



Creative Paradise Inc.



Pattern for XL Lily

Form your XL Lily on the CPGM 139 Cone Former mould.

Arrange three large, three thin and six small diamond shaped petals as indicated in figure 1 overleaf. Figure 1 is provided to indicated petal placement and is much smaller than the size of the actual flower. To create a flower with a hole in the center to place on a stem, create a void where all of the petals meet in the center as indicated in Figure 1.

The glass was tack fired using the tack fire schedule overleaf and then placed on CPGM139 (treated with glass separator) and draped using the drape firing schedule overleaf. Be sure to print PDF as "actual size".



Ensure your mould is well primed before use

By using a primer this will prevent the glass sticking to the mould and potentially damaging the mould and the glass, make sure you use a small brush for detailed areas and dry thoroughly.

Creative Paradise highly recommend using ZYP a Boron Nitride spray due to the high temperatures required, this easy to apply spray can fire up to 982°C. Several light coats with a short waiting period of around 15 minutes between coats is preferable to one heavy coat. Shake the can well before use and hold the can upright while using to assure proper distribution of product. You will need to apply one light coat each time you fire.

Templates

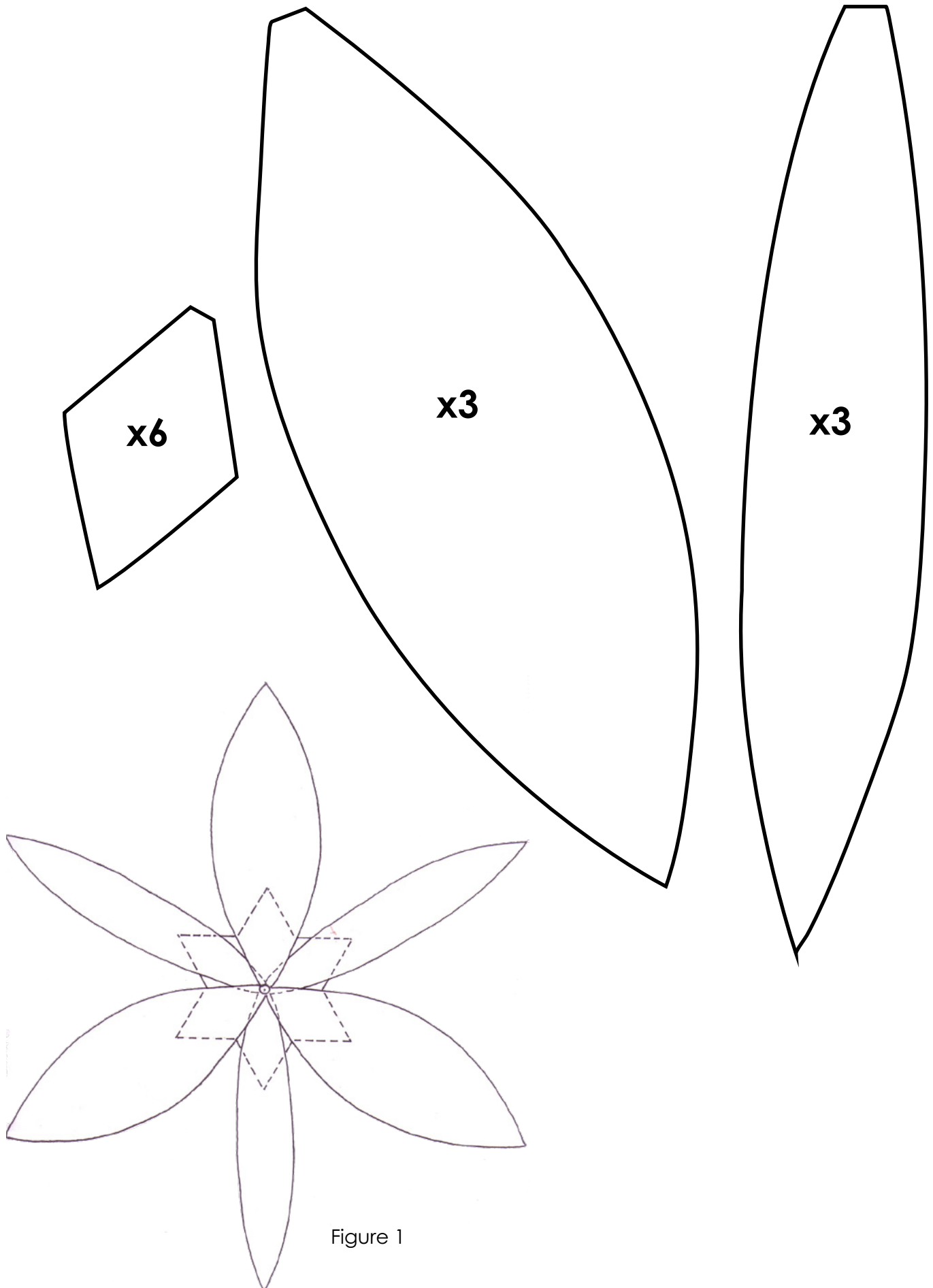


Figure 1

Firing schedules

Tack fuse

Segment	Rate Celsius/hr	Temp	Hold time (hr:min)
1.	153°C/hr	to 593°C	0:15
2.	111°C/hr	to 662°C	0:10
3.	111°C/hr	to 760°C	0:10
4.	AFAP* OR 9999°C/hr	to 510°C	1:30

Drape

Segment	Rate Celsius/hr	Temp	Hold time (hr:min)
1.	153°C/hr	to 537°C	0:10
2.	153°C/hr	to 657°C	0:20
3.	153°C/hr	to 665°C	0:02
4.	AFAP* OR 9999°C/hr	to 510°C	1:30