



# PMC CONNECTION

## FIRING SCHEDULE

The PMC pieces should be completely dried. This can be air dried or dried with a heat source such as a hair dryer, heating tray, electric griddle, food dehydrator or toaster oven. To verify that a piece is completely dry, place it on a mirror. Leave the piece on the mirror for several seconds and then remove it. Look on the mirror for a "ghost", a water vapor mark which is present if the piece is not completely dry.

When the piece is completely dry, fire it according to the applicable table.

**PMC+ and PMC3** are fine silver particles in an organic binder with water. When fired in a kiln or with a torch, the binder burns off, leaving a 0.999 fine silver piece. The PMC+ sheet contains no water and feels like a sheet of vinyl. It has a long shelf life and is highly resistant to drying. In both instances, shrinkage is about 10-12%.

PMC+ silver:	Temperature		Hold Time
	1650° F	900° C	10 minutes
	1560° F	850° C	20 minutes
	1470° F	800° C	30 minutes

PMC3 silver:	Temperature		Hold Time
	1290° F	700° C	10 minutes
	1200° F	650° C	20 minutes
	1110° F	600° C	45 minutes

**PMC Standard** also is made of fine silver particles in an organic binder with water. It has a shrinkage factor of about 30%. The firing schedule is as follows:

PMC silver:	Temperature		Hold Time
	1650° F	900° C	2 hours

**PMC 22 K Gold** is made of gold particles (24 K gold alloyed with fine silver to 22 K) in an organic binder with water. It has a shrinkage factor of about 14-19%. The firing schedule is as follows:

PMC 22 K gold:	Temperature		Hold Time
	1650° F	900° C	10 minutes
	1560° F	850° C	30 minutes
	1380° F	750° C	60 minutes
	1290° F	700° C	90 minutes

## **PMC and OTHER MATERIAL**

PMC, especially PMC+ and PMC3, works well with a wide range of other materials. Of particular interest is use of glass and ceramic materials with PMC3. When using these materials in combination, always remember to use the firing schedule which applies to the most sensitive material being used.

Thus, when using PMC3 with glass, the glass is the more sensitive material. Therefore, we recommend that the firing use a slow ramp (increase in kiln temperature) of about 1500° F per hour to the lowest PMC3 temperature (1110°F) for 45 minutes. At this temperature the glass will not change shape or fuse to the PMC. It is important to shape the PMC around the glass so that the silver will form a secure setting for the glass.

As always when firing glass, remember to guard against thermal shock. We recommend a natural slow cooling period to room temperature.

### **JUST KEEP ON KEEPIN' ON**

One of the wonderful aspects of PMC, PMC+ and PMC3 is the low level of waste. All three products, if they become dried, can be reconstituted by the introduction of small amounts water. Even after firing, you can place additional clay, in any of the four forms, onto a piece which requires additional work and refire the altered piece. You can repeat this process many times with no adverse effects on the piece. The materials are very forgiving and allow the user a great deal of flexibility in completing the final design. So relax and have fun. Your greatest efforts may await you in the next package of PMC.