



**FIVE STAR**  
metal clay

Light Bronze

*Superior Metal Clay  
Easy Firing Options  
Beautiful 10k Gold Color*





## About Five Star Metal Clays and Light Bronze

Five Star Metal Clays are new, revolutionary metal clays that have all the features you desire in base metals. They are simple and fast to fire. The ultra refined powders create a smooth finish for easy polishing. The clays are easily carved and work with cutting machines while also holding great sculpting detail. Five Star Metal Clays come in five metals; copper, red bronze, bronze, light bronze and white bronze. And, all five metals can be fired together in one firing.

Light Bronze is a wonderful metal to work with. The color is a rich 10 carat gold color and highlights almost any stone. It is easy to work with in clay state, fires in a kiln with activated coconut carbon and polishes to a high shine. Five Star Light Bronze Clay shrinkage rate is between 12% and 15%.

Five Star Light Bronze Clay can be formed, molded, rolled, sculpted, and shaped with very simple tools.

Basic tools include:

Non-stick work surface  
Rolling tool  
Depth measuring guides  
Molds and textures  
Stainless Steel Firing Box  
Activated coconut carbon

Release agent  
Cutting tool  
Kiln  
Burnisher  
Brass brush  
Steel mesh



## Working with wet clay



Five Star Light Bronze Clay is a wet clay you may work with immediately after opening the package. If the clay is drier than you would prefer, condition the clay by adding a little water and folding in thoroughly. Roll, mold and sculpt your pieces and allow to dry fully. Two pieces of clay can be connected with paste (slip). This can be achieved in the wet clay state or dry clay state. A thick paste is always better than a thin paste for attachments and regular clay is preferred whenever possible.

Any leftover clay should be stored in an airtight container for use later. A mist of water on the inside of the lid will help keep the clay moist longer.

## Drying and refining clay

Five Star metal clays must be fully dry before firing. Failing to remove all the moisture in a piece may cause air pockets with your finished work and may ruin the final piece.

Air drying with no heat is strongly recommended to avoid warping. As an alternate, a dehydrator will also achieve good results. It will take roughly 24 hours to dry the clay thoroughly. Flipping the pieces over during the first hour or drying will also help with warping issues. Thicker, larger pieces take longer to dry.

Sanding the edges and any flat surfaces should be done after the piece has fully dried. Sanding will minimize any unseen fractures on the edges thus reducing possible cracking during firing.



## Firing Five Star Light Bronze Clay

Five Star Light Bronze Clay should be fired in a kiln with activated coconut carbon. It is highly recommended that a stainless steel container and a lid with no holes be used. Activated coconut carbon should be placed inside the box and each piece of light bronze should have approximately 1" of carbon surrounding all sides. Clay Revolution recommends a two step firing schedule for the best results. Two firing options are provided for your convenience.



**Standard Option (recommended):** 1. Pre-heat the kiln to 1000°F; put the pieces in, on a steel mesh and fire for 5 minutes. Allow to cool slightly. 2. Place 1" of carbon into the steel container, place the pieces into the container leaving 1" between each piece and continue to fill with carbon until the box is full, place the lid on and put into the kiln. Fire at 1400°F for 1 hour. Allow to cool completely.

**Fast Fire Option:** 1. Pre-heat the kiln to 1000°F; put the pieces in, on a steel mesh and fire for 5 minutes. Allow to cool slightly. 2. In cool or pre-heated kiln, place the stainless steel container, with carbon and pieces inside the kiln WITH NO LID. Fire at 1400°F for 30 minutes, remove while hot and quench in water.

## Polishing Five Star Light Bronze

Once fired, the piece will be solid metal. Bronze can be polished with simple tools such as a brass brush and burnisher. Rotary tools and tumblers are also wonderful tools to save time and energy. To begin your polishing, brush the piece under water with a hard brass brush.

Flexible bristle disks are preferred as these will not leave compounds or metal discoloration on your pieces. Start with the coarsest grit and work your way down to the finest grit. You will notice that the metal is hard to polish in the initial state, but eases with each step. Continue until the desired finish is achieved.

Pickling and/or super pickling may also be done to brighten the bronze. We recommend Yurina Pickle as a safe pickling agent. Place the piece(s) in warm solution for 5-10 minutes. Rinse in a water bath with a little baking soda to neutralize the pickle, then rinse under water thoroughly.

Pickle will remove black oxide color and super pickle will remove copper/pink color. Super pickle is a solution of half pickle and half hydrogen peroxide.

