



CHINA SILK™

## The basics of how to cast perfect porcelain every time.

You will need the following supplies:

Two 2- 4 quart pitchers (one with clean water in it)

large bowl of water to clean up with

Sponge, scalpel, Blue trimming knife, wooden spoon or dowel approximately 18" long, metal strainer approximately the dia. of the top of the bottle or less

Begin by testing the porcelain. Open the bottle and stir completely to the bottom with the wooden spoon. Ultra Chic has extreme buoyancy and it will release the wooden spoon quickly. Push the spoon to the bottom of the container and let go. It should bounce out of the bottle within 2 to 3 seconds or your slip is too thick. It is the quartz causing this and is what also causes the sagging problems when you pour with your slip this thick. The professional industry calls this "Liquid Memory". Pour a small amount of water into the gallon and mix completely to the bottom with the wooden spoon. Test with the spoon again and repeat if necessary until it is the consistency of light cream. You should be able to feel the difference just stirring the slip. Do not add too much water all at once or you can get it too thin.

Place the metal strainer over the pouring pitcher that is empty and pour enough of the gallon through the strainer to pour whatever you are casting. Do not try and pour too many at one time. Porcelain sets up and releases rapidly and you won't be able to stay caught up if you pour too many molds at once. Place the strainer into the bowl of water so that it doesn't dry out. Make sure that your mold bands are tight and that you can't force the mold open. Pour gently and without hesitation into the center of the mold until it is full. Now watch as the plaster pulls the water out of the porcelain. You will be able to see the slip sink down before your very eyes. Add a little more slip to the mold to keep it near the top. Watch the thickness and when it is the thickness you want, dump it back into the pitcher. Ultra Chic™ releases even when poured paper thin for such molds as ornaments.

Wait about five minutes and then use the blue knife and slide it around the pour hole, but not all the way into the mold. With the knife between the collar and the mold and your finger on the other side of the collar pull upward. This is called pulling the collar. Save this collar in an old gallon container and any pieces that you might loose while casting. We will reclaim this later.

Now remove the bands and lay the mold so that the seam of the mold is laying horizontally, not vertically. Allow it to sit for five minutes or so on small pieces and longer for larger pieces. Once you can pull gently on the top half of the mold and it lifts without resistance it is ready. Don't force it or you can break the piece. Allow the casting to sit in the bottom half of the mold for a while until it stiffens and comes out easily. Again, forcing it can cause it to crack. No need to protect the casting from air circulation with Ultra Chic™. No film or browning on the edges will occur.

- If you are not sure how thick your casting is you can test it. Use your blue knife and cut the collar in two places, about 1/2 inch apart. Cut it all the way from the top of the collar to the bottom. Now slide the knife between the collar and the mold and with your finger on the inside of the collar pull this small section upward. The bottom of this section will show you the exact thickness of the piece.
- If you are pouring a mold that has a very tiny pour hole and you are having problems getting the slip into that area, thin your slip more. China Silk™ can be thinned very thin and still release.
- When pouring large Spanish Figurine molds with small pour holes it is sometimes difficult to get it to dump. Try pulling and trimming the collar while the mold is still full of slip.
- When pouring something that has add-ons, such as fancy figurines, allow both the main piece and the add-ons to sit for about one half hour before assembly. If you try to assemble it too soon you can loose the piece by liquifying it. Once they have sat and stiffened you can clean them easily with a soft brush and tiny amount of water. Put slip between the pieces, add on the arm or whatever, and then flush that area with water to remove excess slip. Do not allow your piece to dry too much. If when it is dry you see a hairline crack between the two areas, you have waited too long.
- If you are in a hurry for a production piece you can set it in front of an electric fan and force it dry so that within an hour or so you can clean it.
- To reclaim toss your spare collars and broken pieces into an empty gallon container. When it is full fill it with water. You will hear what sounds like Rice Crispy's while the porcelain absorbs as much water as it can, as fast as it can. Let it sit over night or at least several hours. There will now be a water float on top. The porcelain has sunk to the bottom. Pour off the excess water and stir and strain the reclaim. You can now save this and feed it back into new porcelain at a rate of 25% reclaim to 75% new porcelain and not disturb the balance of the new porcelain.
- If you desire a piece to shrink more than it's normal 17% range then use pure reclaim to cast the piece. It will shrink more in the firing.
- When you are stirring your porcelain if you stir too fast you can cause air bubbles to appear in the slip. If this occurs then let the porcelain sit until they rise to the surface and dissipate. You can tap the sides of the gallon to decrease the time it takes to get them out. China Silk™ de-airs very rapidly and you shouldn't have to wait more than ten minutes.
- If a mold is sticking and you can not get the piece out try filling a misting bottle with distilled vinegar and mist the inside of the mold. The casting will come right out.

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