



**HIGH FIRE Suitable for Firing ~ AUSSIE COPPER, SNOW WHITE COPPER, AUSSIE PINK BRASS & AUSSIE VINTAGE BRASS ~ Standard & SuperFlex Clays**

**Always test your kiln: Make some test pieces of each colour to establish your kiln temperatures before you fire a piece you have spent a lot of time working on. Every Kiln is different and you may need to adjust your Kiln by 5 to 10C. This is why testing your kiln is so important and you need to discover the right temperature for each clay for your own kiln!**

Fire as a part of a 2 fire schedule. Fire in a kiln. Fire in activated coconut carbon. Please remember this firing schedule is based on a cold kiln and thickness of the piece also is something you need to work out. If a piece is any thicker than about 5-6mm thick you may need extra time due to the thickness of the piece.

When rehydrating Aussie Metal Clay Make sure you use DISTILLED or DEMINERALISED WATER as it hydrates the clay better than ordinary water. Keep any moist clay in a sealed container so it doesn't dry out - we have found specimen containers you can purchase from the chemist to work very well or just use your own method.

**1st Fire: To burn out the binder** ~ There are 3 ways to burn the binder out of your pieces:

**TORCH:**

1. By torch burn off - Using a butane style torch slowly warm up the piece by moving the torch flame around the piece slowly allowing the piece to heat up. First you will see a little smoke as the binder burns out then a little flame. Place your flame onto piece in a circular motion bringing it to a nice pink colour and continue for 30-60 seconds then remove the flame, allow to cool and carefully remove the piece to the already set up firing pan and follow instructions for 2nd firing.

**KILN:**

2. Place on a wire rack in the kiln following the instructions; or

3. Place on a piece of 1" Kiln blanket, on a bed of activated coconut carbon at a depth of approx. 12-18mm under pieces. no lid on your container.

Ramp at 700C/1290F to 500C/932F

Hold for 30 to 45 minutes for complete burnout of organic binder

Let cool until about 200C/392F or room temperature before proceeding to 2nd fire.

**2nd Fire: To sinter the metal**

Once cool enough, you cover your pieces with activated coconut carbon so that each piece is covered by about 18mm and fire for the second time with a lid on your container

Ramping at Full ramp (which is 1000C/1832F), or if you are concerned about the thickness or delicacy of the piece you can use a slower ramp of 815C/1500F & hold at temperature of 970C/1778F

Hold time of 2 to 2.5 hours & let cool

Remove your pieces from the activated coconut once cool and your pieces are ready to brass brush, tumble & polish

For **video assistance** please go here: <https://www.youtube.com/channel/UCnqx2XbeOY77ti4H3RbQJoQ>

Please note that all Kilns are different and can fire at slightly different temperatures - our temperatures above are based on our brick kiln and in Australian conditions. Muffle kilns will require a different temperature. All kilns have their own "Sweet" firing temperature for each clay and you need to find this for your own kiln by doing individual test pieces on every clay before you make a piece that you spend hours of work on...

Please join our Aussie Metal Clay Hints, Tips & Artistic Design on Facebook  
<https://www.facebook.com/groups/2049625218595476/>

### **Mixing Instructions:**

**Standard Clays:** Mix Sparingly with enough Demineralised or Distilled Water to a form a crumbly clay then mix crumbly clay until all the water is absorbed. There is a fine line between Clay being right and too wet. If the clay becomes too wet let it sit uncovered until the evaporation of water allows it to be the right consistency. Let rest for at least 30 mins to allow the clay to settle

**SuperFlex Clays:** Mix in the SuperFlex component into the metal powder first then Sparingly with enough Demineralised or Distilled Water to a form a crumbly clay then mix crumbly clay until all the water is absorbed. There is a fine line between Clay being right and too wet. If the clay becomes too wet let it sit uncovered until the evaporation of water allows it to be the right consistency. Let rest for at least 30 mins to allow the clay to settle

NOTE: SuperFlex is best to be used in 2-3 weeks from mixing unless it is a make on the day clay - please check chart on the facebook page. You can however, roll out sheets and keep them refrigerated in a container free of condensation.

If you have any questions feel free to ask on the support group...

### **Tips and hints**

Storage: Make sure you store your clays a warm environment - not recommended below 5C

**Safety:** It is suggested that you use a P2 or N95 Mask when working with Aussie Metal Clay

### **Qualified Aussie Metal Clay Teacher:**

**Kim Booklass - Australia**

### **Sculptor, Teacher & Head of Product Development at AMC**

Kim is a highly qualified Aussie Metal Clay Teacher who has been working with Aussie Metal Clay since 2011. Kim has kindly donated her time to continue the growth of Aussie Metal Clay and gives you a free Skype Lesson. Kim is also available for classes for individual or groups on a private basis. [www.facebook.com/KimBooklassWearableArt](http://www.facebook.com/KimBooklassWearableArt)

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