

Art Clay – Silver Firing and Finishing

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Firing – General Information

- Pieces must be completely dry before firing.
- The piece should be finished as much as possible BEFORE firing to eliminate much of the clean up in metal. (See: Finishing the Art Clay)
- Place the piece on a clean kiln shelf. The pieces should not touch each other, the kiln wall or the kiln floor.
- The kiln should be programmed according to the items being fired:

Regular Firing –Art Clay Silver

- Once the kiln beeps complete, crack the door to speed the cool-down process.
- Wait until the pieces are not glowing. They may then be removed with tongs and gently dropped into a dish of water.

Firing with Glass/ Porcelain/ Stones

For best results – do not open the kiln door until the kiln is UNDER 150°F. Pieces may be brought out at that time, but not quenched. DO NOT PEEK!!! The slow cool down will anneal the glass and reduce the possibility of stress cracking or of the glass popping off the metal. Porcelain or stones may be brought out earlier, but with risk.

Finishing the Fired Art Clay Piece

- Remember that most if not all of the finishing can and should be done prior to firing. This will greatly decrease and possibly eliminate the amount of time needed to finish the metal piece.
- Use small files or sandpaper to remove rough areas.
- Brush the piece with a medium-stiff wire brush. Steel or brass work well.
- A patina of Liver of Sulfur may be applied to the piece. Liver of Sulfur can be used hot or cold, diluted or strong. The piece can be dipped into the solution or it may be painted or dabbed onto the piece. Between applications, rinse the piece in running water to halt the coloring process. The piece may be wire brushed or burnished between applications or for a final finish.
- Possible final finishes include:
 - Wire Brush Finish
 - Burnished Finish
 - Tumbled Finish

Art Clay Silver/Gold Clay Type	Temp.	Ramp	Time	Additional Instructions
Regular Silver Clay: Clay / Slow Dry / Sheet Type / Paper Type / Paste / Syringe	1600°F 1560°F 1472°F	5	10 min. 20 min. 30 min.	Crack the kiln door once the firing is complete. May quench pieces once the kiln is below 1000 °F.
Regular Silver Clay with Stones	1600°F 1560°F 1472°F	5	10 min. 20 min. 30 min	Crack the kiln door once the firing is complete. DO NOT quench. Allow to air cool.
Regular Silver Clay with Porcelain / Ceramics	1472°F	5	30 min.	Do not quick cool the kiln. Do not quench.
Regular Silver Clay with Glass	1472°F	5	30min.	Clay is in green-ware state prior to firing. Glass is fired in place. Fire on bulls-eye paper. Do not open kiln until it is room temperature.
Previously Fired Regular Silver Clay w/Glass	1450°F to 1550°F	5	10 min.	The clay is pre-fired. Fire on bulls-eye paper. Do not open the kiln until it is room temp.
Regular Silver Clay with Cork Clay	1472°F	5	30min.	Do not open the kiln door during the firing process.
650 Silver Clay: Clay / Syringe / Paste / Overlay	1435°F + 1290°F 1250°F	5	5 min. 15 min. 30 min.	If this clay is combined with the original clay series, firing conditions should be the same as the original clay series
650 Silver Clay with Stones	1435°F + 1290°F 1250°F	5	5 min. 15 min. 30 min.	Crack the kiln door once the firing is complete. DO NOT quench. Allow to air cool.
650 Silver Clay with Porcelain / Ceramics	1435°F + 1290°F 1250°F	5	5 min. 15 min. 30 min.	Do not quick cool the kiln. Do not quench.
650 Silver Clay with pre- fused Glass	1250°F 1290°F	5	30 min. 15 min.	Clay is in green-ware state prior to firing. Glass is fired in place. Fire on bulls-eye paper. Do not open kiln until it is room temperature.
650 Silver Clay with unfused Glass	1600°F	5	5min.	Fire on bulls-eye paper. Do not open the kiln until it is room temperature.
650 Silver Clay with Cork Clay	1435°F + 1290°F 1250°F	5	5 min. 15 min. 30 min.	Do not open the kiln door during the firing process.
22K Gold Clay- Regular Firing	1830°F	5	1 hour	Air cool. Do not quench.
22K Gold Paste Wash over 650 Silver Clay	1560°F	5	5 min.	Leave kiln closed until under room temperature.

Firing Times / Temperatures for PMC

Follow Additional Instructions on Art Clay Firing Page

PMC Clay Type	Temperature	Ramp	Time
PMC Original	1650° F	5	2 hours
PMC +	1650°F	5	10 min.
	1560°F	5	20 min.
	1470°F	5	30 min.
PMC 3	1290°F	5	10 min.
	1200°F	5	20 min.
	1110°F	5	30min.

The only other major difference between Art Clay Silver and PMC is the shrinkage once the clay is fired:

Art Clay Silver shrinks 8% to 10%.

PMC Original shrinks 25% to 30%.

PMC + shrinks 12% to 15%.

PMC 3 shrinks 10% to 12% .

All of the shrinkage numbers are estimates and can vary depending on firing time / temperature and how the clay was handled before firing.