



Flaming Hearts

Flaming Heart imagery used to be only seen in religious paintings, drawings, and statuary. However, in recent years, it can be seen everywhere from high fashion runways to hipsters' tattoos.



Visit a church in Mexico, Spain, or Italy and you are sure to see a painting, mosaic, or statue featuring a flaming heart. Recently, this imagery has been incorporated into popular culture.

Colour de Verre's Flaming Hearts molds creates castings that can stand alone as *objet d'art*, or that can be incorporated into larger finished pieces like votives, platters, or mosaics. They also

make great pieces to hang in windows.

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 Lubricat (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.)

To use ZYP, hold the can 10 to 12 inches from the mold. Apply a light coat using a four 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 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.

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.

Filling the Flaming Hearts

We have a favorite combination of frits we like to use to fill the Flaming Hearts design. However, you should not be constrained by our color choices.

We are going to use:

- Black powder
- Fine Grenadine Red
- Fine Pale Amber
- Fine Orange
- Fine Cherry Red
- Fine Clear

These are all transparent System 96 colors. Similar colors can be found in color palettes of other glass manufacturers.

Start by combining 8 grams of the Grenadine with 4 grams of Clear in a small, lidded container. Shake the container to completely combine the two frits.

Availability

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

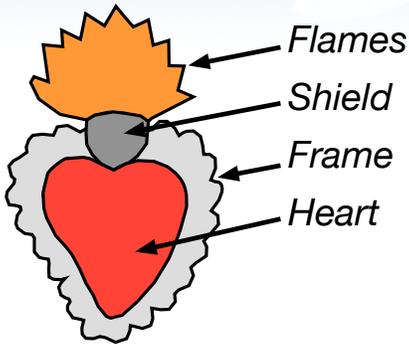
Tools

- ✓ Colour de Verre Flaming Heart mold
- ✓ Digital scale
- ✓ Sifter
- ✓ Small, lidded container
- ✓ Assorted artists' brushes

Supplies

- ✓ Hotline Primo Primer™ or ZYP BN Lubricat (formerly MR-97)
- ✓ Assorted frits

Note: When working with frits, it is always advisable to wear a dust mask.



Parts of the Flaming Heart Design

We will start by filling the larger of the two hearts. The first step is to use Black powder to highlight the details in the “frame” that surrounds the heart, the “shield” that sits atop the heart, and the “flames” atop the shield.



Put 1/2 to 1 gram of Black powder into a small sifter. Use the sifter to distribute the powder into the shield, frame, and flames. Don't be concerned if a little of the powder drops into the heart. Tap the mold to cause the powder to settle into the details.

Carefully fill the heart with 7 grams of the Grenadine mixture. You will have to pile up the mix-

Fill Weights

Small Heart	Large Heart	Temperature
0.5-1	0.5-1	Black powder in the shield, frame, and flames
5	7	Fine Grenadine mixture in the heart
2	3	Fine Orange in the flames
2	2	Fine Cherry Red in the flames
40	50	Fine Pale Amber distributed across the cavity
30	37	Fine Clear capping the colored frits
80	100	Total amount of frit in the cavity

Casting Schedule*

Segment	Ramp	Temperature	Hold
1	300°F/165°C	1420°F/770°C	5 minutes
2	AFAP	960°F/515°C	60 minutes
3	100°F/55°C	600°F/315°C	0 minutes. Off

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

ture to make it fit. Don't worry if a little spills out of the area. This will only add character and interest to your casting.



Next add some of the Pale Amber. Distribute about 20 grams of Pale Amber around the Grenadine frit in the heart and into the frame and into the shield. This will help hold the Grenadine mixture in place and form a dam to separate the shield frit from the frit which

will be placed in the flames. Again, don't worry if a little bit of the Pale Amber spills into the flames.



Fill the flames area with 3 grams of Orange and 2 grams of Cherry Red. Distribute the remaining Pale Amber evenly across the design.

Finally, cap the colored frit with 37 grams of fine Clear frit mounding it a little over the heart area.

The smaller Flaming Heart design is filled in a similar way only with

less frit. See the Fill Weight table for both sizes' fill weights.

Fire the mold according to the Casting Schedule.



Larger Projects

In our studio we created two projects incorporating the Flaming Heart.

The first project was an elegant Oval Votive created using our Oval Votive design. We started by cutting to panels 7.75" (197mm) wide and 4.25" (110mm) tall from a beautiful sheet of gold, metallic irid on Amber. We ground all the edges slightly so the edges would smooth evenly during the firings.

We placed these panels - iridized side up - on a prepared kiln shelf. We arranged three hearts on one of the panels and proceeded ac-

Slow Tack Fusing Schedule*

Segment	Ramp	Temperature	Hold
1	300°F/165°C	1200°F/650°C	30 minutes
2	200°F/110°C	1250-1265°F/675-685°C	5 minutes
3	AFAP	960°F/515°C	60 minutes
4	50°F/30°C	800°F/425°C	0 minutes
5	100°F/55°C	600°F/315°C	0 minutes. Off

Extra Slow Slump Schedule*

Segment	Ramp	Temperature	Hold
1	100°F/55°C	300°F/150°C	10 minutes
2	200°F/110°C	1250°F/675°C	5 - 10 minutes
3	AFAP	960°F/515°C	60 minutes
4	50°F/30°C	800°F/425°C	0 minutes
5	100°F/55°C	600°F/315°C	0 minutes. Off

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

ording to our Oval Votive project sheet (www.colourdeverre.com/go/votive). However, since the panels will have a wide range of thicknesses, use the Slow Tack Fusing Schedule and the Extra Slow Slump Schedule above.



Another project that we made was a small tray with flaming hearts at each end. Again, use the Slow Tack Fusing Schedule and the Extra Slow Slump Schedule.

