

## INSTRUCTIONS

Thank you for purchasing ART CLAY SILVER 650 Clay Type.

Please read the instructions and directions carefully before use.

## WARNING

- If the clay is not dry enough before firing, bubbling may occur.
- Oxygen can be consumed and both smoke and gas emissions may result during firing. Always be sure to ventilate the workroom well.
- Do not place the just-fired and still hot clay on or near by any inflammable objects. It can cause a fire.

## CAUTION

- Take care not to get burned with the heated clay when drying, firing, and after firing.
- Keep this product out of the reach of children.
- If you get any of this product in your eyes or mouth, flush immediately with plenty of water and call your physician.

## [CHARACTERISTICS]

- ART CLAY SILVER 650 consists of pure silver particles, binding agents and water. The binding agent is produced from harmless pulp fiber.
- During firing, the pure silver particles solidify. The binding agent consists of carbon, hydrogen and oxygen, which when fired together results in the release of a small amount of carbon dioxide and steam.
- This product is low - fire clay that can be fired from 650°C/1200° F, and turns into pure silver (99.9%) after firing. The special formulation of this product allows for combining with glass, porcelain and ceramic materials, and is also suitable for firing with sterling silver findings or wire (use of SV925 and higher quality recommended and the firing temperature at 650°C/1200° F, holding time for 30minutes recommended).

\*Do not fire soldered pieces with 650 as the soldering temperature is lower than the firing temperature.

## [INSTRUCTIONS]

- This product is water-based. If the clay becomes stiff during shaping, add a few drops of water and knead it well.
- Take out only the necessary amount of clay. Place the rest of the clay in the original 650 bag or a plastic bag and keep it in a sealed container to prevent it from drying up.

- Do not use rubber bands to wrap the clay in plastic wrap (as they may discolor the clay).
- It may cause cracks during firing if the clay is not sufficiently dry, so dry thoroughly before firing.
- Some kilns show different temperatures variations from the actual one. It is known that silver will melt at 962°C/1758. F. It is therefore recommended that your firing temperature does not exceed 900°C/1652. F.
- Do not bend the fired piece with unreasonable pressure.
- Keep the clay indoors out of direct sunlight.
- Do NOT keep in a refrigerator.
- Use as soon as possible after unsealing the package.

#### [DIRECTIONS]

##### PREPARATION

- Take out the necessary amount of clay. When you use newly opened 650 or if the unused portion of 650 seems stiff, knead it well in the palm of your hand to soften.
- Because the piece will shrink 8 to 9% during firing, make the mold larger than the finished size.
- You may combine any unused portion of 650 with the original clay series (clay, paste and syringe types), but the firing condition should be same as the original clay series.
- It is necessary to dry the clay completely, so dry it in the following ways:

##### MOLDING & DRYING

<Conditions for Drying>

- Hair dryer: 10-15 minutes with a 1200w hair dryer. Place the dryer within 5-10cm/3 inches from the piece.
- Food Dehydrator: At least 10 minutes at 60°C/145. F
- Oven: At least 10 minutes at 180°C/330. F
- Cooking plate: At least 10 minutes at 150°C~180°C/300-330. F
- Kiln: At least 10 minutes at 150°C/300. F
- Natural dry: At least 24 hours at room temperature.

\*Do not apply heat over 250°C/480. F, otherwise the binders will burn away before firing and the shape of the piece can change.

##### **How to Tell When the Piece is Dry Enough**

Take the still-warm piece and place it on some stainless steel, glass or plastic sheet .

After 10~20 seconds pick up the piece. If there is no cloud of water vapor, it is dry. (It is easy to check for condensation on black stainless steel, glass or plastic.). If the piece is cold, warm first by hot air dryer for five minutes, then conduct the test as explained above.

## FIRING

### <Kiln Firing>

To fire, place the piece in a cold or warm kiln (below 300°C/570。 F). It is the safest to start with a cold kiln. Take at least 15 minutes to reach firing temperature. You may use any of the three firing temperatures and hold times listed below. If you are combining with other materials (i.e. man-made stone, glass), please check the appropriate firing temperature and hold time. If you are firing more than two pieces, make sure the pieces are not touching each other.

- 650°C/1200。 F - hold time 30 minutes
- 700°C/1290。 F - hold time 15 minutes
- 750°C/1380。 F - hold time 10 minutes
- 780°C/1435。 F and above - hold time 5 minutes.

\*You may fire 650 using a gas torch or on a cooking gas stove. Some restrictions and conditions apply. Please ask for the details from your supplier.

## COMPLETION

● The surface of the fired piece will be white and matte initially due to the crystallization of silver during the firing process but a luster can readily be obtained by polishing. ( i.e. Stainless brush, Burnisher, Sandpaper, File, etc.)

●The completed piece is pure silver(99.9%).

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·Manufacturer

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<http://www.artclay.co.jp/>