



BULLSEYE

GLASS CO.

MOLD TIPS: CONE BOWL MOLD #8943

Notes generated in the Bullseye Research & Education studios, firing in Paragon GL24 kilns.



Prepare the Cone Bowl Mold with primer/separator and kiln-dry as directed in “Tips for Using Bullseye Slumping Molds” (at www.bullseyeglass.com/education).

Measure the top edge of your mold to determine the diameter. Cut your glass to the same diameter as the mold or up to 1/16” (1.5mm) larger all around. This slightly larger size allows the mold’s narrow lip to support the glass and hold it in place as it slumps into the steep form.

To promote even heating, slumping and cooling, place the Cone Bowl Mold centrally in the kiln and elevate with 2” (5cm) posts. This particular form may slump unevenly if one side is closer to the elements. The same characteristics that make this small form unique, such as depth combined with a narrow lip and flat base, make it unforgiving of uneven heat.

Before firing, verify that the mold and glass are level.

SUGGESTED FIRING SCHEDULE

	RATE (DEGREES PER HOUR)	TEMPERATURE	HOLD
1	300°F (167°C)	1225°F (663°C)	1:45*
2	AFAP**	900°F (482°C)	1:00
3	100°F (56°C)	700°F (371°C)	:00
4	AFAP	70°F (21°C)	:00

* If possible, visually confirm slump.

** As Fast As Possible. Allow the kiln to cool at its natural rate with the door closed.

Segment 1 hold-time note: We commonly hold at slumping process temperatures for over an hour, especially for molds with steep sides. This lower-for-longer approach to slumping reduces the amount of mold texture picked up by the glass and helps maintain a uniform, overall thickness.

Visual confirmation note: If you are not able to observe a slump in progress, remember that it is often much easier to re-fire and increase the heatwork than to fix something that has slumped too much.

Mold re-preparation note: Steep sided molds such as 8943 need more frequent re-preparation than forms with gentle curves, which are often fired to lower process temperatures paired with shorter hold times. As glass slumps into this steep form, it pulls minute amounts of primer away from the mold surface. If the primer layer wears too thin, glass can get hung up and be prone to slump unevenly. To ready the mold for a fresh application of primer, remove the used primer with a soft, green scrub pad. Re-apply primer and kiln-dry as usual. Expect to re-prime after four or five slump firings, or as needed.