Unicorn casting mould

Casting molds are a simple way to make beautiful glass art. This fun detailed mould creates a finished piece measuring 3" x 4". Display it alone as an ornament with bail, slump it over the small stand up mould (sold separately) to make a three-dimensional piece or tack fuse it into a larger piece to make complex wall art and more.

You will need to following to create this project:

- Creative Paradise, Inc. mould LF189 and stand-up mould GM40 if you want the unicorn to stand
- Powder sifter
- Pipette
- ZYP
- F1 Powdered Frits, F2 Fine Frits

TOP TIP

Make sure you use a glass separator on your casting mould

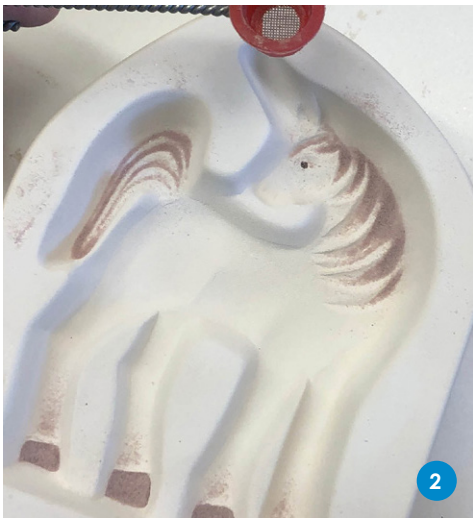
It is crucial that you coat your mould with a glass separator so that the glass won't stick to the mould once it is fired. If you don't apply enough glass separator your glass will get stuck or pull out some of the mould. We would recommend using ZYP (Boron Nitride Spray), this comes in a can which can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

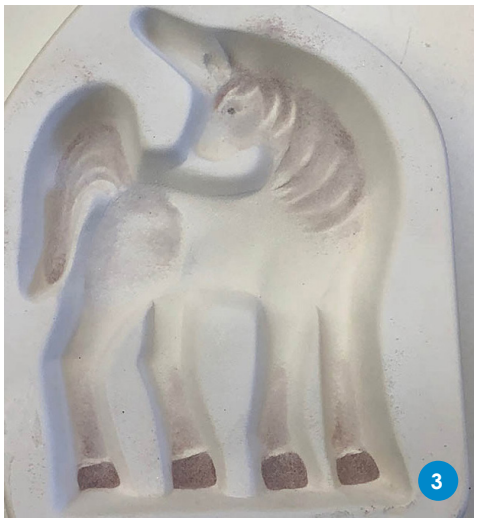
TOP TIP

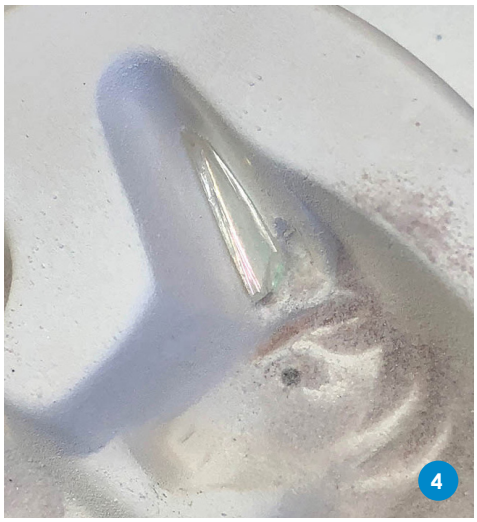
Keep your mould edges clean

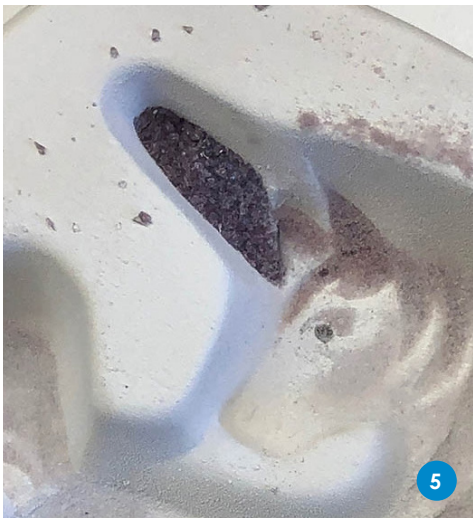
Once you have added your frit make sure that you sweep away any loose frit from the edges of the mould, this will prevent burrs from occuring and will ensure that your shape has a smooth edge. Use a powder sifter when using your powdered frit to allow you to easily add fine detail.

The process









1. Use a Powder Vibe or other device to place F1 Black in the eye and F1 Plum Opal in the hooves.
2. Use a powder sifter to sift F1 Plum Opal into the mane and tail and a bit into the legs above the hooves.
3. Use a powder sifter to sift F1 Pale Purple into the maine and tail, cheek, hindquarter and the lower legs.
4. Cut a small piece of Clear Dichroic and place that sliver into the horn area with the coating side down.
5. Cover the Dichroic in the horn area with F2 Violet.
6. Fill the rest of the mould cavity with 30 grams of F2 White (approximately 1/4" of frit).
7. Sweep the frit back from the cavity wall. Fire the project to a tack fuse. A suggested firing schedule can be found overleaf.
8. Allow the kiln to cool. Remove the glass from the mould and wash the glass to remove any glass separator. Place the glass piece on a GM40 Small Stand Up Mould that has been treated with a clay based glass separator. (Zyp/Mo-re BN glass separators may cause the glass to slide off of the mould during the firing process). Fire the glass on the mould using a slump firing schedule. A suggested slump schedule can be found overleaf.

Tack fusing program

Segment	Rate Celsius/hr	Temp	Hold time (hr:min)
1.	152°C/hr	to 621°C	0:20
2.	194°C/hr	to 771°C**	0:05
3.	AFAP* OR 9999°C/hr	to 515°C	1:00

Slumping program for stand up mould (optional)

Segment	Rate Celsius/hr	Temp	Hold time (hr:min)
1.	152°C/hr	to 654°C	0:30
2.	AFAP* OR 9999°C/hr	to 515°C**	1:30
3.	55°C/hr	to 260°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.