



*Creative Paradise Inc.*



# Christmas Tree casting mould

In this tutorial you will learn how to make a beautiful Fire Tree Ornament using the Creative Paradise, Inc mould CPLF239.

## You will need to following to create this project:

- Creative Paradise, Inc. moulds - CPLF239 Large Fir Tree, CPGM267 Conical Drape
- Powder sifter
- Pipette
- ZYP
- F1 Powdered Frits or F2 Fine Frits in Medium Blue Opal, Cobalt Blue Opal or Trans, Pale Blue Trans, Light Blue Trans. F2 Fine: White Opal, Pale Blue Opal. F3 Medium Grain or Coarse: Clear
- CPLBGM267 Lamp Base kit (optional)
- Acrylic stains or non-fired color product to decorate LBGM267 Lamp Base (optional)
- Fairy Lights (optional)



### Make sure you use a glass separator on your casting mould

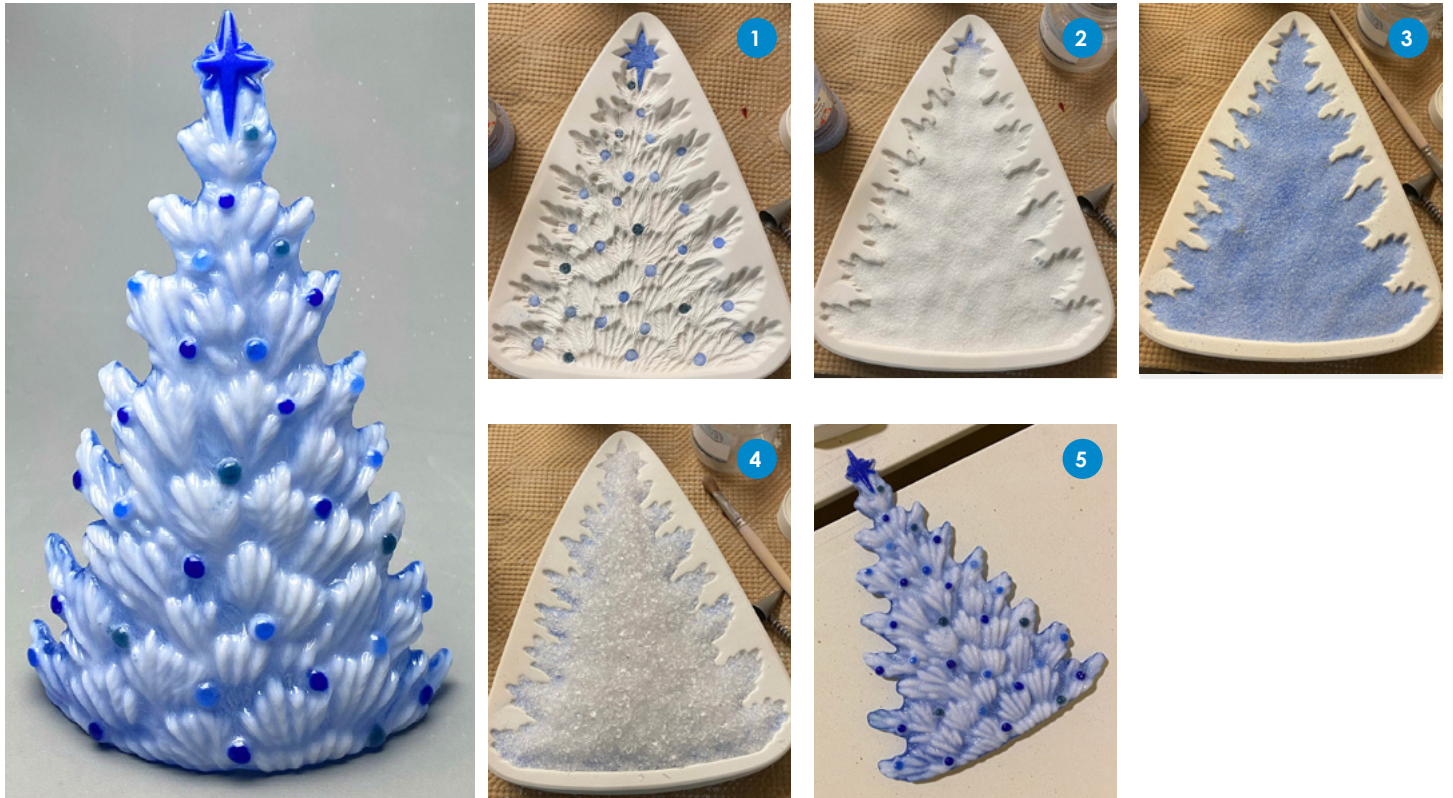
It is crucial that you coat your mould with a glass separator so that the glass won't stick to the mould once it is fired. If you don't apply enough glass separator your glass will get stuck or pull out some of the mould. We would recommend using ZYP (Boron Nitride Spray), this comes in a can which can 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 - White before Blue



### 1 Fill the ornaments on the tree

Fill the ornaments with Cobalt Blue, Pale Blue and Light Blue, either powder or fine frit can be used. Fill the star with Medium Blue Opal.

### 2 Fill with white frit

Place a layer (approx 1/4" deep) of Fine White frit over the entire surface of the mould cavity.

### 3 Fill with blue frit

Place a layer (approx. 1/4" deep) of Fine Pale Blue over the White in the mould cavity.

### 4 Fill with clear frit

Fill the mould with medium or coarse clear frit until the mold holds 425 grams of frit. Sweep the frit back to reveal the perimeter of the casting cavity.

### 5 Fire your mould

Place the mould into a kiln and fire to a full fuse. A suggested schedule can be found in Table overleaf.

## The process - Blue before White



### 1 Fill the ornaments on the tree

Fill the ornaments with Cobalt Blue, Pale Blue and Light Blue, either powder or fine frit can be used. Fill the Star with White Opal.

### 2 Fill with blue frit

Place a layer (approx 1/4" deep) of Pale Blue frit over the entire surface of the mould cavity.

### Fill with white frit

3

Place a layer (approx. 1/4" deep) of Fine White Opal over the Pale Blue in the mould cavity.

### Fill with clear frit

4

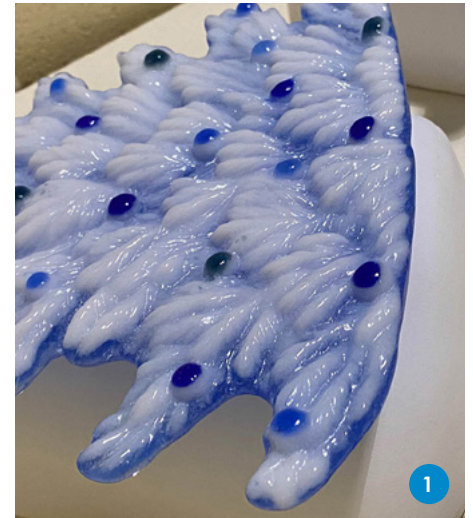
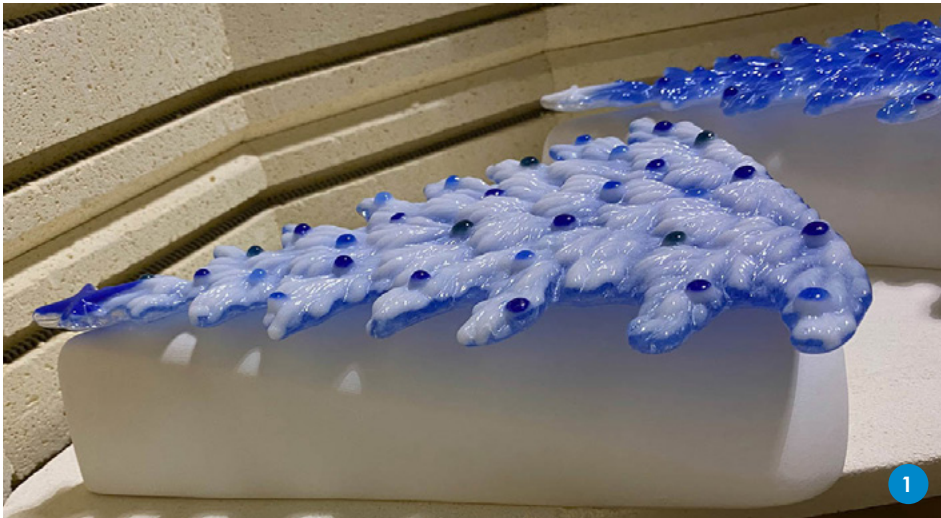
Fill the mold with medium or coarse clear frit until the mold holds 425 grams of frit. Sweep the frit back to reveal the perimeter of the casting cavity.

### Fire your mould

5

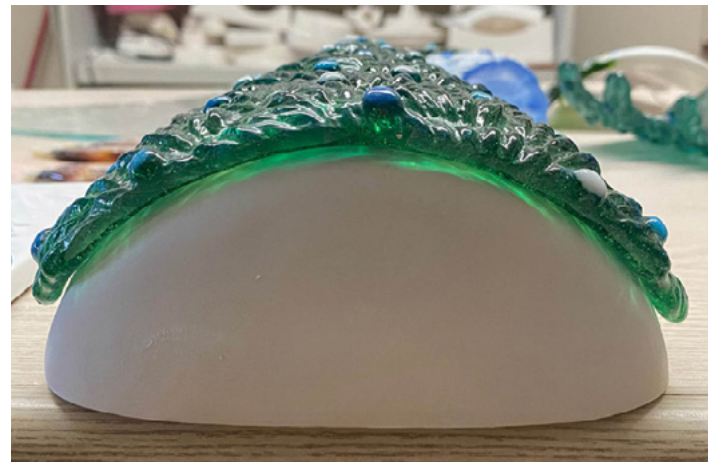
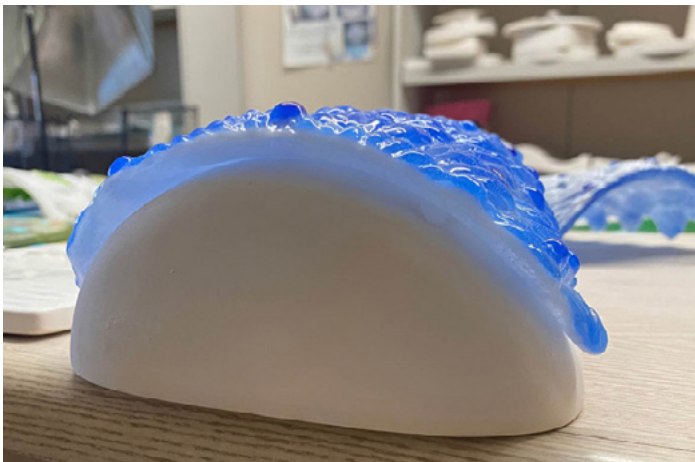
Place the mould into a kiln and fire to a full fuse. A suggested schedule can be found in Table overleaf.

## The process - Draping



### 1 **Drape your castings over the Conical Drape Mould.**

To drape the casted Fir Trees, wash the castings to remove any residual glass separator. Place the fused Tree onto the CPGM267 Cone former that has been treated with a glass separator. There is an ornament in the center of the base of the tree. Align the center ornament with the center mark on the mould with the casting about 1/8" from the bottom of the mould and the star lined up with the top point of the mould.



The glass, in the image above on the left, did not sufficiently drape onto the drape mould. The glass can be fired again adding 10 degrees to the top temp on the firing schedule to get the glass to bend to the shape of the mould as shown in the image above on the right.

If the glass is not slumped hard enough on to the CPGM267, the glass will not take the shape of the bottom edge of the mould. It may not stand on its own if the original casting doesn't completely fill the CPLF239 Fir Tree casting mold and/or the glass isn't draped sufficiently on the CPGM267 Cone Drape mold.

## Fusing program - full fuse

Segment	Rate Celsius/hr	Temp	Hold time (hr:min)
1.	167°C/hr	to 621°C	0:45
2.	83°C/hr	to 743°C	0:20
3.	194°C/hr	to 793°C**	0:10
4.	AFAP* OR 9999°C/hr	to 510°C	1:00



### 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.

## Fusing program - Drape

Segment	Rate Celsius/hr	Temp	Hold time (hr:min)
1.	139°C/hr	to 687°C	0:10
2.	AFAP* OR 9999°C/hr	to 515°C	1:00

\*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.



After the casting has been draped, it should stand on a level flat surface and can be displayed alone, or you can add the casting to the LBG267 Lamp Base Kit. The earthenware base can be decorated with acrylic stains or spray paint. After the paint is dry, insert the clip light through the bottom of the base through the hole in the top and place the bulb into the socket.