



Ginkgo Plate

This low, shallow plate is a great accent for a dining room table.



Given the finished piece, one might think of this as too complex a project for a beginner. Actually, this project can be completed by people new to glass casting. The trick is to approach the project as four “mini projects”:

- Create a collection of ginkgo castings. Make more than you expect to use so that you can experiment with various layouts.
- Fuse two pieces of sheet glass together to create the panel.
- Tack the cast leaves to the panel.

- Slump the panel using a shallow form.

Create the Ginkgo Leaves

Before each firing, clean your molds with a stiff nylon brush to remove any old kiln wash. (This can be skipped if the molds are brand new.)



Give each mold cavity four *thin*, even coats of Hotline Primo Primer. Each ginkgo mold has six mold cavities built in, but since there are three on each side, only three ginkgo leaves can be cast per firing. It is not necessary to prime mold cavities that won't be filled.

Hotline Primo™ primer is the only conventional primer we recommend because it doesn't obscure the mold's fine detail and is easy to remove after firing. Use a soft brush to apply the primer and a hair dryer to completely dry each coat before applying the next.

The mold should be completely dry before filling.

If you prefer, you can use boron nitride aerosol primer. (We used this for our project) We recommend ZYP BN Lubricat (formerly MR-97) exclusively. You can read more about this in *Advanced Priming with Boron Nitride Aerosol* which can be found in our website's Learn section.

The ginkgo leaves are cast from a



combination of fine Moss Green and fine Yellow frit. To create visual interest, three different frit combinations are used.

Combination #1:
30% fine Moss Green
70% fine Yellow

Combination #2:
40% fine Moss Green
60% fine Yellow

Availability

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



Tools

- ✓ Ginkgo Leaves mold
- ✓ Small and Large artist's brush
- ✓ Small containers for mixing frit
- ✓ Digital scale
- ✓ Assorted kitchen measuring spoons

Supplies

- ✓ Hotline Primo Primer or ZYP BN Lubricat (formerly MR-97)
- ✓ Fine Moss Green and Yellow frit
- ✓ Moss Green Frit and Stringer on Clear; Clear and White Streaky sheet glass
- ✓ Powder Black frit.

Combination #3:
50% fine Moss Green
50% fine Yellow

Combine the two frit colors in lidded containers and shake to combine. (Empty frit jars work perfectly.) Whenever mixing frits, it is highly advisable to wear a dust mask.

As mentioned above, each mold has six casting cavities, three on each side. The fill weights for Side A, the side with the “Ginkgo Leaves” text are 9, 9, and 9 grams. the fill weights for Side B, the side with the copyright text, are 15, 7, and 14.

To accentuate the subtle veining, sprinkle ¼ to ½ gram (a pinch) of black frit into each cavity. Hold the mold in place with one hand and use the other to tap the mold. This will cause the black powder to settling into the mold’s shallow groves. Using the fill weights mentioned above, evenly fill the ginkgo leaves. Lightly tap the mold to level the frit and transfer the mold to the kiln. Fire the molds according to the Component Casting Schedule. (See “Tips for Thin Casting” in the project section of Colour de Verre’s website.)

If the castings “ball up” decrease either the hold time or target temperature. Given the differences between individual kilns, it may take one or two test firings to get perfect results in your particular kiln.



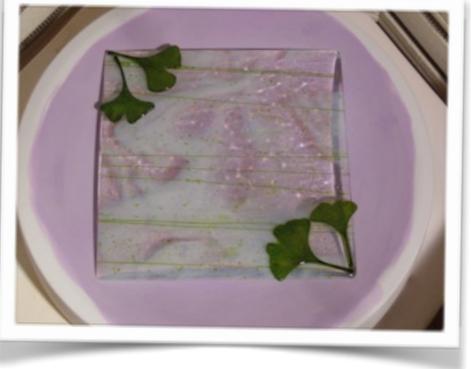
Creating the Panel

Cut a 10x10” (25x25cm) square from each piece of sheet glass. Protect the kiln shelf with primer or a piece of ThinFire™ shelf paper. Stack the Moss Green frit and stringer glass on top of the white and clear streaky glass. Place the stack in the kiln and fire according to the Sheet Glass Fusing Schedule below.

Attaching the Elements

Remove the fused panel from the kiln and place on the workbench. Create a pleasing arrangement of ginkgo leaves on the fused panel. Use small dabs of white glue to temporarily hold the components

in place. When dry, move the panel to a kiln shelf that has been protected with primer or a piece of ThinFire shelf paper. Fire the piece according to the Tack Fuse Schedule.



Slumping the Panel

Place the panel into a primed slump mold. Slowly fire the piece according to the Slumping Schedule. It is important not to rush the firing as there is quite a bit of thickness variation.

Variations

There are many combinations of sheet glass and frit color for which this technique produces beautiful

Component Casting Schedule*

Segment	Ramp	Temperature	Hold
1	300°F/165°C	1340-1360°F/725-735°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.

Sheet Glass Fusing Schedule*

Segment	Ramp	Temperature	Hold
1	250°F/135°C	1200°F/650°C	30 minutes
2	250°F/135°C	1410-1420°F/765-770°C	10 minutes
3	AFAP	960°F/515°C	60 minutes
4	100°F/60°C	700°F/370°C	Off. No venting

*Schedule for COE 96. For COE 90, increase casting temperature by 25°F/15°C. AFAP means “As Fast As Possible”, no venting.

results. One we found particularly pleasing was a 14" round disk created with Black Streamer Bits on Clear sheet backed by an off-white or Almond sheet.



Ginkgo leaves were created using the following frit combinations:

Combination #1:
30% fine Medium Amber
70% fine Pale Amber

Combination #2:
40% fine Medium Amber
60% fine Pale Amber

Combination #3:
50% fine Medium Amber
50% fine Pale Amber



As before, a little black powder was sprinkled into the mold to accentuate the detail.

Tack Fuse Schedule*

Segment	Ramp	Temperature	Hold
1	200°F/120°C	1200°F/650°C	30 minutes
2	200°F/120°C	1260-1275°F/680-690°C	5 minutes
3	AFAP	960°F/515°C	60 minutes
4	50°F/30°C	800°F/425°C	None
5	100°F/60°C	600°F/315°C	Off. No venting

*Schedule for COE 96. For COE 90, increase casting temperature by 25°F/15°C. AFAP means "As Fast As Possible", no venting.

Slumping Schedule*

Segment	Ramp	Temperature	Hold
1	100°F/60°C	200°F/95°C	15 minutes
2	100°F/60°C	400°F/205°C	10 minutes
3	150°F/85°C	1250°F/675°C	10-20 minutes
3	AFAP	960°F/515°C	60 minutes
4	50°F/30°C	800°F/425°C	None
5	100°F/60°C	600°F/315°C	Off. No venting

*Schedule for COE 96. For COE 90, increase casting temperature by 25°F/15°C. AFAP means "As Fast As Possible", no venting.



A "random" pattern was collaged and tack fused into place.



The tack fused disk was shaped using a shallow bowl slump form.