












## Drying Chart for Art Clay Series

|   | Drying Time                                  |   |      |                                  |
|---|--|---|------|----------------------------------|
|   | Hot Air Dryer                                | Cooking Plate                             | Kiln | Air Dry                          |
| ACS 650<br>              | More than 10 min.                            | More than 10 min. at 150°C / 302°F        |      | More than 24 hrs.                |
| ACS 650 Slow Dry<br>     | More than 45 min.                            | More than 20 min. at 150-180C / 302-356°F |      | Not recommended                  |
| Overlay Silver Paste<br> | More than 10 min.                            | More than 10 min. at 100C /212° F         |      | More than 60 min.                |
| ACS Slow Tarnish<br>     | More than 10 min.                            | More than 10 min. at 150C / 302°F         |      | More than 24 hrs.                |
| ACS Basic<br>          | More than 15 min.                            | More than 10 min. at 150C / 320°F         |      | More than 24 hrs.                |
| ACS Basic Slow Dry<br> | More than 45 min.                            | More than 20 min. at 150-180C / 302-356°F |      | Not recommended                  |
| ACS Paper type<br>     | No need to dry                               |   |      |                                  |
| ACS Oil Paste<br>      | More than 30 min.                            | More than 30 min. at 100C /212° F         |      | More than 24 hrs.                |
| ACG Clay type<br>      | More than 15 min.                            | More than 10 min. at 150C /320° F         |      | More than 24 hrs.                |
| ACG Paste type<br>     | (Undiluted)<br>More than 5 min.              | Not recommended                           |      | (Undiluted)<br>More than 15 min. |
|   | (Diluted)<br>Depending on the medium amount. | Not recommended                           |      | (Diluted)<br>NO                  |

- Test pieces used for this chart are in 5g clay volume.
- Hot air dryer used for this chart is 1200W and 3-4 cm from the drying pieces.

## Firing Chart for Art Clay Series

|   | Firing Temperature / Holding time (Kiln firing)                       |                 |                 |                 |                 |                 |                 |                 | Other Methods |           |        |        |
|---|---|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|---------------|-----------|--------|--------|
|   | 650°C<br>1202°F   | 700°C<br>1292°F | 750°C<br>1382°F | 780°C<br>1436°F | 800°C<br>1472°F | 850°C<br>1562°F | 870°C<br>1598°F | 990°C<br>1814°F | Stove top     | Gas torch |        |        |
| <b>ACS 650</b><br>   | 30min.  | 15min.          | 10min.          | 5min.           |                 | /               |                 |                 | YES           |           |        |        |
| <b>ACS 650 Slow Dry</b><br>                                      | 30min.  | 15min.          | 10min.          | 5min.           |                 |                 |                 |                 |               |           |        |        |
| <b>Overlay Silver Paste</b><br>                                  | 30min.  | 15min.          | 10min.          | 5min.           | 0min.           | /               |                 |                 | /             |           |        |        |
| (Holding time/ Fire from cold kiln)   |   |                 |                 |                 |                 |                 |                 |                 |               |           |        |        |
| <b>ACS Slow Tarnish</b><br>                                      | /   |                 |                 |                 | 30min.          | /               |                 |                 | YES           |           |        |        |
| <b>ACS Basic</b><br>   |   |                 |                 |                 | /               |                 |                 |                 |               |           | 30min. | 20min. |
| <b>ACS Basic Slow Dry</b><br>                                  | /   |                 |                 |                 |                 |                 |                 |                 | 30min.        | 20min.    | 10min. |        |
| <b>ACS Paper type</b><br>                                      |   |                 |                 |                 | /               |                 |                 |                 | 30min.        | 20min.    | /      |        |
| (Holding time / Fire from cold kiln)  |   |                 |                 |                 |                 |                 |                 |                 |               |           |        |        |
| <b>ACS Oil Paste</b><br>                                       | /   |                 |                 |                 | 30min.          | 10min.          | /               |                 |               | NO        |        |        |
| <b>ACG Clay type</b><br>                                       |   |                 |                 |                 | /               |                 |                 |                 |               |           |        | /      |
| <b>ACG Paste type</b><br>                                      | Application on fired ACS<br>500°C(932°F) → 800°C(1472°F) / hold 5min. |                 |                 |                 |                 |                 |                 |                 | YES           | NO        |        |        |
| Application on porcelain surface<br>Cold kiln → 800°C(1472°F) → switch off → under 100°C(212°F) to take out                                       |   |                 |                 |                 |                 |                 |                 |                 | NO            |           |        |        |
| Application on glass surface<br>Cold kiln → 800°C(1472°F) / hold 5min. → crash cool to 600°C(1112°F) → close kiln door → natural cool to take out |   |                 |                 |                 |                 |                 |                 |                 |               |           |        |        |

● Test pieces used for this chart are in 5g clay volume.