

Instructions: Milestone Decals



Application:

1. Remove the layer of wax paper.
2. Fill a bowl or tray with clean, room temperature water.
3. Soak each of your decal sections (one at a time) in the water until it starts to uncurl and relax slightly (don't leave them to soak for too long as they will detach in the water).
4. Remove from the water and allow it to rest for a few moments. You will notice that the decal easily slides around on the backing paper when gently moved. The decal is now ready for use.
5. Make sure your glass/ceramic is clean as any dirt or grease will affect the fired result.
6. Pick up the decal with the backing paper and slide the decal from the paper onto your work. Do not apply upside down. Position the decal in the correct location and hold one edge with a finger. Using a squeegee remove all water and air bubbles from under the decal.
7. Wipe carefully with a clean cloth or paper towel to remove surface water.
8. When the decal has been on the glass/ceramic for a few minutes, it cannot be easily moved so make a final check for positioning and bubbles.
9. Allow to dry completely for 4-8 hours before firing.

Firing tips:

- Try backing the decals with a white or pale opal glass to visually enhance the effect of the decal, especially the digital decals which can appear transparent on clear glass.
- For best results with glass, apply decal to glass that has been taken to a full fuse. The decal can then be applied to a smooth surface for a second firing.
- **Make sure the kiln is well ventilated up to 535°C (1000°F)**
- **The decal should be fired very slowly below 260°C (500°F)**

Each kiln fires differently, below are suggested firing schedules only, results may vary so please use these schedules as a starting point.

Glass Firing Schedule

Segment	Rate (Degrees/hour)	Temperature	Hold
Segment 1	44°C (80°F)	85°C (185°F)	20 minutes
Segment 2	97°C (175°F)	204°C (400°F)	15 minutes
Segment 3	111°C (200°F)	316°C (600°F)	15 minutes
Segment 4	556°C (1000°F)	743°C (1370°F)*	10 minutes
Segment 5	999°C (999°F)	482°C (900°F)	1 hour
Segment 6	56°C (100°F)	371°C (700°F)	end

*for metallic decals take to 788°C (1450°F)

Ceramic Firing Schedule

Segment	Rate (Degrees/hour)	Temperature	Hold
Segment 1	28°C (50°F)	85°C (185°F)	20 minutes
Segment 2	83°C (150°F)	175°C (300°F)	15 minutes
Segment 3	139°C (250°F)	260°C (500°F)	15 minutes
Segment 4	333°C (600°F)	535°C (1000°F)	10 minutes
Segment 5	555°C (1000°F)	750°C (1382°F)	10 minutes

***Cone firing: On porcelain and ceramic fire at cone 017 or 017. If you have a slow setting on your kiln you can use it for the first part of the firing (below 500°F/260°C)**

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