



Base Metal Clays

Long working times	No Residue	Carve + Sculpt	1-Hour Sinter	11-15% Shrinkage
--------------------	------------	----------------	---------------	------------------

Shaping

To begin, shape your creation by molding, rolling, or sculpting the clay. If you're assembling multiple pieces, simply moisten the surfaces or use a bit of moist clay to bond the surfaces together. For flat pieces, place a ball of clay on a non-stick surface and roll it to your desired thickness using a clay roller and depth gauges, like Clay Revolution's Adjustable Rolling Gauges. Apply a release agent like Liberation Spray to any surfaces that will touch the clay to prevent sticking.

If the clay cracks while you're working it, just add a drop of water and knead gently until you've reached your desired consistency. Always keep unused clay stored in its original packaging, or a jar, to prevent it from drying out.

Drying

After shaping your piece, place it on a non-stick surface to dry. Slow drying is key to avoid warping and cracks. Project X can be safely dried at 200F when speed is a concern. To test if your piece is fully dry, gently warm it and place it on a mirror; if you see condensation, continue drying. Once dry, refine edges and surfaces by sanding. Keep in mind, the clay is fragile at this stage, so handle with care.

Kiln Firing

Phase 1- Burnout on Steel Mesh:

- Full Ramp to 800°F / 426°C
- Hold for 10 minutes

Allow your piece to cool. It will appear dark gray and be quite fragile at this stage.

Phase 2- Sintering in Carbon:

- Place your piece in a stainless steel firing container filled with Chromatic Carbon. Ensure your piece is surrounded by at least 1" of carbon on all sides. Layering pieces is fine as long as the spacing is maintained. Place a lid on top of the container.
- Full Ramp to temperatures listed below:
 - Copper: 1,800°F / 982°C
 - Red Bronze: 1,700°F / 926°C
 - Bronze: 1,600°F / 871°C
 - Light Bronze: 1,500°F / 815°C
 - White Bronze: 1,400°F / 760°C

Hold these temperatures for 1 hour. If a higher sinter is preferable, fire at the listed temperature and hold for 2 hours. To achieve the best color, allow your pieces to cool in the carbon. The pieces should be a bright orange to yellow color. Expect around 11-15% shrinkage during firing.

Polishing

The surface of the piece will have a matte finish. Use a wire brush, sandpaper or sanding sponges, rotary tools or other polishing equipment until the desired finish is achieved.

White Bronze is a brittle metal. After firing, it can break easily before the polishing has finished. Take extra precautions to handle the piece carefully and polish to a high shine for durability.

Safety

While rare, it is important to note that a few individuals may experience skin rash or itchiness upon contact with Project X clays. In such cases, it is advisable to cease using the product and seek medical advice from a physician. When handling Project X clay, it is essential to wash hands thoroughly, avoid ingestion, and ensure it is kept out of the reach of children.

We recommend wearing a dust mask while working with any powdered substances.

Use of kilns and torches should be done with caution. Kilns should be positioned on a stable surface, away from combustible materials, with a foot of open space on all sides. When working around heat, wear appropriate clothing and avoid clothes made with synthetic fabrics. Eye protection should be worn at all times when working with heat.