

1. Unique product identification

1.1. Definition of transfer printing.

Kiln-fired transfers – decorative painting or graphical elements and motives of various patterns, sizes and shapes, single- or multicoloured, printed with ceramic colours or other agents, using silk-screen printing on transfer paper, covered with a covercoat with index number and production batch number.

1.2. Classification of transfers.

The classification process consists of a visual inspection of the transfer with naked eye, at 0,3 – 0,4 m distance, for compliance with the specification provided below.

2. Identification of technical parameters

2.1. Properties of transfers.

No.	Parameter	Value	Measurement method / equipment
1	Separation of transfer from the backing paper	Complete	Transfers dipped in water. Transfer should be easily separated from the backing paper after ca. 3 minutes.
2	Firing of covercoat	Complete	Visual inspection of fired transfers.
3	Transfer bond with the substrate (base item)	Permanent	Move the edge of knife and press manually over fired transfer (10x).
4	Abrasion of gold / platinum	None	Rub with dampen wooden stick and press manually over the surface of fired transfer (10x).

2.2. Types and sizes of acceptable and unacceptable defects.

No.	Defect	Defect specification	Occurrence rate
1	No colour	Part of pattern or colour missing as compared to the template.	Unacceptable
2	Colour shifts	Colours on the pattern are shifted.	Acceptable up to 0,3 mm.
3	Creases, folds	Paper creases on the pattern.	Unacceptable
4	Contaminations	Unintentional contamination of colours on the pattern or within the covercoat.	Acceptable up to 3 defects / sheet, up to 0,3 mm in diameter.
5	Defective covercoat	Incomplete coverage of the pattern with covercoat.	Unacceptable
4	Shades	Copies differ in colour intensity as compared to the template or arrangements.	Only minor acceptable*

* In consideration of technical and technological limitations, transfers may show minor differences in colour (visible with naked eye) that do not affects the decorating quality of the pattern.

3. Application

Printed transfers are applied to decorate glass, ceramic and enamel surfaces.
 The transfers are customized to customer requirements (base item, firing conditions, etc.).

Transfers can be applied exclusively by professionals for decorating glass, ceramics and applied enamel surfaces.

Before application, perform a firing test under suitable conditions of manufacture.

4. Packaging

Transfers are secured against sticking together with protective paper and packed in packaging paper, max. number of transfers – 100 pcs.

Waste material code: 150101 – pursuant to the Regulation of the Minister of the Environment of September 27, 2001 on the Waste Catalogue (Journal of Laws, no. 112, item 1206).

5. Labelling

Printed label containing the following data on each transfer:

- manufacturer name and address
- type of transfer printing depending on the substrate (base item)
- pattern number
- order number
- firing temperature
- waste code

Packaging label featuring the following data:

- manufacturer name and address
- type of transfer printing depending on the substrate (base item)
- pattern name / number
- order number
- date of manufacture
- quantity
- grade
- QC acceptance
- final user

6. Transport

Transfers are to be transported with covered means of transport. Protect against moisture and sunlight.

7. Storage

Store in rooms at 45 - 65% relative humidity and 15 - 25⁰C, arranged vertically.

Store for no longer than 6 months for transfers with noble metals, and 12 months for transfers without noble metals. Transfers produced with preparations containing matt gold or platinum – storage period of 1 month only.