



Innovative Ceramic Corporation

Creative Solutions to Product Identification & Decoration

Applying And Firing Recommendations for Waterslide Decals

1. Place the decal in 20-23°C water. The room and ware temperature should be 18-25°C (65-75°F). Only place enough decals in the water that will be use in about ten minutes. If the decal sheet dries out, the motif will adhere to the backing paper and become unusable.
2. Once in the water, the decal will curl up.
3. After approximately 10 seconds the decal will start to uncurl.
4. Remove the decal from the water before it lays flat and separates from the paper. Place the decal on a towel for approximately 30 seconds (time is required for the water to activate the adhesive). For a small decal, it is easier to use tweezers to remove the motif from the water to towel. And then from the towel to the ware.
5. Take a wet squeegee and wet the surface where the decal will be position.
6. Take the decal from the towel and slide the decal off the decal paper on to the clean ware (substrate). Because of step five, the decal should easily slide into position.
7. Squeegee the decal from the center to remove water and air.
8. Take a dry cloth and remove excess water from the decal and the substrate.
9. Before firing the ware make sure the ware and the decal are completely dry. If you are air-drying, wait 24 hours.
10. The firing should be in an oxidizing atmosphere with good ventilation to burn off the organic materials in the decal. A slow firing rate (~4°C/minute) is required until the organic materials are burned off at (454°C). A fast firing rate during this period will trap gases under the decals producing pinholes and blisters in the final design.