



Cabbage Leaf

Craft whimsical plates reminiscent of antique majolica ware with this wonderful design or, if you are ambitious, create impressive platters, bowls, or wall art.



The cabbage leaf motif is often seen in both modern and antique majolica ware. The Colour de Verre design has an abundance of detail so very realistic cast glass leaves can be created. The integrated slumping surface on the mold's reverse side adds to the realism by creating plates with the same wavy edges one would expect to see in a real leaf.

Priming the Mold

Always start by priming Colour de Verre molds. There are two products that can be used: Hotline Primo

Primer™ and ZYP BN Lubriccoat (formerly MR-97).

With either product, clean the mold with a stiff nylon brush and/or toothbrush to remove any old kiln wash or boron nitride. (This step can be skipped if the mold is brand new.)

If you are using Hotline Primo Primer, mix the product according to directions. Apply the Primo Primer™ with a soft artist's brush (not a hake brush) and use a hair dryer to completely dry the coat. Give the mold four to five thin, even coats drying each coat with a hair dryer before applying the next. Make sure to keep the Primo well stirred as it settles quickly. The mold should be totally dry before filling. There is no reason to pre-fire the mold.

To use ZYP, hold the can 10 to 12 inches from the mold. Apply a light coat using a four to five-second burst of spray in a sweeping pattern across the mold's cavities. Do not saturate the surface. Set the mold aside for five minutes so it can dry. If the mold has never been used with ZYP before, apply a second coat using another four to five-second burst of spray. Let the mold dry for ten to fifteen minutes. The mold is ready to fill.

ZYP will result in fewer casting spurs and crisper detail.

See our website's Learn section for more instructions about priming Colour de Verre molds with ZYP.

Filling the Cabbage Leaf

The suggested fill weight for the Cabbage Leaf is 400 grams.

To accentuate the mold's details, 10 to 15 grams of White powder frit will be sifted into the mold. Before opening the jar, put on a dust mask. It is always important to wear a mask when working with glass powders or other fine particles as to avoid breathing in any glass dust or particles.



Place a small sifter on a piece of paper and load the sifter with some of the powder. Hold the sifter over the mold and tap the sifter to distribute a fine layer over the mold's surface concentrating

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 Cabbage Leaf mold
- ✓ Digital scale
- ✓ Sifter
- ✓ Assorted measuring spoons

Supplies

- ✓ Hotline Primo Primer™ or ZYP BN Lubriccoat (formerly MR-97)
- ✓ Assorted powder and fine frits

on the deep veining of the design. Once all the White powder is in place, tap the side of the mold in several places with your hand to cause the powder to collect in the veining.

The remainder of the mold is to be filled with two frit mixtures. Make Mixture #1 by combining 30 grams of fine Fern Green with an equal amount of fine Clear in a lidded container. Cover the container and shake.

Make Mixture #2 by combining 165 grams of fine Fern Green/Opal White DualTone frit with 165 grams of fine Clear frit in a large lidded container. Close the container and shake to thoroughly mix. (If you don't have access to a DualTone frit, you can substitute a 25/25/50 mixture of Fern Green, White, and Clear, but the shading won't be as subtle.)



Since Cabbage leaves have more intense color at the edges, use a spoon to distribute Mixture #1 evenly around the top outer edge of the design. Then use the lighter of the two mixtures, Mixture #2, to fill the inner part and the bot-

tom stem area of the design. When finished, the frit should be distributed evenly in the mold's casting cavity.

Fire the mold according to the Casting Schedule. The firing schedule's low target temperature and long hold will prevent the frit from becoming too liquid and balling up due to surface tension. This will keep the leaf thin and delicate.

Slumping Individual Leaves

The easiest way to shape individual Cabbage Leaf castings is to use the integrated slumping surface on the mold's reverse side. Using the same methods described above, prime the slumping surface with either Hotline Primo Primer or ZYP. Position the leaf on the primed surface with the textured side up. Notice the wavy edge of the slumping surface. Feel free to rotate the leaf to add variations and to accentuate the leaf's design. Place the mold into the kiln. Follow the Individual Leaf Slumping Schedule below.



To create bowls, use Colour de Verre's 7-10" Bowl Slumper and follow the same Individual Leaf Slumping Schedule.



Casting Schedule*

Segment	Ramp	Temperature	Hold
1	300°F/165°C	1300-1330°F/705-720°C	45-60 minutes
2	AFAP	960°F/515°C	60 minutes
3	100°F/60°C	600°F/315°C	Off. No venting

* Schedule for COE 96. For COE 90, increase casting temperature by 15°F/8°C. AFAP means "As Fast As Possible", no venting.

Individual Leaf Slumping Schedule*

Segment	Ramp	Temperature	Hold
1	300°F/165°C	1200-1210°F/650-655°C	10-20 minutes
2	AFAP	960°F/515°C	60 minutes
3	100°F/60°C	600°F/315°C	Off. No venting

* Schedule for COE 96. For COE 90, increase casting temperature by 15°F/8°C. AFAP means "As Fast As Possible", no venting.

Creating Larger Pieces

Multiple leaves can be tack fused to one another and then shaped.



To tack fuse multiple pieces together, start by protecting the kiln shelf with a good shelf primer (e.g. Hotline Primo™ Primer) or shelf paper (e.g. ThinFire™, Papyros®).

Overlap the pieces in a pleasing manner and fire according to the Multiple Leaf Tack Fusing Schedule.



Multiple Leaf Tack Fusing Schedule*

Segment	Ramp	Temperature	Hold
1	300°F/160°C †	1200°F/650°C	60 minutes
2	50°F/30°C	1260°F/680°C	10 minutes
3	AFAP	960°F/515°C	90 minutes (180 minutes for 4 or more leaves)
4	50°F/30°C	800°F/425°C	0 minutes
5	100°F/60°C	600°F/315°C	0 minutes
6	200°F/110°C	100°F/40°C	Off. No venting

Once the combined leaves have cooled, place them in a large, kiln-washed slumping form and fire according to the Combined Multiple Leaf Slumping Schedule.

Combined Multiple Leaf Slumping Schedule*

Segment	Ramp	Temperature	Hold
1	80°F/45°C ††	300°F/150°C	30 minutes
2	80°F/45°C ††	1000°F/535°C	60 minutes
3	50°F/30°C	1200°F/650°C	10 minutes
4	AFAP	960°F/515°C	90 minutes (180 minutes for 4 or more leaves)
5	50°F/30°C	800°F/425°C	0 minutes
6	100°F/60°C	600°F/315°C	0 minutes
7	200°F/110°C	100°F/40°C	Off. No venting



When tack fusing or slumping combined leaves, it is important to follow the slow ramps. The larger pieces will have a wide range of thicknesses and can crack if ramp speeds are too rapid.

* Schedule for COE 96. For COE 90, increase casting temperature by 15°F/8°C. AFAP means "As Fast As Possible", no venting.

† Schedules were developed for side element kilns. Slow ramps by 50°F/30°C for top element kilns.

†† Slow ramps by 30°F/15°C for top element kilns and more than three leaves.