



Creative Paradise Inc.



Angel icicle casting mould

In this tutorial you will learn how to make a delicate Angel Icicle Ornament using the Creative Paradise, Inc mould LF176.

You will need to following to create this project:

- Creative Paradise, Inc. mould LF174
- Powder sifter
- Mosaic Nipper
- Pipette
- ZYP
- F1 Powdered Frits, F2 Fine Frits, F3 Medium, Clear frit
- Clear glass rods/Clear sheet glass
- Dichroic glass
- Liquid fired gold (optional)



Make sure you use a glass separator on your casting mould

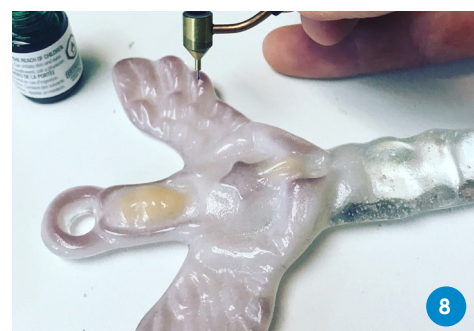
It is crucial that you coat your mould with a glass separator so that the glass won't stick to the mould once it is fired. If you don't apply enough glass separator your glass will get stuck or pull out some of the mould. We would recommend using ZYP (Boron Nitride Spray), this comes in a can which can be sprayed easily - spray several light coats in intervals, turning the mould to make sure you coat all the surfaces. Make sure you also wear a mask to avoid breathing in the spray.



Keep your mould edges clean

Once you have added your frit make sure that you sweep away any loose frit from the edges of the mould, this will prevent burrs from occurring and will ensure that your shape has a smooth edge. Use a powder sifter when using your powdered frit to allow you to easily add fine detail.

The process



- 1 Use a small powder applicator or pipette to fill the Angels face and hands with F1 Champagne Opal.
- 2 Use a sifter to place some F1 Turns Pink in the star, hair, wing tips and edge of sleeve followed by a dusting of F1 Pale Purple on the wings and body of Angel.
- 3 Fill the Angel portion of the cavity with F2 White frit.
- 4 Fill the icicle portion of the cavity with a clear rod cut to size and/or thin strips of clear sheet glass.
- 5 Fill the icicle cavity up with the rod and/or sheet glass. This will help the icicle part of the project to have fewer Champagne bubbles (than if you had used only frit). If desired add thin slivers of Clear Dichroic glass amongst the sheet glass. This will add a shiny glimmer to the icicle once fired.
- 6 Cover the cavity with F3 Medium Clear frit until the mould holds a total of 72 grams of glass.
- 7 Gently sweep the frit away from the post with a paint brush or similar tool to prevent burrs. Fire the mould using the schedule found in table 1.
- 8 If desired a gold pen can be used to apply liquid fired gold to enhance the Angels features. The liquid fired gold then needs to be matured in a second firing. To mature the gold without effecting the shape of the Angel, fire at 222°C per hour to 648°C and hold for 5 minutes then go as fast as possible to 510°C and hold for an hour.

Fusing program

Segment	Rate Celsius/hr	Temp	Hold time (hr:min)
1.	166°C/hr	to 621°C	0:45
2.	83°C/hr	to 743°C	0:20
3.	222°C/hr	to 790°C**	0:10
4.	AFAP* OR 9999°C/hr	to 510°C	1:00
5.	55°C/hr	to 426°C	0:05

*AFAP = as fast as possible, some controllers will not allow a rate of 9999°C /hr

** Will vary depending on desired result and kiln

This data is a guide only, firing programmes may need to be adjusted according to size and thickness of glass and the kiln's performance. Ensure that data is entered into the controller accurately, otherwise glass may not fuse correctly.



Removing the casting from the mould

When your piece has finished fusing and has cooled down, remove it from the mould by gently turning the mould over and letting it fall out onto a soft surface. DO NOT pick the piece out of the mould as you may break the post off.