



Deer casting mould

Casting molds are a simple way to make beautiful glass art. This fun detailed mould creates a finished piece measuring 3" x 4". Display it alone as an ornament with bail, slump it over the small stand up mould (sold separately) to make a three-dimensional piece or tack fuse it into a larger piece to make complex wall art and more.

You will need to following to create this project:

- Creative Paradise, Inc. mould LF193 and stand-up mould GM40 if you want the deer to stand
- Powder sifter
- Pipette
- ZYP
- F1 Powdered Frits, F2 Fine Frits



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 Sift F1 Black Opal into the eyelash, pupil and hooves. F1 Flame Opal into the end of the nose and F1 Sunflower Opal into the bells.
- 2 Sift F1 Pale Amber into the chest and middle of ears, tail, hind quarters, lower part of the legs above the hooves.
- 3 Place F2 Red Opal into the harness.
- 4 Sift F1 Almond Opal over the eye and cheek area, into the muzzle, chest, tail, hind quarter and lower part of the legs above the hooves.
- 5 Place F2 Almond in the horns, chest and tail. Place F2 Chestnut Opal through out the body area that isn't black or almond. Fill the cavity with about 1/4"-3/8" of frit or 50 grams. Tack fuse the Deer to the schedule overleaf.
- 6 Once tack fired, allow the kiln to cool. Remove the glass from the mould and wash the glass to remove any glass separator. Place the glass piece on a GM40 Small Stand-Up Mould that has been treated with a clay based glass separator such as Primo Primer. (Zyp/Mo-ore BN glass separators may cause the glass to slide off of the mold during the firing process). Fire the glass on the mould using a slump firing schedule as found overleaf.

Tack fusing program

Segment	Rate Celsius/hr	Temp	Hold time (hr:min)
1.	152°C/hr	to 621°C	0:20
2.	194°C/hr	to 771°C**	0:05
3.	AFAP* OR 9999°C/hr	to 515°C	1:00

Slumping program for stand up mould (optional)

Segment	Rate Celsius/hr	Temp	Hold time (hr:min)
1.	152°C/hr	to 654°C	0:30
2.	AFAP* OR 9999°C/hr	to 515°C**	1:30
3.	55°C/hr	to 260°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.