



Bright Gold Paste for machine lining (neoprene) on porcelain PGP 6500 H

1 General Information

PGP 6500-20% H is a bright gold paste for machine lining neoprene on porcelain. The fired metal film shows a yellow gold colour shade. With the slow drying high viscos lining paste lines of up to 10mm width can be achieved.

2 Standard Firing Range

Substrate	Firing range
Porcelain	780 – 880°C

The firing result depends on the firing temperature, on the total firing time, the soak time and not least on the glass type. To achieve an optimized firing result, we therefore recommend a firing test under the users own individual conditions.

3 Properties of the preparations

The major characteristics of a Heraeus precious metal preparation are determined by its production recipe. From each lot produced, we take a sample and check defined characteristics.

In case of machine lining pastes we check the physical properties and the application properties compared to a predefined standard. After firing under standard firing conditions, we check the gold colour shade and the adhesion to the substrate. Controlling each single production lot assures the highest product quality and lot-to-lot consistency.

3.1 Processing

We supply bright precious metal preparations for machine lining neoprene ready to use. If the viscosity requires some adjustment, we recommend thinner V 170 H.

3.2 Storage

Printing pastes are subject to an ageing process. Therefore, we recommend using the material within 9 months. The material should be stored at room temperature (20°C). Cool storage – but no freezing – has a positive impact on the shelf life.

3.3 Consumption

The material consumption depends on the thickness of the applied precious metal layer. Under our conditions, the consumption is approx. 0,2 to 0,40g/100 cm².*

4 Properties of finished decorations

The properties of finished decorations are influenced by a number of factors which interact with each other: The precious metal preparation used application, substrate, possible substrate treatment and last but not least the

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firing conditions. We processed PGP 6500-20% H under defined, standard test conditions and run certain tests of the achieved precious metal decoration.

4.1 Dishwashing durability

All details as to whether decorations are dishwasher durable are to be regarded as approximate values, as test results vary widely according to the type of dishwasher, washing programme, washing-up detergent, water quality and firing conditions.

Heraeus tests whether finished decorations are dishwasher durable, roughly following the test-washing programme of the Technical Standards Committee for Material Testing (Fachnormenausschuss Materialprüfung) in a Miele continuous dishwasher. If a decoration withstands 500 washing cycles essentially without damage, we designate it as dishwasher durable. If it withstands 1000 washing cycles, we designate it as dishwasher resistant.

Test decorations prepared with PGP 6500-20% H proofed to be dishwasher durable.

4.2 Abrasion resistance

In tests decorations created with PGP 6500-20% H showed a good abrasion resistance.

4.4 Oxidation resistance

Being a material of yellowish gold colour shade PGP 6500-20% H does contain a certain amount of silver.

Under unfavourable conditions silver containing precious metal decorations can tarnish in the course of time. Especially the contact to cardboard boxes, high humidity and high temperature support the reaction of silver to silver sulphide.

5. Application recommendations

5.1 Preparation of the substrate to be decorated

Make sure that the surface of the object to be decorated is clean and dry. Dust, fingerprints and water condensation can affect the decoration while firing.

Take care that the objects to be decorated are not taken from a cold store into a warm shop. A fine condensation film may occur, which is not visible to the naked eye. This results in firing disturbance (pinholes) in the fired precious metal decoration. Allow enough time so that the items to be decorated can adjust to the decoration room temperature.

5.2 Application preparation

Please fill only 3/4 of the reservoir of the lining machine with the lining material. During the lining process part of the solvents will evaporate. Therefore please fill from time to time some fresh material into the tank.

Before you start regular production, take some time to determine the optimal application conditions:

- Roller hardness
For wider lines softer neoprene rolls are recommended, for thinner lines harder neoprene rolls show best results. As orientation point recommend the following neoprene rolls: Thin lines: Approx. 50 shore. Wide lines: Approx. 40 shore.
- Fixing the angle of incidence of the roller
The choice of the optimal angle is of great importance for good coverage of the applied material. Especially for wide lines and for the decoration of very arched areas or of hollows. Investigation of the optimal angle is essential.
- Rotations
The number of necessary rotations is influenced by the lining machine used (two or one rollers). Mostly 2 to 4 rotations are enough for a sufficiently strong and homogenous precious metal layer.
- Preparation fluidity

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The optimal preparation fluidity out of the reservoir onto the roller needs to be determined by testing. If too much material flows out of the reservoir the precious metal line tends to fray. A too thick layer can result in cracking, boiling up and matt areas of the precious metal decoration. If too little preparation is released, many rotations are necessary to reach a homogenous precious metal film. A too thin precious metal film has influence on the chemical and mechanical resistance of the fired decoration.

- After the application...

Please take care for dustfree surroundings during the application and the drying. The wet surface is extremely sensitive to dust. After drying, the decoration is not as dust sensitive as before, but the objects should be fired as soon as possible. Using heat radiators or infrared lamps, the drying time can be reduced to few minutes.

5.3 Cleaning of the lining machine

After finishing the application or at the end of the working day, the reservoir should be cleared and cleaned as well as the metal wheel, the brush or the roller. For cleaning of the stock container, the metal wheel or the roller we recommend our cleaners V 35 or V 39.

5.4 Firing

During the first heating phase the organic components of the preparation burn off. This process is completed at approx. 400°C. The gold film is formed. A constant, slow temperature increase, enough oxygen and sufficient ventilation are decisive for the quality of the fired precious metal decoration.

The firing profile considerably influences the mechanical and chemical properties of the fired decoration.

The rate of cooling has no major influence on the quality of the gold decoration, unlike the firing temperature and soak time. However, the firing process should not be stopped too abruptly after the soak time. If the rate of cooling is too fast, there may be a danger of damaging the article (cracks and broken glass).

5.5 Burnishing of the fired gold layer

After firing the burnish gold decoration needs to be burnished. The gold layer can be burnished with a burnishing machine or by hand with a glass fiber brush. An older method it to burnish the gold with sea sand.



6 Typical defects, root causes and countermeasures to prevent them

Defect	Possible Cause	Countermeasure
rough edge to the precious metal line	too much preparation was applied to the object	reduce preparation flowability and / or number of rotation
blurred contours, running gold	too much thinning of the product	leave the pot open for a while, so that some of the solvent can evaporate
	too much organic fumes in the furnace	reduce the number of objects and / or improve the ventilation
spots, firing disturbance	contaminations as dust, finger marks or water drops	clean the object before decorating
	problems with the furnace such as: <ul style="list-style-type: none"> • furnace atmosphere reduction • insufficient ventilation • too quick a heat up between 300-400°C • too many objects in the furnace 	<ul style="list-style-type: none"> • optimize air addition and ventilation • improvement of the ventilation • reduce the speed of heat up • reduce the number of objects
low mechanical resistance of the precious metal decoration	too low a firing temperature	increase the firing temperature
	the layer of the product is too thin	increase the layer thickness of the precious metal decoration
fine pinholes	pinholes can be released by moisture on the surface of the decorated object. Taking objects from a cool store into a warm shop gives invisible condensation on the surface.	give the goods time to take on the temperature of the decoration room and with that the possibility to evaporate the condensation film
bulg formation during application with neoprene roller	neoprene roller is too hard	use of a less hard neoprene roller
	paste has been thinned too much	let the solvents evaporate or add fresh preparation