

# COLOUR *de* VERRE

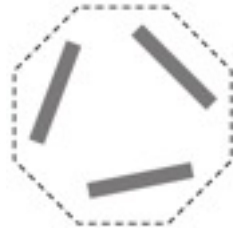
GLASS CASTING SYSTEM

**Priming** Mix by volume 1 part *Hotline Primo Primer*<sup>™</sup> 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:

|                      |           |
|----------------------|-----------|
| 7" Floral Forms..... | 400 grams |
| 9" Floral Forms..... | 600 grams |

**Mold Setup** It is important that the mold is elevated and well supported on kiln posts. Never place the mold directly on the kiln shelf or the kiln floor. For larger molds, place three posts approximately 1" x 4" on their sides. (See illustration to the right.) Set mold on top making sure that the mold is stable and level.



**Firing Large Molds** Avoid thermal shock by heating mold and its contents no faster than 300°F per hour until 1250°F is reached. Use the following firing schedule as a general guide for frit casting. Actual times depend on individual kilns and glass thickness:

- Segment 1, 300°F /hour to 1250°F. Hold 20 minutes
- Segment 2, AFAP\* to 1410-1440°F, Hold 20-30 minutes
- Segment 3, AFAP to 960°F (without venting), Hold 60-90 minutes
- Segment 4, 60°F /hour to 700°F, Off, Cool kiln without venting

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

# COLOUR *de* VERRE

GLASS CASTING SYSTEM

**Special Firing for Top Element Kilns** A special firing schedule has been developed for fusing kilns that have only top or lid heating elements.

- Segment 1, 300°F/hour to 1100°F, Hold for 20 minutes.
- Segment 2, 300°F/hour to 1410-1440°F, Hold for 20 minutes.
- Segment 3, AFAP to 960°F (without venting), Hold for 60 minutes.
- Segment 4, 60°F/hour to 700°F, Off, Cool kiln without venting.

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

**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 1200-1230°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](http://WWW.COLOURDEVERRE.COM) for latest techniques, project ideas, and tips.