COLOUR de VERRE

REUSABLE MOLDS FOR GLASS CASTING



Cloud Forest Magnolia

Create both service pieces and art pieces using the Cloud Forest Magnolia design. Once thought to be extinct, this tree has become a favorite in Pacific Northwest gardens.

Create the most beautiful cast glass leaves using Colour de Verre's Cloud Forest Magnolia. Cast wafer-thin and slumped, the beautiful art pieces can be displayed on a mantle or table, or in a shadow box. Cast thicker, the castings can be turned into elegant, functional pieces.

Priming the Mold

Always start by priming Colour de Verre molds. There are two products that can used: Hotline Primo Primer™ and ZYP BN Lubricoat (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.)

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.

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 cavity. 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.

Filling the mold

The suggested fill weight for a Cloud Forest Magnolia for functional use is 250 to 300 grams. The most simple way to fill the Cloud Forest Magnolia mold is to weigh out 300 of fine frit and to evenly distribute the frit in the mold. Fire the mold and frit according the Casting Schedule below. This design is also a perfect candidate for our Wafer-Thin technique. One can read more about this at www.colourdeverre.com/go/wafer.



More interesting and realistic castings can be made by combining frit colors and frit meshes.

Weigh the empty mold and, with a pencil, mark on the mold's side its weight in grams. We will use this

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 Cloud Forest Magnolia mold
- ✓ Digital scale
- ✓ Sifters
- ✓ Assorted measuring spoons

Supplies

- ✓ Hotline Primo Primer™ or ZYP BN Lubricoat
- ✓ Assorted powder and fine frits

weight later on to ensure the mold is completely filled.

To accentuate the mold's details, two to three grams of black powder will be sifted into the mold. (You may substitute for Black another dark color like Hunter Green powder.) *Note: We believe it is always important 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 the powder. Hold the sifter over the mold and tap the sifter to distribute a fine layer over the mold's surface. Once all the Black powder is in place, tap the side of the mold with your hand in several places to cause the powder to collect in the detail.



For the rest of the mold, choose complementary colors such as fine mesh Kelly Green and fine mesh Spring Green with Fuchsia accents. (All of these are Bullseye colors, but similar colors can be found in the Urobors/Oceanside color palette.) Rather than directly adding these to the mold, first "dilute" the colored frit with 50% fine Clear frit.



Distribute these color combination into the mold to create a pleasing pattern. It is not necessary to fill the mold, simply to create a layer of color.

Once a layer of color has been added to the mold, the mold needs to be backfilled with Clear to bring the total amount of glass in the mold to the 250 to 300 gram fill weight. To determine the amount of additional glass needed to fill the mold, weigh the partial filled mold. Subtract the weight of the empty mold (the weight previously noted on the mold's side) from the weight of the partial filled mold. The result is the weight of the glass in the mold. Since the mold needs to have 250 to 300 grams in it to be completely filled, subtract amount of the glass currently in the mold from 300. This is the amount of glass that needs to be added to the mold.

Weight out the number of grams of fine, clear frit calculated above. Evenly distribute the clear frit across the mold using a spoon.

Fire the mold according to the Casting Schedule. The firing schedule's low target temperature



Bullseye Casting Schedule*

Segment	Ramp	Temperature	Hold
1	300ºF/165ºC	1345-1350ºF/730-732ºC	45-60 minutes
2	AFAP	900ºF/482ºC	60 minutes
3	100ºF/60ºC	600ºF/315ºC	Off. No venting

* Schedule for Bullseye glass. For COE 96 glass, decrease target temperature by 20ºF/10ºC. AFAP means "As Fast As Possible", no venting. Anneal at 900ºF/482ºC.

Slumping Schedule*

Segment	Ramp	Temperature	Hold
1	300ºF/165ºC	1200ºF/650ºC	10 minutes
2	AFAP	900ºF/482ºC	60 minutes
3	100ºF/60ºC	600ºF/315ºC	Off. No venting

* Schedule for Bullseye glass. For COE 96 glass, decrease target temperature by 20ºF/10ºC. AFAP means "As Fast As Possible", no venting. Anneal at 900ºF/482ºC.

and long hold will help prevent the frit from becoming too liquid and balling up due to surface tension. This will keep the Cloud Forest Magnolia thinner and more delicate.

Slumping The Casting

Cast Cloud Forest Magnolias can be slumped into shallow bowls. We find a perfect slumper for this is Bullseye Glass Short Oval design, #8952 14.8 x 6.3 x 1.7 inches. (These slumping forms are marketed outside North America as Creative Ceramics.)







Cloud Forest Magnolias can be slightly slumped to add more "life" to the finished piece. For this we used Bullseye Rectangular slumper #8924 12.62 x 7.62 x 1.87 inches. This is best done by placing a Cloud Forest Magnolia in a diagonal position across the slumping surface.

In either case, slump the Cloud Forest Magnolia using the Slumping Schedule.





