cleaning solvents**

禁干洗溶剂

Perchloroethylene and similar solvents soften adhesive backing. Spot-clean only.

**No high-heat exposure**

禁高温暴露

Avoid leaving rhinestone garments / shoes in hot cars, near radiators, in direct summer sun for hours.

**Avoid perfume / hairspray contact**

避免接触香水 / 喷雾

Apply perfume and hairspray before wearing rhinestone accessories. Direct spray can damage stone facets and adhesive layer.

**Air-dry only**

仅自然晾干

Never use machine dryer or hairdryer. Pat with soft towel and lay flat to dry.

**Storage between uses**

不穿戴时储存

Wrap in soft cloth or store in original packaging. Avoid pressure from other items on top.

FOR BRANDS SELLING LOCA-DECORATED PRODUCTS

**Include a simple care card with each retail unit.**

A 5×5 cm care card with four lines — "no machine wash, no dry-clean solvents, air dry, store flat" — cuts warranty claims by an order of magnitude. LOCA supplies translated care-card templates in English, Chinese, Hindi, Portuguese, and Arabic on request.

在零售单元里加一张 5×5 cm 维护卡·列四条："禁机洗·禁干洗溶剂·自然晾干·平铺储存"·能把保修索赔降低一个数量级。乐卡按需提供英、中、印地语、葡语、阿拉伯语五种语言的维护卡模板。

## All eight product lines covered. Plus Quick Assistance and Care & Handling.

8 条产品线全部覆盖 · 加跨产品故障排查表与成品维护说明

*Edition 2.0 of the LOCA Application Manual covers all eight product lines: Crystal Mesh, Diamond Rope, Diamond Lace, Bangle Diamond Sticker, Diamond Flower, Shoe Patch, Shoe Upper, and PVC Strip. The Edition adds a cross-product Quick Assistance troubleshooting table and Care & Handling notes for finished accessories. Future editions will translate selected pages into Hindi and Portuguese for the India and LATAM markets.*

乐卡应用手册第二版覆盖全部 8 条产品线：水钻胶网片、水钻抽条、水钻胶条、手镯钻贴条、钻花、鞋花、鞋面、PVC 亮条。本版加跨产品故障排查快速对照表 · 以及成品维护与售后说明。后续版本会把核心页翻译为印地语 / 葡语 · 服务印度和拉美市场。

FOR SAMPLING OR TECHNICAL QUESTIONS

### **Send product photo, target application, target volume.**

LOCA's development team responds within 24 hours on weekdays. A clear brief shortens the first sampling round dramatically — see the Motif Brief guide for what to include.

乐卡开发团队工作日 24 小时内回复。一份清楚的 brief 能大幅缩短第一轮打样时间 — 见 Motif Brief 指南。

WhatsApp · +86 186 0677 6000

Email · Lucky@locacrystal.com

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LOCA APPLICATION MANUAL · EDITION 2.0 · V2.0 COMPLETE · MAY 2026

**PUJIANG LOCACRYSTAL® ACCESSORIES CO., LTD.**

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Est. 2009 · Pujiang & Yiwu, Zhejiang, China · OEM / ODM available