



*Priming
Colour de Verre Molds
Using
ZYP Lubricoat Spray*

ZYP Lubricoat® is a boron nitride (“BN”) spray. When applied to Colour de Verre molds, the results are superior castings, virtually no spurs or sharp edges, and a beautiful, shiny surface. Application is as easy as applying a cooking spray. So what is the hitch? This sounds just too good to be true.

The biggest considerations are:

- Application requires a bit of finesse. Lubricoat spray contains an ultra-fine powder. One must make sure that the entire surface is thinly but completely covered.
- Once you start using a BN spray on a mold, you can’t go back. The spray seals the mold and traditional primers won’t be absorbed evenly.
- All our testing was at temperatures less than 1400°F in our

shallow, embellishment molds. We have no data *yet* about performance at higher temperatures. We don’t recommend it for use with our larger, deeper molds e.g. our box molds.

- Like all fine particle products, it is important to wear a dust mask. Also, because of the propellents, it is important to apply it and remove it outside or in a well-ventilated space.
- BN sprays costs more than Hotline Primo Primer. A tub of Primo Primer cost about \$10 and will coat hundreds of molds. A can of quality BN runs about \$45 bucks and will give you four to five dozen uses.

Not all BNs are Equal

After testing many boron sprays, we discovered a clear winner: ZYP Lubricoat. This product gave us consistent, superior results. Lubricoat-treated molds produced light, delicate, ultra-thin castings with perfectly smooth edges using a 1350°F to 1375°F (730-745°C) casting schedule. See *Tips for Thin Firing* in our website’s Project Ideas section.

Yes, Lubricoat is a touch more expensive than some of the other

BN products. However it only takes one broken mold or project disaster to persuade you not to use a lesser quality product. ZYP Lubricoat is available at our website, colourdeverre.com/zyp, or from the manufacturer, ZYP Coatings, zypcoatings.com.

Applying Lubricoat

If your mold has been used before, completely remove all the old Primo Primer from the mold with a stiff nylon kitchen brush and/or tooth brush. Read the instructions on the Lubricoat can. The Material Safety Data Sheet can be downloaded the ZYP product detail page in our online store.

The first time Lubricoat is used on a mold, it is necessary to apply two coats of the product. Hold the can 8 to 10 inches from the mold. Apply the first, light coat using a one to two-second burst of spray in a sweeping pattern across all the mold’s cavities. Do not saturate the surface. Set the mold aside for five minutes so it can dry. Once dry, reapply a second coat using another one to two-second burst of spray. Let the mold dry for ten to fifteen minutes. The mold is ready to fill.

Thin Firing Casting Schedule*

Segment	Ramp	Temperature	Hold
1	300°F/165°C	1350-1375°F/730-745°C	30 minutes
2	AFAP	960°F/515°C	30 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.

Filling the Molds

The Lubriccoat surface is delicate and care must be taken not to scratch away the primer as you fill the mold. We recommend using powder and fine frit as opposed to larger meshes. The larger frit can scratch the surface and create potential sticking problems.

Firing Schedules

We are becoming proponents of “long and low” firing schedules as opposed to “hot and fast” firing schedules. We use the attached schedule with the Colour de Verre embellishment molds – leaves, blossoms, flowers, dragonflies, etc. – when using Lubriccoat and the thin firing fill weights. See *Fill Weights at a Glance* in our website’s Project Ideas section.

This attached schedule was developed for a Skutt® side-element kiln. If you are using a kiln with top elements, it might be necessary to reduce the target temperature.

Cleaning Your Castings

It is important to remove any residual boron nitride from your glass casting otherwise your cast components will not tack fuse properly in your next firing.

Wash the casting in warm water with a little dish washing liquid and a mild, abrasive cleansing powder like Bon Ami®. Rinse thoroughly and dry.

Subsequent Firings

The Lubriccoat becomes powdery after firing and it is best to remove it so that it doesn’t mix with frit on the next firing. We strongly suggest doing this outside or in a well ventilated area wearing a dust mask. Use a stiff, nylon kitchen brush and/or toothbrush – the same tools used to remove Primo Primer – to remove the BN powder. The cleaned surface will look burnished and shiny. Reapply *one* thin coat of Lubriccoat as before. The surface should now look matte. If any areas are still shinny, touch up with a little more spray. Let the mold dry for ten to fifteen minutes before refilling.