



Innovative Ceramic Corporation

Creative Solutions to Product Identification & Decoration

Applying and Stoving Recommendations for Non-Firing Waterslide Decals

1. Place the decal in 20-23°C water. The room and ware temperature should be 18-25°C (65-75°F). To prevent the accumulation of gum, the water should be change at frequent intervals. A gum residue will impair the finished results. 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 ten 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).
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 back paper on to the clean substrate. For a small decal, it is easier to use tweezers to remove the motif from the water and towel. 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. Dry the substrate at ambient temperature for minimum eight hours. With tweezers lift the covercoat edge and gently peel the covercoat away.
10. It is not necessary, but colors toughness and adhesion will improve by stoving at 100°C (212°F) for thirty minutes.