

## **Instructions for a basic Cone 04 Bisque Firing (Earthenware, Stoneware & Porcelain)**

### **Segment 1 50 degrees F per hour up to 200 degrees F and HOLD**

The length of the HOLD is based on the size, thickness, and moisture content of the load.

Holding here allows all the physical moisture in the clay to evaporate and dry. Water boils at 212 degrees F. If the kiln goes past 212 with physical moisture still in the clay, it will cause a buildup of steam and explode. This will destroy your work and potentially damage the kiln.

To ensure all physical moisture has been removed, pull the top peep plug and place a small jar or mirror over the top peep. Any remaining moisture will cause a fog of condensation in the jar or on the mirror. This indicates that you should continue to HOLD at 200 degrees F until all physical moisture is gone before proceeding to segment 2.

### **Segment 2 100 degrees F per hour up to 800 degrees F**

This allows time for the naturally occurring organics and gases in the clay to begin burning and or vapor out of the kiln. All clays contain organics and if not allowed adequate time to burn out, can get trapped and cause bloating of the clay or out gassing in later stages of firing that will show up in the form of pin holing in your glaze.

### **Segment 3 150 degrees F per hour up to 1300 degrees F**

This allows chemically combined water (on molecular level) found in all clay particulates, to dissipate/ dehydrate from the clay. In addition, it allows safe passage through the quartz inversion process. This is one of the vital stages of the firing, both on the way up in heating and on the way down in cooling. During this time free silica found in all clays will expand by 1% while remaining particulates are shrinking; silica process reverses on the cooling cycle. You can imagine the contraction that is happening amongst all those clay particles. It is very stressful on the clay and going through this phase to quickly can cause damage in the form of cracks.

## Segment 4 200 plus degrees F up to 1940 degrees F

Once you are past 1850 degrees F then most of the damage that can be done to clay has passed. Your clay is now considered "bisque" and has changed from clay to ceramic. Your bisque firing is now complete.

When firing is complete, shut down the kiln ensuring to seal it up the best you can to deter air drafting into the kiln. This includes turning off any vent system you may have. Allow the kiln to cool naturally. It takes the kiln approximately the same amount of time to cool as it did to bring it up to temperature. If your firing takes 13 hours to complete you can expect the cooling to take 13 hours.

It is of importance to proceed slowly through cristobalite inversion portion of the cooling. Cristobalite happens during cooling around 428 degrees F. During this time the silica that expanded earlier in the firing, now suddenly shrinks. Fast cooling at this temp can cause cracking.

Note: Some clay bodies are more susceptible to this process than others. It is always best to err on the side of caution.