

# CLAY MIXING INSTRUCTIONS: STONEWARE

## GENERAL INFORMATION:

- Always mix a single 100 lb. batch of clay if there is at least one bucket of scrap clay available. If no scrap clay is available, a double batch of dry mix may be made (200 lbs. dry ingredients).
- ALWAYS put scrap, vinegar, and water into the mixer before adding any dry ingredients.
- NEVER put dry ingredients into mixer before adding water, vinegar and water.
- The amount of water used depends on the amount of scrap being used and how wet the scrap is, so you're making an educated guess at best on the amount of water to use. It's always best to err on the side of a body that is too wet rather one which is too dry.
- A barrel of scrap should be filled only to the point where the bucket's handle is attached to the bucket.

## MIXING INSTRUCTIONS:

- The batch recipe uses approximately 100 lbs. of dry ingredients. This is added to water, vinegar and whatever scrap clay is used. The recipe is as follows:

<b>FIRECLAY:</b>	<b>65 LBS.</b>
<b>OM4 BALL CLAY:</b>	<b>15 LBS.</b>
<b>CUSTER FELDSPAR:</b>	<b>10 LBS.</b>
<b>SILICA:</b>	<b>3 LBS.</b>
<b>GROG:</b>	<b>5 LBS.</b>
<b>MULLITE:</b>	<b>7 LBS.</b>

- After putting the water, vinegar, and scrap in the mixer, turn it on and begin adding the dry ingredients, beginning with the fireclay and proceeding in the order that the materials appear in the above recipe.

## DETERMINING AMOUNT OF WATER USED:

- If no scrap is used, use 24 lbs. of water per 100 lbs. of dry ingredients (ALWAYS ADD 2 LBS. TO ACCOUNT FOR THE WEIGHT OF THE BUCKET!). For a double batch, this means you'll put 50 lbs. of water (including bucket weight) in the mixer before adding dry ingredients.
- If 1 bucket of scrap is used, use 16 lbs. of water.
- If 2 buckets of scrap are used, use 12 lbs. of water.
- If 3 buckets of scrap are used, use 9 lbs. of water.

REMEMBER: This is only an approximation of the water needed. It may prove to be too much (resulting in a pasty consistency of the body) or too little (resulting in the body getting very stiff prior to all dry ingredients being added to the mix). IT IS IMPERATIVE THAT YOU WATCH THE MIX CAREFULLY AS YOU ADD DRY INGREDIENTS TO INSURE THAT THE MIX IS NOT BECOMING TOO STIFF. If it is getting too stiff, begin sprinkling water into the mixer as it turns until mix is wet enough to continue adding dry ingredients. DO NOT POUR WATER INTO THE MIXER AS IT WILL FORM A POOL ON THE BOTTOM WHICH WILL CAUSE THE CLAY TO STOP BEING PUSHED THROUGH THE MIXER BLADES. Just sprinkle it in a little at a time!

- If your mix is like paste when all dry ingredients have been added and have mixed for several minutes, add the following: 4 scoops fireclay, 1 scoop ball clay

- If the mix is still too wet, repeat the 4 scoops fireclay & 1 scoop ball clay. If you need to do this a 3rd time, also add a 1/4 scoop feldspar, 1/8 scoop silica, 1/4 scoop grog, 1/4 scoop mullite.

- ONCE ALL INGREDIENTS HAVE BEEN ADDED AND YOU FEEL THE CONSISTENCY IS PRETTY CLOSE TO WHAT YOU WANT, CONTINUE MIXING FOR AT LEAST 5 MINUTES TO INSURE THAT ALL MATERIALS ARE THOROUGHLY BLENDED.

## CLEAN-UP:

- Unload clay; thoroughly clean mixer, sponging walls, blades, and floor to get rid of all residue.
- Thoroughly clean around mixer, sweeping floor and getting up all chunks of clay.
- Thoroughly clean scale and return to closet.
- Close partially used bags of ingredients and store in closet.
- Bag clay, using USED CLAY BAGS FIRST and thoroughly clean clay cart, wedging table, scale, and floor around wedging table and scrap barrel.