

## Directions for Use

Before purchasing, determine which decal product suits your needs. Low-fire decals are generally fired to 1034-1074 degrees Fahrenheit. High-fire decals go up to 1300-1425 degrees Fahrenheit.

Always remember, decals go on your FINISHED, fire polished piece. DO NOT cap the decals with a top glass layer. Decal firing is the last step to your piece.

### Preparation

#### Preheating

The preheating process ensures best possible outcomes desired of your particular piece.

#### Ventilation

There are materials in the medium that need to burn off slowly. Ventilation prevents the materials from settling back on the glass. To achieve ventilation, use kiln posts to keep the lid open during the heating up stages. The lid should be open about 1-2 inches. Ventilation is crucial for a perfect gold or silver finish.

#### Pre-fused Glass

Decals work best when placed on pre-fused glass, which gives a smooth, even base for them to adhere to. This helps to prevent bubbles from forming and ruining the final product.

#### Materials Needed

Decal  
Pre-fused glass  
Glass Cleaner  
Water container  
Distilled Water  
Paper towel  
Kiln  
Prepared kiln shelf  
Kiln posts  
Protective glasses

1. Determine which glass you want as your background and fuse two or more pieces together to a full fuse to achieve a smooth piece.
2. Cut the decal to the desired shape and size.
3. Cleanse glass with desired glass cleaner. Dry the piece with a lint free towel.
4. Remove sheet of paper that is protecting the decal.
5. Pour distilled water into clean container.
6. Soak pre-cut decal in water until it can be easily slid off of background paper.
7. Slowly and delicately slide decal onto glass.
8. Blot decal with paper towel removing any unwanted bubbles from under decal.

9. Allow piece to dry thoroughly. All the moisture must be removed from the piece before firing in kiln. This may take up to 24 hours. Dry for a minimum of 12 hours.

## Kiln Procedure

1. Place piece on kiln shelf that has been either washed with kiln wash or protected with kiln paper.
2. Shut the lid or access. Use kiln posts to vent kiln about 1-2 inches
3. Start the kiln.
4. Heat kiln at approximately 250 degrees per hour to 350 degrees Fahrenheit and hold at this temperature for 10 minutes.
5. Increase heat.
  - Low Fire Decals:* Heat kiln at around 500 degrees per hour to 1000 degrees Fahrenheit and hold for 10 minutes.
  - High Fire Decals:* Heat the kiln at 350 degrees per hour to 750 degrees Fahrenheit and hold for 20 minutes.
6. Take piece up as fast as possible to final firing temperature.
  - Low Fire Decals:* 1034-1074 degrees Fahrenheit
  - High Fire Decals:* 1300-1425 degrees Fahrenheit
7. Soak at this temperature.
  - Low Fire Decals:* 8-10 minutes
  - High Fire Decals:* 12 to 15 minutes
8. Bring piece down to annealing temperature (900 degrees Fahrenheit for Bullseye Glass and 950 degrees for System 96 glasses) and hold for about 1 hour depending on thickness.
9. If the unit is built with heavy fire bricks, turn off and unplug the unit. If the unit is assembled with ceramic fiber, it must be kept on and monitored so that it does not cool down more than about 300 degrees Fahrenheit per hour.
10. When the temperature drops beneath 100 degrees Fahrenheit, the kiln may be opened.