



Overglaze Decal Preparation for PGP Printers Team

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- Overglaze decals can be applied to low and high fire ceramics but they require a pre-fired, already-glazed glossy surface for the best results.
- They like to be applied to smooth surfaces; the more texture the harder it will be to get the decal to adhere evenly. Since there is no white ink in the printer, please consider what your background colour is going to be.
- Overglaze decals are best suited for glossy white or off-white glazes.
- The lamination used on the sheets contains a small amount of flux so there is a slight raised line that can appear around the decal image, thus the need to cut as close to the image as possible.
- We can get pretty close to many colours, but the printer uses China paint, not paper ink, and matching colours is almost impossible.
- Apply the decals on your pieces at least 12 hours to dry before firing or if you need to put them in the kiln right away, let them preheat for an hour or so before letting the cycle go.

Application and Tips

- Your wares need to be clean of grease and dust.
- Cut out the image as close as possible to the edges.
- Place them in warm water for about **5 seconds**. Place them on a clean surface for another **5 – 10 seconds** until the printed image starts to slide off the backing paper...feels kind of slimy. This means the decal is ready to apply to the surface. Do not soak for too long or the adhesion will not work! ** this is recommended for the Lamination Film A4 sheets One-Step DPP that we are currently using.
- As you position the decal on your work, you have a little time to slide it exactly where you want it.
- Once you have set it in place, take a soft rubber rib and gently squeeze out the water or air bubbles. Any water or air trapped between the decal and surface will stay in place and you will be left with a bare spot in that place.

Firing and Temperature Recommendations

- These decals like lots of air flow and so it is important to NOT stack the kiln too tight.
- Try not to place the decal side of your pieces too close to the kiln elements.
- You will be firing your wares to approximately Cone 012 in a slow bisque.
- You can also use Enduring Image's firing schedule if you want to set this up on your kiln's computer: It is a two-step firing program to increase a positive result:
 - Step 1 - 70°F-788°F at 200°F per hour and 0 hold.
 - Step 2 - 788°F-1616°F at 285°F per hour and 15 minute hold.