Large Snowman casting mould

In this tutorial you will learn how to make a beautiful Snowman Ornament using the Creative Paradise, Inc mould CPLF237.

You will need to following to create this project:

- Creative Paradise, Inc. moulds - CPLF237 Large Snowman, CPGM267 Conical Drape
- Powder sifter
- Pipette
- ZYP
- Papyros paper
- 17 gauge high temp wire
- F1 Powdered Frits in Dark Green Opal, Flame Opal, Amazon Green Opal, Orange Opal and Black
- F2 Fine Frits in Amazon Green Opal, Light Green Transparent, Black and White
- F3 Medium Frits in Moss Green, Clear and White
- CPLBGM267 Lamp Base kit (optional)
- Acrylic stains or non-fired color product to decorate LBGM267 Lamp Base (optional)

TOP TIP

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.

TOP TIP

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 occuring 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
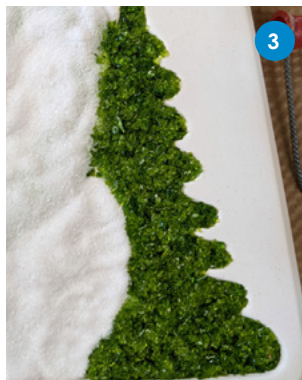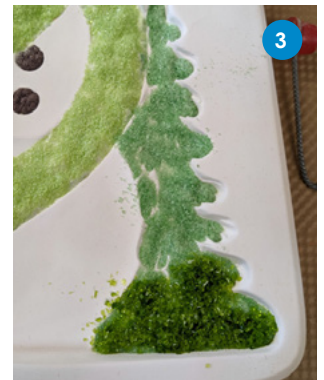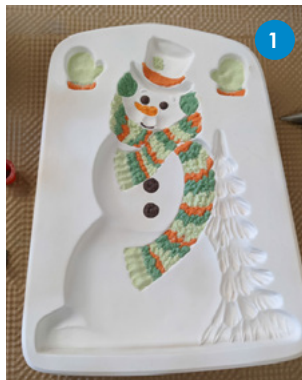
1 Fill in the details

Using your chosen colours, begin by filling in the details of the snowman. Here, the scarf is alternating Dark Green, Amazon Green, and Flame, the earmuffs, mittens, and hat stripe use the same. The nose is Orange and the eyes, buttons, and mouth are all Black.

2 Fill details with a fine frit

Use a fine textured frit colour similar to or the same as one of your detail colors to back the mittens, earmuffs, and scarf to make sure white doesn't show through. Amazon Green was used here.

3 Fill the tree

The tree can either be filled in with a single color of frit or multiple colors to create depth. Here, fine Light Green Transparent was used to fill in the more detailed parts of the tree.

Medium Moss Green was used to back the Light Green and fill out the rest of the tree. Make sure the frit doesn't bleed over into the snowman's body. Back the rest of the hat in Black as well, taking care not to disturb the frit of the patch and stripe.

4 Fill snowman with fine white frit

Back the entire snowman except for the hat and tree in fine White frit. Optional sparse amounts of medium Clear frit can then be added for a more "icy" finished look.

Then back everything with medium White, making sure to keep the line between snowman and tree clean.

5 Fill with medium clear

Fill everything with medium Clear until you reach the recommended fill weight of 450 grams.

The process cont.
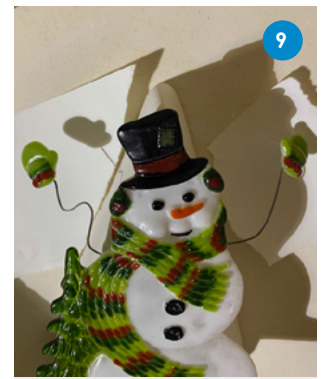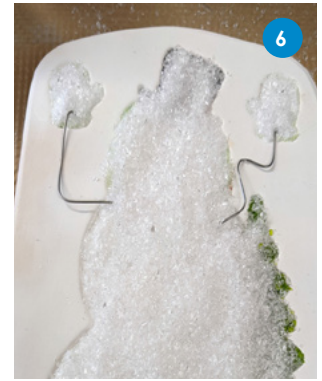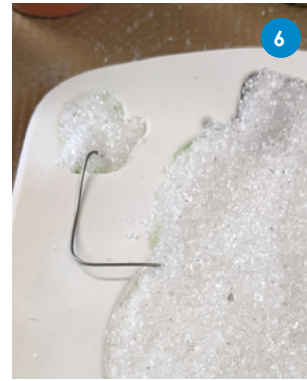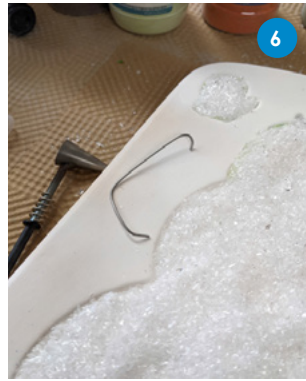
6 Create the arms

Bend the High Temp Wire for the arms. Bend the ends of the wire downwards so they can stick into both the snowman and mitten.

When placing the wire into the frit, make sure it is placed deep enough to remain embedded in the glass. If it is too shallow the arms will fall off. However, if it is too deep, the wire can poke through the front of the finished product.

Make sure that the very ends of the wires are the only parts that will come into contact with any frit during the firing process. This makes sure the arms stay bendable and not stuck to any extra glass.

7 Fire the mould

Place the mold into the kiln and fire at a Full Fuse as seen in Table overleaf.

8 Fired piece

Here is the piece after the full fuse but before the slump. Please refer overleaf for instructions on how to find the middle of the casting for draping and other helpful hints.

9 Drape the mould

Using GM267 and the Drape schedule overleaf, drape the snowman. Place kiln paper beneath the mittens to prevent them from sticking.

Finding the centre of your casting

1 **Finding the centre with a ruler**

To find the center of your casting for draping, you can simply lay the casting on a ruler and measure to the halfway point.When you find the halfway point you can mark it on the casting with pencil, which should either be easily removable or burn off during draping.

2 **Finding the centre without a ruler**

Or you can trace the bottom of the casting onto paper and fold it in half to find the halfway point as well. When ready to drape, line up your halfway point with the mark on the GM267. For ideal draping, the bottom of the casting should be about 1/8" above the mark on the GM267.

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.	222°C/hr	to 796°C**	0:10
4.	AFAP* OR 9999°C/hr	to 482°C	1:00
5.	56°C/hr	to 426°C	0:05

TOP TIP

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.	153°C/hr	to 690°C	0:15
2.	AFAP* OR 9999°C/hr	to 510°C	1:30

*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.

Allow everything to cool before removing from the kiln. After draping, the casting can either stand alone or be displayed on the LBGM267 Lamp Base Kit. The base can be decorated with acrylic stains or spray paint.

After the paint is dry, insert the clip light through the hole in the bottom of the base and place the bulb into the socket. If desired, use hot glue or an epoxy to adhere the snowman to the base.