

Vitreous Enamel Process at Stocksigns



Metal Shop
High quality, low carbon steel is cut to the required size or shape.



Degreasing
A high quality detergent degreaser is used to remove surface impurities.



Base 'Grip' Coat
Grip coat is sprayed evenly over all surfaces of the steel.



Firing Stage 1
The Grip coated steel is fired at a temperature of 860 C.



Top 'White' Coat
The white or base colour coat is sprayed on to the grip coated surface.



Firing Stage 2
The white is fired at 820 C in the furnace.



Print
Each colour is screen printed by hand using stencils.



Final Print Firings
Several firings take place at around 750C on multi colour signs.