



Icicle casting moulds

We have a selection of christmas icicle casting moulds which are perfect for making decorations for your christmas tree.



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.



Adding frit to your mould

Use a powder sifter when using your powdered frit to allow you to easily add fine detail.



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.

Recommended frit weights

Code	Mould	Frit weight in grams (full fuse)
CPLF174	Icicle Angel Ornament	72g
CPLF175	Icicle Snowman Ornament	75g
CPLF176	Icicle Frost Fairy Ornament	120g
CPLF178	Icicle Santa Ornament	68g

The process



- 1** Spray your mould with ZYP mould release spray
- 2** Use a powder sifter to fill in the fine details
- 3** Use a pipette to fill in areas with medium grade frit
- 4** Brush the frit away from the edges of the mould
This will prevent burrs when its firing.
- 5** Fill the icicle part of the mould with clear rods or strips of clear glass
- 6** Fill the entire mould with F3 clear frit
See table overleaf for frit weights for specific icicle moulds.
- 7** Place your mould in the kiln
Use the firing 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.