Slumpy's glass slumping and fusing molds are produced using high quality clay materials and industry process standards. Our molds are made with great care placed on quality control and creating the best slump mold possible. Below are instructions on caring for Slumpy's molds. Please read the following to provide the longest life for your mold.

Slumpy's Ceramic Mold Care Instructions

Initial Check —

Upon receipt of your mold, check for any possible damage that may have occured during shipment. Our molds are very durable, but shipping can potentially result in chipping or cracking. If your mold is damaged during shiping, **notify Slumpy's within 5 days of delivery**.

Some Slumpy's molds have a product sticker on the base of the mold. Carefully remove this sticker from the bottom of the mold prior to firing. If sticker is left on during firing it may leave a residue or colored spot. This can be cleaned off with sandpaper; however the residue will not affect the function of the mold.

In Use —

If debris is present on the mold it will adhere to glass during fusing or slumping. **Clean the mold** by blowing off debris, or wiping the surface of mold with water.

Primer should be applied to the mold before slumping glass into the form. Apply 3-4 coats of primer evenly over the surface of the mold, including the lip and any portion of the mold that may come in contact with hot glass. Slumpy's provides several types of mold primer. Be sure to carefully follow all manufacturer's instructions for applying, drying, and curing the primer prior to slumping or fusing.

Before firing **make sure base of mold is not in contact with residual glass** on kiln shelf. If the base contacts glass during firing, the mold may fuse to the shelf and damage the mold and/or shelf. Also **check for a uneven shelf surface**. Uneven distribution may cause tension within the mold and may weaken or cause the mold to break while in storge or during firing.

Avoid thermal shock caused by subjecting mold to drastic changes in temperature over short periods of time. Avoid raising temperature of molds from ambient conditions to hot kiln enviornment too quickly. When cooling, ramp the temperature of the kiln slowly to avoid abrupt changes in the temperature of the mold body, which could cause the mold to crack. **It is recommended a ramp up of no more than 400°F (204°C) and and for a ramp for cooling it is best to avoid leaving the kiln open to cool it down, especially with double sided molds such as the Belmont Series. To be safe, Slumpy's recommends not opening the kiln prior to 100°F (37°C).**

Avoid excessive loading and pressure points on the molds. These conditions may cause molds to fracture.

Avoid draping glass over Slumpy's ceramic molds. Glass overlapping the outer surfaces of molds may cause the mold and/or glass to crack while cooling. Use drop-in molds, or calculate the glass surface area before slumping. (Stainless Steel molds are best recommended for draping.)

Storage —

Store molds with care to prevent damage. **Store in a dry place. Avoid stacking molds.** Possible damage to mold and/or degradation to primer layers may occur. If stacking molds is necessary, take care to prevent possible damages by use of a barrier between molds. Always allow mold to cool before storing.

Other Specifics —

Clay slumping molds can fire to 2000 °F (1100 °C). If mold cracks or chips, it may be possible to repair some damages. Use Slumpy's Magic Mender to repair minor fractures. Product and instructions are available on www.slumpys.com

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