

72 Processes to Make a Piece of Porcelain (制瓷 72道工序)

a) mentioned in Tian Gong Kai Wu (天工开物) of Ming Dynasty Written by Song Ying Xing (宋应星)

b) Details provided by Master Tang De Gui (唐德贵大师)

| Process # | Process Name | Process  | Remarks   |
|-----------|--------------|--|---|
| 1         | 勘山           | Survey the mountain  | Done outside of Jingdezhen  |
| 2         | 烧矿           | Fire the surface mines   |   |
| 3         | 运石           | Transport the stones from the cave   |   |
| 4         | 碎石           | Break the stones before shipping   |   |
| 5         | 槽石           | Pulverize the stones with water pestle   |   |
| 6         | 制浆           | Process the clay   |   |
| 7         | 取泥           | Extract the clay   |   |
| 8         | 制不           | Form the brick   |   |
| 9         | 船载           | Transport by ship  |   |
| 10        | 存行           | Store in the shop  |   |
| 11        | 烧碱           | Calcine limestone & fern leaves as glaze ingredients   |   |
| 12        | 配釉           | Mix the glaze  |   |
| 13        | 炼泥           | Prepare the clay for saggar  |   |
| 14        | 镀匣           | Make the saggar  |   |
| 15        | 验匣           | Inspect the saggar   |   |
| 16        | 送厂           | Deliver to the kiln  |   |
| 17        | 化不           | Mix the bricks in water  |   |
| 18        | 陶洗           | Wash the impurities from the bricks  |   |
| 19        | 铲泥           | Use spade to pick up and throw the clay back and forth   |   |
| 20        | 踩泥           | Stamp on the clay  |   |
| 21        | 揉泥           | Knead the clay to remove air bubbles   |   |
| 22        | 做坯           | Form the clay body   |   |
| 23        | 修模           | Trim the mold  |   |
| 24        | 定型           | Fix the shape in the mold  |   |
| 25        | 利坯           | Shave the clay body to be 0.5mm in thickness   |   |
| 26        | 印坯           | the half-dry clay bodes placed in the mold after beating and pressing by hand                          |   |
| 27        | 刚坯           | Trim the porcelain base  |   |
| 28        | 取釉           | Remove the glaze at the base   |   |
| 29        | 削坯           | Trim the clay body   |   |
| 30        | 接坯           | Attach (handle or spout) to the clay body  |   |
| 31        | 棒坯           | Place clay body on a long wood plank   |   |
| 32        | 晒坯           | Dry up the clay bodies in the open area  |   |
| 33        | 盪釉           | Rinse the glaze in the inner side of the ware  | These are concurrent process, they need to do 2 or 3 out of these 5 processes |
| 34        | 吹釉           | Blow the glaze in the outer side of the ware   |   |
| 35        | 蘸釉           | Dip the ware in glaze liquid for outer surface of the ware   |   |
| 36        | 浇釉           | Pour the glaze onto the ware   |   |
| 37        | 捺水           | Brush the clay with water before glazing   |   |
| 38        | 补釉           | Touch up the clay body with glaze  |   |
| 39        | 配釉           | Mix the glaze for color ware   | For color ware  |
| 40        | 涂釉           | Brush the glaze for color ware   |   |
| 41        | 淡描           | Outline the design   | For underglaze  |
| 42        | 混水           | Apply cobalt blue washes to create 5 shades  |   |
| 43        | 捏雕           | Hand-pinching finishing touches on small objects   |   |
| 44        | 刻花           | Carve the design on the clay   |   |
| 45        | 驮坯           | Deliver 2 rows of clay body to the kiln  |   |
| 46        | 挑坯           | Deliver 5 stacks of clay body to the kiln  |   |
| 47        | 修匣           | Fasten the saggar  |   |
| 48        | 装坯           | Place the clay bodies into the saggars   |   |
| 49        | 加表           | Stack up the saggars to the top  |   |
| 50        | 满窑           | Load the kiln orderly  |   |
| 51        | 挑柴           | Pick up the firewoods  |   |
| 52        | 烧窑           | Fire the kiln  |   |
| 53        | 开窑           | Unload the kiln  |   |
| 54        | 装篮           | Pack the wares into the basket after cooling   |   |
| 55        | 调泥           | Mix the very thick clay for repairing the kiln   |   |
| 56        | 拏窑           | Repair or build the kiln   |   |
| 57        | 看色           | Sort the wares into 4 grades based on quality  | For overglaze   |
| 58        | 选瓷           | Select the matching wares for overglaze  |   |
| 59        | 搗料           | Grind the pigments with creamy liquid  |   |
| 60        | 格色           | Select the ground pigments   |   |
| 61        | 起稿           | Create design sketch   |   |
| 62        | 拍图           | Moisten the final design sketch with water and smack it so the design shows on the surface of the ware |   |
| 63        | 搓料           | Grind again and place the creamy pigments in palette   |   |
| 64        | 画瓷           | Draw the overglaze design on the wares   |   |
| 65        | 填色           | Fill up the colors on the wares  |   |
| 66        | 写款           | Write the reign mark on the base   |   |
| 67        | 满炉           | Put the overglaze wares into the kiln  |   |
| 68        | 烤花           | Bake the decoration on the wares   |   |
| 69        | 汇色           | Inspect the overglaze quality  |   |
| 70        | 挑瓷           | Select and pack the wares into the baskets   |   |
| 71        | 装草           | tie the wares in bundles with straw of hay.  |   |
| 72        | 装桶           | Pack into the wooden pails.  |   |