

General Instructions

Creative Ceramics Slumping Moulds



The Creative Ceramics moulds are designed as durable slumping & sagging moulds for glass. The specially formulated raw materials guarantee the durability even when fired several times per day!

The smooth surface accepts kilnwash uniformly and ensures the glass slides smoothly during the slumping process.

Mould Sizes



The moulds are largely made by hand. Small differences in size may be possible. We strongly recommend to cut the glass to the size measured from the actual mould rather than relying solely on the dimensions shown in the catalogue or the product sheet.

Mould Preparation

Large Moulds

Pre-firing is recommended for moulds larger than 30 cm. This process, carried out on the new mould, strengthens the inner structure and makes the mould less susceptible to thermal shock.

Segm.	Rate °C/h	Time	Temp °C	Hold min.
I	50	960	800	--

Cool the mould down to room temperature in the closed kiln.

All Moulds

Brush or spray on 4 or 5 coats of kilnwash and let dry. If you kiln-dry the mold use the following firing schedule

Segm.	Rate °C/h	Time	Temp °C	Hold min.
I	350	40	200	20

As long as your slump firings do not exceed 720°C, there is no need to re-kilnwash the mould. If you fire at temperatures above 720°C, replace kilnwash every 3rd to 4th firing or when necessary. Gently buff of the old primer with a dry scrub pad and apply new kilnwash as above.

Firing

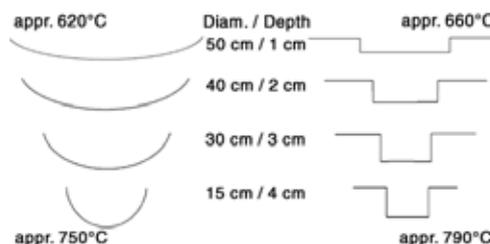
Place the mould on kiln posts for the slumping process and make sure that the vent-holes in the mould are open.

Distance to the heating elements no less than 2-3 cm. The moulds are susceptible to thermal shock (similar to glass) and should not be heated or cooled too fast (special attention required in side-firing kilns).

See below a typical slump firing cycle (Bullseye glass, size approx. 30 cm, thickness 6 mm)

Segm.	Heating / Cooling		Temp °C	Hold min.
	Rate °C/h	Time		
I	200 Side Firing	150	520	25
	300 Top Firing	100		
II	330	25	650	20
III	9999	0	516	50
IV	60	150	370	--
V	100	200	40	--

Variations of slumping temperatures depending on size and shape



The suggested temperatures are an indication only (Bullseye glass, 6 mm) and will vary depending on the kiln and the viscosity of the glass.