

# INSTRUCTIONS

Thank you for purchasing ART CLAY SILVER 650/ OVERLAY SILVER PASTE.

Read the Instructions and Directions carefully before use.

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## [CHARACTERISTICS]

●ART CLAY SILVER 650/Overlay Silver Paste (OSP) is “low-fire” silver clay in paste form, formulated specifically to use on glazed porcelain. ●Overlay Silver Paste is in a viscous, liquid form and water soluble, so that you can express 3 dimensional drawings on a surface of porcelain, ceramic or glass. ●After firing at applicable temperature ranging from 650°C/1200° F to 800°C/1470° F, it will turn into 99% silver form. ●During firing, the pure silver powder solidifies. The binding agent consists of carbon, hydrogen and oxygen resulting in the release of harmless carbon dioxide and steam during firing.

## [INSTRUCTIONS]

●Some silver settling may occur at bottom of the jar. Stir the paste well with a brush or metal spatula before use. ●This product is water-based and can dry up. Always keep the container tightly capped. (If it dries up, add a little water to recover its original state). ●To dilute the paste, take out the necessary amount and place it in a different container. Then, add necessary amount of water. Do not dilute it directly in the bottle. ●It is important that your kiln's pyrometer is functioning properly. \*The melting point of fine silver is 965°C/1769° F. ●Always be sure to ventilate the workroom when using a kiln.

## [DIRECTION]

Preparation → Overlaying → Drying → Firing → Completion

### Preparation

- Clean the surface of the ceramic or porcelain with alcohol, or soap and water to remove dust or oil which may interfere with the OSP sticking to the surface.
- Thin the OSP with water to the consistency needed in order to paint the surface.

### Overlaying

- Recommended thickness is less than 0.5mm. If the application is too thick, it may delaminate from the surface with the glaze after firing or by polishing.

### Drying

- The applied paste must be completely dried before firing. It may be dried in the following ways:
  - Hair dryer: At least 10–15 minutes with 1200w hair dryer. Place the dryer within 15cm/6 inches from the piece.
  - Food Dehydrator: At least 10 minutes at 60°C/140° F
  - Oven: At least 7 minutes at 180°C/356° F
  - Kiln: At least 7 minutes at 150°C/302° F
  - Natural drying: At least 1 hour at room temperature.

\*Do not apply heat over 250°C/482° F, or the binder will burn away and the OSP shape of the layer may change.

## Firing

● You must fire the piece with a programmable electric kiln, which is equipped with a temperature control.

● Ventilate your workroom well.

● To fire, place the piece in a cold or warm kiln (below 200°C/390°F). Ramp the kiln to the applicable temperature depending on the kind of porcelain, glass, ceramic or type of your project.

● Take at least 15 minutes to reach firing temperature.

\*Ramping time varies by type and size of the kiln. Please refer to your kiln manual.

### ① Firing OSP applied porcelain piece

Firing temperature	650°C/1202° F ~ 800°C/1472° F
Holding time	Not needed.

After reaching the selected temperature, turn off the kiln and cool down to 100°C/210° F.

### ② Firing OSP applied porcelain piece with combination of Art Clay Silver type.

Firing temperature	650°C/1202° F	700°C/1292° F	750°C/1382° F	780°C/1436° F	800°C/1472° F
Holding time	30min.	15min.	10min.	5min.	Not needed

After reaching the selected temperature, turn off the kiln and cool down to 100°C/210° F.

● Take out the piece after the kiln's temperature drops down below 100°C/212° F.

\*Quickly cooling the piece, such as quenching, may cause it to break or crack.

## Completion

● The surface of the fired area where OSP was applied, will be white and matte due to crystallization of silver, but a luster can be obtained by polishing. (i.e. Stainless blush, Burnisher, Sandpaper, File, etc.)

## [PRECAUTIONS]

● Keep the clay Indoors out of direct sunlight. ● Do NOT keep in a refrigerator. ● Use it soon after opening.

● When drying and firing, take care to prevent burns or fire. ● Ventilate your workroom well during firing.

● Keep this product out of the reach of children. ● If you get any of this product in your eyes or mouth, flush/rinse immediately with plenty of water and call your physician. ● Avoid contact with your skin. If skin irritation or itching occurs, wash with water and consult your doctor immediately. ● Do not place a ceramic or porcelain piece that has the Overlay Silver Paste applied into a microwave oven. ● It is important to follow the recommended instructions when using the Overlay Silver Paste in order to insure a successful firing.

Art Clay is a registered trade mark in 40 countries around the world.

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