

METAL CLAY FIRING CHART

Type of clay	Attributes	Firing temperature	Firing time (minutes)	Shrinkage (percent)	Firing method
Art Clay® Silver 650 also known as ACS650	Strong formula, suitable for items which encounter stress. Can be fired with glass, ceramics, select gems, Cubic Zirconia, and sterling silver.	1435°F/780°C	5	8-9	Hot Pot kiln/ butane torch/ programmable electric kiln
		1380°F/750°C	10		
		1290°F/700°C	15		
		1200°F/650°C	30		
Art Clay® Silver - Overlay Silver Paste also known as Lowfire Silver Overlay Paste	Formulated to bond to high-fire porcelain glazes. Paint paste onto glazed porcelain, ceramics, or glass in thin layers. Use for repairing low-temperature fired pieces.	1435°F/780°C	5	8-9	Butane torch/ programmable electric kiln
		1380°F/750°C	10		
		1290°F/700°C	15		
		1200°F/650°C	30		
Art Clay® Silver 650/1200 Low-Fire	The moisturizing binder keeps clay from drying and allows for special techniques like braiding and weaving. Dry completely before firing.	1200°F/650°C	Fire from cold kiln 30	8-9	Butane torch/ programmable electric kiln
Art Clay® Gold 22K	Can be applied as a paste onto greenware metal clay.	1832°F/1000°C	60	15	Butane torch (paste)/ programmable electric kiln
Art Clay® Silver - Paper Type	Thin, flexible sheet which can be folded, cut, draped, or layered. Will not dry out. Difficult to repair before firing. Thicker than PMC Sheet®.	1562°F/850°C 1472°F/800°C	Fire from cold kiln 20	8-9	Programmable electric kiln
			30		
			30		
Art Clay® Regular Slow Dry	Takes five times longer to dry and has more elastic properties. Dry completely before firing.	1562°F/850°C 1472°F/800°C	Fire from cold kiln 20	8-9	Butane torch/ programmable electric kiln
			30		
PMC3®	Strong formula, suitable for items which encounter stress. Can be fired with glass, ceramics, select gems, cubic zirconia, and sterling silver.	1290°F/700°C* 1200°F/650°C* 1110°F/600°C*	10	10-12	Hot Pot kiln/ butane torch/ programmable electric kiln
			20		
			45		
Aura 22® (22K gold)	Creamy paste which can be painted onto fine silver. Works best on clean, just-fired, unburnished metal clay.	1562°F/850°C 1472°F/800°C	10		Butane torch/ programmable electric kiln
			30		
PMC Sheet® also known as PMC Paper	Thin, flexible sheet which can be folded, cut, draped, or layered. Will not dry out. Difficult to repair before firing. Fired sheet is flexible and a single layer can be easily cut or punched.	1650°F/900°C* 1560°F/850°C* 1472°F/800°C*	Fire from cold kiln 10	10-15	Programmable electric kiln
			20		
			30		
			30		
PMC+®	Suitable for items which encounter stress. Can be fired with Cubic Zirconia.	1650°F/900°C* 1560°F/850°C* 1472°F/800°C*	10	10-15	Programmable electric kiln
			20		
			30		
PMC® also known as PMC Standard	Use for items which do not encounter stress.	1650°F/900°C*	2 hours	25-30	Programmable electric kiln
PMC Gold® 24K	Alone, soft and unsuitable for items which encounter stress. Can be thinned to a paste and applied to fired silver clay.	1830°F/1000°C	2 hours	25-30	Butane torch (paste)/ programmable electric kiln

* For strongest results, fire at 1650°F/900°C for two hours.