



Creative Paradise Inc.



Snowman icicle casting mould

In this tutorial you will learn how to make a delicate Fairy Icicle Ornament using the Creative Paradise, Inc mould LF176.

You will need to following to create this project:

- Creative Paradise, Inc. mould LF175
- 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 Use a powder sifter to fill the nose of the snowman with powdered Orange Opal frit.
 - 2 Fill the eyes and mouth with powdered Black frit. Clean up any stray frit using an ear wax vacuum or soft brush. Be careful not to stir up the glass separator.
 - 3 Place a bit of powdered Mauve in the cheeks of the snowman.
 - 4 Use a pipette or the to fill the lower area of the scarf and hat trim with fine Medium Blue frit.
 - 5 Fill the fringe of the scarf and begin to fill the top of the hat with fine Hydrangea frit.
 - 6 Begin to fill the scarf and hat trim with fine Cobalt Opal frit. Fill only as full as will stay inside the scarf area.
 - 7 Fill the hat with fine Hydrangea frit.
 - 8 Begin to fill the face with fine White frit. Fill only as full as will stay inside the face area.
 - 9 Continue to fill the face with fine White and the scarf and hat with fine Hydrangea alternating from one to the other until the areas are filled with those frit colors.
 - 10 Fill the arms and body with about 1/4" of fine White frit.
 - 10 Back the entire snowman area of the cavity with medium grain White frit.
- Place rods and/or strips of clear glass (on edge) in the icicle portion of the mold cavity.
- Fill the entire cavity with medium grain Clear frit until the mold is holding 76 grams of frit. Fire the mold using the schedule overleaf.

Fusing program

Segment	Rate Celsius/hr	Temp	Hold time (hr:min)
1.	166°C/hr	to 621°C	0:45
2.	83°C/hr	to 743°C**	0:20
3.	222°C/hr	to 790°C	0:10
4.	AFAP* OR 9999°C/hr	to 510°C	1:00
5.	55°C/hr	to 426°C	0:05

*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.