Salamander Platter

This platter's amazing surface is created by "flattening" a piece of iridized, herringbone ripple sheet glass. During this process, the beautiful irid colors are preserved but the surface becomes matte. Once the panel is created, salamanders are fused to it and the piece is slumped into a platter.

The project can be broken into easy-to-manage steps and each step can be completed in a few hours or less. The steps are:

- Create the salamanders. Depending how many castings you expect to incorporate, you might want to consider having multiple molds.
- "Flatten" the iridized sheet.
- Create the disk that will be slumped into the bowl or platter.
- Tack fuse the salamanders to the disk.
- Slump the disk.

Create the Salamanders

Before each firing, clean your molds with a stiff nylon brush to remove any old primer. Colour de Verre molds must be primed with

either Hotline Primo Primer or ZYP BN Lubricoat Aerosol (formerly MR-97). If you are using Hotline Primo Primer, give each mold four *thin*, even coats. It is the only traditional primer we recommend because it doesn't obscure the mold's fine detail and is easy to remove after firing. Use a soft brush to apply the primer and a hair dryer to completely dry each coat before applying the next. The mold should be completely dry before filling.

If you prefer to use ZYP, hold the thoroughly shaken can 10 to 12 inches from the mold. Hold both the mold and the can upright. Apply a two to three-second burst of spray in a sweeping pattern across all the mold's cavities. Do not saturate the surface. If it is the first time ZYP is used on a mold, it is necessary to apply a second coat of the product after waiting five minutes. Apply a second coat using another two to three-second burst of spray. Let the mold dry for ten to fifteen minutes before filling. ZYP will result in fewer casting spurs and crisper detail. For more details about using ZYP, visit our website's Learn section.

Create a 50/50 mixture of fine Black frit and fine Clear frit. For each salamander, put 25 grams of fine Black frit and 25 grams of fine Clear frit into an empty, lidded container. Cover and shake the container to thoroughly mix the contents. Whenever using powdered frits or mixing frits as described, it is highly advisable to wear a dust mask.

Availability

Colour de Verre molds are available at fine glass retailers and many online merchants including our online store, www.colourdeverre.com.

Tools

- ✓ Colour de Verre Salamander mold
- ✓ Artist's brush
- ✓ Small containers for mixing frit
- ✓ Digital scale
- ✓ Slumping form

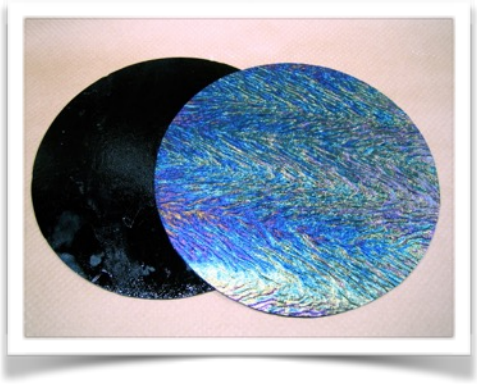
Supplies

- ✓ Hotline Primo Primer or ZYP BN Lubricoat Aerosol (formerly MR-97)
- ✓ Black and Black iridized, herringbone ripple sheet glass.
- ✓ Black and Clear fine frit
- ✓ Shelf paper

Since we want the Salamander to be more delicate than usual, the Salamander mold is filled with only 45 grams of mixture instead of the recommended 65. Level the frit with a small artists brush and fire according to the Component Casting Schedule.

Creating the Panel

Cut the piece of iridized Black herringbone ripple glass to a square that it is about 2" (5cm) larger than the final disk. Protect the kiln shelf with primer or a piece of ThinFire™ shelf paper.



Fire the square, iridized surface down, according the Flattening Schedule.

Once the panel has cooled, cut a disk from the panel and a similar disk from the plain Black sheet. Place the flattened iridized disk, iridized surface down, on a protected kiln shelf. Place the plain Black disk on top of it. Fire according to the Disk Fusing Schedule.

Completing the Piece

Remove the fused disk from the kiln, wash it, and place it on the workbench. Create a pleasing arrangement of salamanders. Use small dabs of white glue to hold the components in place. If desired, small pieces of kiln paper can be placed under the chins of the salamanders. This will keep their heads up during the tack fuse and slump firings and will result in more lifelike-looking salamanders. Make sure that the small pieces of

kiln paper do not extend beyond the salamanders' heads as this might effect the surface of the iridized panel.

Place the panel along with the parade of salamanders on a protected kiln shelf and fire according to the Tack Firing Schedule.

Slumping the Disk

Remove the cooled disk with its tack fused components from the kiln. Do not remove the small pieces of kiln paper used to support the salamanders' chins. Prepare a shallow slumping surface with primer. Place the disk on the slumping surface and fire according to the schedule. Note the slow ramps. The piece has a wide range

Component Casting Schedule*

Segment	Ramp	Temperature	Hold
1	350°F/195°C	1375°F/745°C	10 minutes
2	AFAP	960°F/515°C	10 minutes. Off

Flattening Schedule*

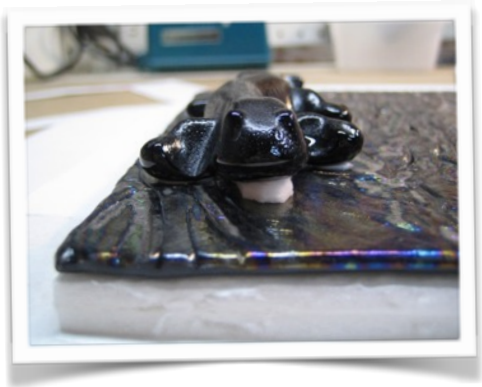
Segment	Ramp	Temperature	Hold
1	350°F/195°C	1420°F/770°C	10 minutes
2	AFAP	960°F/515°C	30 minutes. Off

Disk Fusing Schedule*

Segment	Ramp	Temperature	Hold
1	350°F/195°C	1250°F/675°C	30 minutes
2	350°F/195°C	1420°F/770°C	20 minutes
3	AFAP	960°F/515°C	60 minutes
4	100°F/55°C	600°F/315°C	0 minutes

*Schedule for COE 96. For COE 90, increase casting temperature by 25°F/15°C. AFAP means "As Fast As Possible", no venting.

of thicknesses and these slow ramps are necessary to prevent the piece from cracking and ensuring the piece is completely annealed.



Variations

Smaller pieces that require fewer firings can be made using a simplified version of this technique.

Start by cutting a piece of Black herringbone iridized sheet glass approximately 6 by 9.5 inches (15 x 24 cm). Flatten the glass by placing it face-down on a prepared kiln shelf and firing according to the Flattening Schedule.

Create a slumping form by cutting a piece of ¼" fiber paper the same size as the glass sheet and cutting a 5 x4.5 inch (12.5 x 11.5 cm) rectangle from the fiber paper's center where the glass will drop.

Tack Fusing Schedule*

Segment	Ramp	Temperature	Hold
1	200°F/110°C	400°F/205°C	0 minutes
2	250°F/110°C	1200°F/650°C	30 minutes
3	250°F/140°C	1270°F/690°C	10 minutes
4	AFAP	960°F/515°C	90 minutes
5	50°F/30°C	800°F/425°C	0 minutes
6	100°F/55°C	600°F/315°C	0 minutes. Off

Slumping Schedule*

Segment	Ramp	Temperature	Hold
1	100°F/55°C	300°F/150°C	10 minutes
2	150°F/85°C	1000°F/540°C	30 minutes
3	150°F/85°C	1220°F/660°C	20 minutes
4	AFAP	960°F/515°C	90 minutes
5	50°F/30°C	800°F/425°C	0 minutes
6	100°F/55°C	600°F/315°C	0 minutes. Off

*Schedule for COE 96. For COE 90, increase casting temperature by 25°F/15°C. AFAP means "As Fast As Possible", no venting.

Position a salamander at each of the narrow ends of the glass and, if desired, prop their heads as described above.

On a protected kiln shelf, place the fiber paper slumping form with the glass on top. Fire according to the Tack Fusing Schedule. This

firing will both attach the salamanders to the glass and slump the glass over the fiber paper.