

COLOUR de VERRE

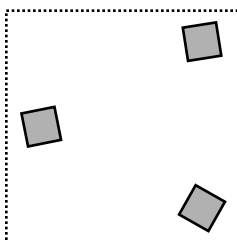
Reusable Molds For Glass Casting

Priming Mix by volume 1 part *Hotline Primo Primer*™ to 5 parts water. Mix thoroughly. Apply 4 to 5 *thin* coats of primer with a soft brush. Make sure to keep the primer thoroughly mixed every time the brush is dipped. Use a hairdryer to dry every coat. It is not necessary to pre-fire the mold, however, it must be completely dry before filling and firing.

Filling The following are suggested fill weights:

- 10" Round Fuser.....minimum 900 grams
- 10" Square Fuser.....minimum 1200 grams

Mold Setup It is important that the mold is elevated on kiln posts. Never place the mold directly on the kiln shelf or the kiln floor. Place the mold on three posts at least 1" tall. (See illustration to the right.)



Large Mold Firing Schedule Avoid thermal shock by heating mold and its contents no faster than 300°F per hour. Use the following firing schedule for frit casting. Actual times depend on individual kilns, COE, glass color, frit size, and glass thickness:

- Segment 1, 300°F /hour to 1150°F. Hold 45 minutes
- Segment 2, 300°F /hour to 1410-1440°F, Hold 30-35 minutes
- Segment 3, AFAP* to 960°F (without venting), Hold 2-3 hours
- Segment 4, 60°F /hour to 700°F, Off, Cool kiln without venting

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

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Slumping Schedule A cast piece can be shaped into bowls, plates, and other forms using the following firing schedule:

- Segment 1, 300°F /hour to 1200-1220°F, Hold 10 minutes
- Segment 2, AFAP to 960°F (without venting), Hold 60-90 minutes
- Segment 3, 60°F /hour to 700°F, Off, Cool kiln without venting

Unmolding If the mold was properly primed, the casting will fall out easily. However, if necessary, turn mold face-down and tap it against a hard surface cushioned with several layers of newsprint.

Reusing The Mold Clean mold thoroughly after each firing with a stiff, nylon bristle brush. (We often use a kitchen brush and an old toothbrush.) Avoid breathing any dust by wearing a proper dust mask. If correctly primed and fired, a Colour de Verre mold will yield many castings.

More Information Visit our website at WWW.COLOURDEVERRE.COM for latest techniques, project ideas, and tips.

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