COLOUR de VERRE

REUSABLE MOLDS FOR GLASS CASTING



Rain Forest Leaf

Cast beautiful leaves on one side of these molds and then create perfect dessert and hors d'oeuvres plates with the integrated slumping surface on the molds' reverse side. Larger, gallery-quality works can be produced by combining a collection of these leaves.

The Rain Forest Leaf is based on a ti leaf from the Hawaiian Islands. After hours of meticulous carving, a stylized model was produced. That model was the starting point for the Colour de Verre Rain Forest Leaf design.

Priming the Mold

Always start by priming your molds. There are two products you can use: Hotline Primo Primer™ and MR-97 Boron Nitride Spray.

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.)

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.

The first time MR-97 is used on a mold, it is necessary to apply two coats of the product. Hold the can 10 to 12 inches from the mold. Hold both the can and the mold upright. Apply the first, light coat using a three-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, apply a second coat using another three-second burst of spray. Let the mold dry for ten to fifteen minutes. The mold is ready to fill.

MR-97 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 MR-97.

Filling the Rain Forest Leaf

The suggested fill weight for the Rain Forest Leaf mold is 120 to 130 grams.



To accentuate the mold's details. one to two grams of Black powder is sifted into the mold. Before opening the bottle, put on a dusk mask as it always best to wear a dust mask when working with glass powders or other fine particles.

Place a small sifter on a piece of paper and load the sifter with some of the powder. Hold the sifter over the mold and tap the sifter to distribute a fine layer over the mold's surface. Use a small

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 Rain Forest Leaf mold
- ✓ Medium primer brush
- ✓ Digital scale
- ✓ Sifter
- ✓ Assorted measuring spoons

Supplies

- ✓ Hotline Primo Primer™ or MR-97 Boron Nitride
- ✓ Assorted powder and fine frits

paintbrush to brush away any errant powder from the mold's top edge.

In a large, lidded container, combine 10% (13 grams) of Adventurine powder and 90% (117 grams of fine Water Clear frit. Shake the container. Since glass dust is created by mixing the two frits, put on a dust mask before opening the container.

Use a small spoon to layer the frit mixture into the mold. Apply the first three-quarters of the frit mixture evenly into the mold. Use the last one-quarter of the frit to increase the frit depth around the leaf's center.

Fire the mold according to the Casting Schedule. The firing schedule's low target temperature and long hold will prevent the frit



from becoming too liquid and balling up due to surface tension. This will keep the leaf thin and delicate.

Slumping Individual Leaves

The easiest way to shape individual Rain Forest Leaf castings is to use the integrated slumping surface on the mold's reverse side. Using the same methods described above, prime the slumping surface with either Hotline Primo Primer or MR-97. Position the leaf on the





primed surface with the textured side up and place the mold into the kiln. Follow the Individual Leaf Slumping Schedule below.





To create more dramatic plates, use Colour de Verre's Square "Sushi" Slumper. Follow the same

Casting Schedule*

Segment	Ramp	Temperature	Hold
1	300ºF/165ºC	1300-1320ºF/705-715ºC	45-60 minutes
2	AFAP	960ºF/515ºC	60 minutes
3	100ºF/60ºC	600ºF/315ºC	Off. No venting

* Schedule for COE 96. For COE 90, increase casting temperature by 15ºF/8ºC. AFAP means "As Fast As Possible", no venting.

Individual Leaf Slumping Schedule*

Segment	Ramp	Temperature	Hold
1	300ºF/165ºC	1200-1210ºF/650-655ºC	10 minutes
2	AFAP	960ºF/515ºC	60 minutes
3	100ºF/60ºC	600ºF/315ºC	Off. No venting

* Schedule for COE 96. For COE 90, increase casting temperature by 15ºF/8ºC. AFAP means "As Fast As Possible", no venting.

Individual Leaf Slumping Schedule.





Creating Larger Pieces

Multiple leaves can be tack fused to one another and then shaped.

To tack fuse multiple pieces together, start by protecting the kiln shelf with a good shelf primer (e.g. Hotline Primo™ Primer) or shelf paper (e.g. ThinFire™). Overlap the pieces in a pleasing manner and fire according to the Multiple Leaf Tack Fusing Schedule.



Once the combined leaves have cooled, place them in a large, kiln-washed slumping form and fire according to the Combined Multiple Leaf Slumping Schedule.

When tack fusing or slumping combined leaves, it is important to follow the slow ramps. The larger pieces will have a wide range of thicknesses and can crack if ramp speeds are too rapid.

Multiple Leaf Tack Fusing Schedule*

Segment	Ramp	Temperature	Hold
1	200ºF/110ºC †	300ºF/150ºC	10 minutes
2	200ºF/110ºC †	1000ºF/535ºC	30 minutes
3	200ºF/110ºC †	1200ºF/650ºC	45-60 minutes
4	100ºF/60ºC	1250-1260ºF/675-680ºC	10 minutes
5	AFAP	960ºF/515ºC	90 minutes (180 minutes for 4 or more leaves)
6	50ºF/30ºC	800ºF/425ºC	0 minutes
7	100ºF/60ºC	600ºF/315ºC	0 minutes
8	200ºF/110ºC	100ºF/40ºC	Off. No venting

Combined Multiple Leaf Slumping Schedule*

Segment	Ramp	Temperature	Hold
1	80ºF/45ºC ††	300ºF/150ºC	30 minutes
2	80ºF/45ºC ††	1000ºF/535ºC	85 minutes
3	50ºF/30ºC	1200ºF/650ºC	5 minutes
4	AFAP	960ºF/515ºC	90 minutes (180 minutes for 4 or more leaves)
5	50ºF/30ºC	800ºF/425ºC	0 minutes
6	100ºF/60ºC	600ºF/315ºC	0 minutes
7	200ºF/110ºC	100ºF/40ºC	Off. No venting

* Schedule for COE 96. For COE 90, increase casting temperature by 15ºF/8ºC. AFAP means "As Fast As Possible", no venting.

† Schedules were developed for side element kilns. Slow ramps by50ºF/30ºC for top element kilns.

†† Slow ramps by30ºF/15ºC for top element kilns and more than three leaves.

Variations

Consider creating leaves with colors other than Aventurine powder and fine Water Clear.

Above are some examples (from upper left). All colors mentioned are in fine frit except for a dusting of Black powder to accentuate the detail before filling:

- Light Orange center vein, Light Orange markings, 15%

Tangerine/Clear mixture for body.

- Moss Green markings, 50% Amazon Green and Clear for body.
- Medium Amber veining, 50% Pale Amber and Clear for body.
- Violet veining, 50% Fern Green/White Dual Tone and Clear for body.
- Moss veining, 50% Lemongrass and Clear for body.
- Cherry Red veining, 50% Lemongrass and Clear for body.