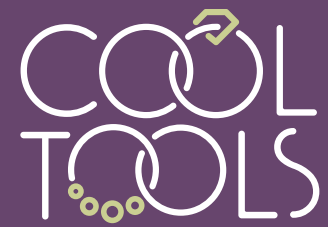


Accent Rose Gold™ Instructions



Accent Rose Gold™ is a gold-base product used to apply layers of 18k rose-colored gold accents to jewelry articles. It can be used on articles made from cast and wrought sterling silver, fine silver and fine and sterling silver metal clay. It is applied as a paste, dried, fired and then provided with the desired finish.

Mixing & Application - First Coat

- The surface of the article must be clean. Accent Rose Gold can be applied to recently fired silver surfaces, or the surface can be prepared by abrading with abrasive paper or a stainless steel brush. After using abrasion, wipe the surface clean with a wet cloth or alcohol.
- After opening a new container of Accent Rose Gold, add 4 or 5 drops of distilled water to the contents in the container. Stir with a brush. Add additional drops as necessary (start with just one or two) and stir again to make a syrupy liquid. Mix for about two minutes to ensure the paste is smooth and free of lumps. If it is too thin, let some of the water evaporate.
- Using a clean brush or clay shaper, dip into the container to capture some of the paste.
- Apply the first coat thick enough so that it is opaque to the silver beneath it. Cover the entire region of interest with the first coat. For broad, flat areas use a flat brush. If the texture is deep, a round pointed brush may be needed. Smooth the coat while wet to remove any lumps or bubbles. A hot plate is not recommended for drying.
- Air dry the first coat for at least one hour. After drying, the silver should be barely visible, if at all, beneath the coating.
- Close the container of unused Accent Rose Gold. The brush or clay shaper can be left to dry and then reused. Be sure not to lose any dried gold that may flake off. If this happens, return the loose gold particles to the original container for reuse.

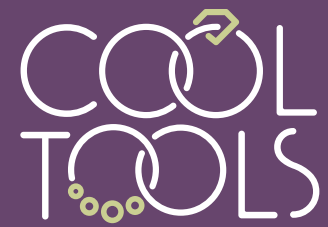
Mixing & Application - Second Coat

- First rehydrate the paste in the container by adding a few drops of distilled water. Also rehydrate the brush or shaper by using it to stir the paste into the consistency of smooth syrup. Mix a little longer to ensure lumps are removed.
- Apply Accent Rose Gold onto the piece by working quickly. Moisture can rehydrate the first layer which may pull up, leaving bald spots. If this happens, apply additional paste.
- Be sure the final coat is smooth and free of lumps. Any lumps will remain after firing and will require heavy burnishing to remove them. Using smooth brush strokes and a creamy mixture are essential to avoid lumps.
- Dry the second coat the same way as the first coat - at room temperature. A coated and dried piece can be left over night.

Effect of Kiln Type

Actual kiln temperatures may run either hotter or cooler than the indicated temperature. It is advisable to check your kiln temperature accuracy with a pyrometer. You can develop the best firing schedule for your

White COPPRclay™ Overview & Firing Guide



kiln by experimenting with small test pieces of silver coated with Accent Rose Gold before firing jewelry if you are not certain on the accuracy of the temperature. After firing, the Accent Rose Gold should burnish to a smooth layer. A rough layer indicates a firing temperature that could be too hot, or that there were lumps in the paste you applied.

Firing

- Use a stainless steel firing pan such as one used to base metal clay. Our standard firing pan is preferred. To prevent under-firing, do not use a larger sized pan. Fill the bottom of the pan with about 1/4" - 1/2" coconut shell activated carbon. Place the article on the activated carbon layer, and add 1" - 1-1/2" of activated carbon, and then place the lid on the pan. Do not fill the pan to the top with activated carbon, this will reduce the heating rate.
- Use kiln posts or fire brick to elevate the firing container so it is line with the heating elements in your kiln. Do not place the pan on the bottom of the kiln. Use a firing fork or stainless steel tongs to take the container in and out of the kiln. Practice with the tongs when the kiln is cool to minimize heat loss when you insert the pan into the heated kiln.
- The target firing temperature is 1245°F (675°C). Wear gloves! Preheat the kiln to this temperature, and then place the firing pan in the kiln quickly and close. The temperature will drop; when it returns to 1200°F (650°C), begin timing for 30 minutes.
- After 30 minutes, turn the kiln off and allow the kiln and pan to cool. Remove the pan after the kiln has cooled below about 500°F (260°C).
- For a programmable kiln, when the temperature reaches 1200°F (650°C) set the remaining firing time to 30 minutes and let the kiln do the rest.

Finishing

- The recommended method of finishing is first, burnish the fired layer, followed by tumbling in wet stainless steel shot for the final polish.
- Because 18k gold is harder than 24k and 22k gold, burnishing will require a bit more effort than burnishing higher karat gold layers.
- If brushing, use a stainless steel brush. do not use a brass brush because it will discolor the layer.

Cautions & Recommendations

- Use a small test piece, or pieces, to develop an acceptable method of both firing and finishing.
- Accent Rose Gold is not recommended for use within narrow or deep textures because of the difficulty in burnishing it after firing.
- Do not polish the fired layer with abrasive wheels. Doing so may wear through the material.
- Do not use liver of sulfur on Accent Rose Gold because it will cause discoloration. You can carefully paint liver of sulfur surrounding regions of exposed silver, but keep it off the layer of Rose Gold.
- Do not pickle with piece after firing because it will remove copper from the fired layer and possibly discoloration.