

**Codes starting with G and Custom Glass Decals should be fired according to this Guide.**

## **Digital Glass Decal Application & Firing Instructions**

**1/** Cut the motif from the sheet; for decals made with fluxed covercoat, cutting closer to the image minimises the appearance of the flux halo.

**2/** Place decal in container of tepid warm water until paper curls; remove from water and leave for 20-30sec until decal slides free of backing paper. This prevents the adhesive from dissolving away in the water and minimises water take up into the decal. Adding a drop of washing up liquid to the water can help reduce surface tension and makes bubbles easier to remove. Make sure the piece to be decorated is not cold.

**3/** Slide decal from backing paper face up onto wet finished ware. Proceed to "squeeze" out all the water making sure there's **NO** moisture or bubbles underneath. Take extra care over dark areas as the water is harder to remove from these areas and will show any pin holes more readily than lighter areas. **Ideally use a Decal squeegee for this.** This process takes time and care. If the piece to be decorated is not flat, use heat (hot water or heat gun) to make the decal more flexible.

**4/** Wait **AT LEAST 24** hours for decal to dry. Lower temperatures or higher humidity increases drying time. The acid test for dryness is to set a small kiln at 100 C and insert a decorated piece for 5-10 minutes. If wet, the decal shows water blisters; if dry it stays flat and goes shinier. Digital glass decals take longer to dry completely than conventional decals.

**5/** Fire slowly up to 95C to allow any remaining moisture to evaporate, then up to (580-600)°C\*.

**6/** Ideal firing cycle 0-95 in 120min; 95-420 in 300min, hold 10min, 420-(580-600°C) in 90min, hold 10 min, then off. If it is humid or you want to reduce the drying time, increase the time from 0-95 degrees.

**\*NB.** These instructions are intended to be used as a guide only. Please test fire all decals before use to determine the optimum temperature for your kiln.