

COLOUR *de* VERRE

GLASS CASTING SYSTEM

Box Lid and Base Casting Instructions

Priming Thoroughly mix 1 part *Hotline Primo Primer*™ with 4 parts water. Apply five *thin* coats of primer with a soft artist's brush. Dry each coat before applying the next (a hairdryer can be used to speed the process) and keep the primer stirred as it settles quickly. While it is not necessary to pre-fire the mold, the mold must be completely dry before filling.

Filling The following are suggested fill weights:

Design	Base (grams)	Lid (grams)
3½" Round	295	115
4x5" Rectangle	450	220
6" Elliptical	375	180
5" Kidney	385	180
3½" Heart	310	130

Glass spurs can develop as the melting glass drags down the mold's interior surface. To reduce or eliminate spurs, mound the glass towards the design's center. Fine frit produces fewer spurs than larger frit or cut sheet glass. Spurs can be ground and the piece fire polished. See "Box Basics" in the Project Ideas section of www.colourdeverre.com for techniques and schedules.

Firing Schedule Avoid thermal shock by heating the mold and its contents no faster than 300°F (165°C) per hour. Use the following firing schedule as a general guide. Actual times depend on kiln type (side or top element), glass color, and frit size. This schedule was developed for transparent COE 96 glass. For opal glass, decrease maximum temperature 25°F (15°C). For COE 90, increase maximum temperature up to 25°F (15°C).

Segment 1, 300°F (165°C) /hour to 1250°F (675°C). Hold 30 minutes

Segment 2, 300°F (165°C) /hour to 1410-1430°F/765-775°C. Hold 20-50 minutes

Segment 3, AFAP, no venting, to 960°F (515°C). Hold 90 minutes

Segment 4, 50°F (30°C) /hour to 800°F (425°C)

Segment 5, 100°F (60°C) /hour to 600°F (315°C). Off, no venting

* AFAP (As Fast As Possible) = Full = 9999 = SKIP

Reusing The Mold Clean mold thoroughly after each firing with a stiff, nylon bristle brush. (A dry, synthetic, kitchen scouring pad, e.g. Scotch-Brite™, can also be used.) Avoid breathing any dust by wearing a proper dust mask. If correctly primed and fired, a Colour de Verre mold will yield many castings.

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