



Deer icicle casting mould

Fuse your very own Rudolph the Red Nose Reindeer Icicle! Have fun and make all of Santa's Reindeer!

You will need to following to create this project:

- Creative Paradise, Inc. mould LF191
- 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 Sift F1 Black Opal into the eyes and hooves, F1 Flame into the nose.
- 2 Sift F1 Hunter green into the scarf.
- 3 Place F2 Almond over the hooves filling the cuffs around the hoofs.
- 4 Place Amazon Green into the lower parts of the scarf.
- 5 Sift F1 Medium amber into the face and ears and F1 Bronze into the antlers.
- 6 Place F2 Almond into the muzzle and eye area of the face and the base of the ears and into the antlers.
- 7 Place F2 Chestnut around the outside of the ears and the top of the head and outside of the face.
- 8 Add more F2 Almond to the middle of the ears and middle of face, Fill more of the scarf with F2 Amazon.
- 9 Fill the face with F2 Chestnut.



- 10** Place F2 Red opal into the sweater and sleeve area.
- 11** Alternate back and forth to fill the scarf with F2 Amazon and the sweater with F2 Red Opal. Place a bit of F2 Chestnut below the scarf and sweater. If desired nip some dichroic glass and place dichroic side down into the icicle part of the mould to add a glitter effect. Back with F3 Clear.
- 12** Place F3 Clear into the mould until the mould holds 100 grams of frit. Sweep the frit back away from the post. Fire the project to the suggested schedule below.

Fusing program

Segment	Rate Celsius/hr	Temp	Hold time (hr:min)
1. Initial heat	149°C/hr	to 621°C	0:45
2. Rapid heat process soak	65°C/hr	to 743°C**	0:20
3. Rapid cool anneal soak	204°C/hr	to 790°C	0:10
4. Anneal cool	AFAP* OR 9999°C/hr	to 510°C	1:00
5. Cool to room temp	38°C/hr	to 426°C	0:05
6. END	-	-	-

*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.