

KILNCASTING – Glass Dragonfly

FILLING THE MOLD

The glass level will drop to about 50% as it melts into the mold. To be sure you put in enough glass to fully fill the mold.

1. Cut a piece of glass for the body provided in the pattern.
2. Place the body piece in the mold.
3. Put in a piece of glass or some frit for the head.
4. Fill in the mold alongside the body piece with frit or powder. Using a different color than the piece cut for the body will produce stripes. With a small brush, wipe away the frit or powder to level with the mold.



KILN WASH

It's necessary to reapply fresh kiln wash for each firing. If you don't remove the kiln wash from the previous firings, it will continue to build up and fill in the detail in the mold. Because it's easy to scrub out with a toothbrush, we recommend "Hotline" kiln wash.

FIRING SCHEDULE for CASTING

- Seg 1 600 dph to 1000 F hold 20 min
- Seg 2 1500 dph to 1475 F hold 15 min
- Seg 3 AFAP to 960 F hold 30 min
- Seg 4 600 dph to 100 F OFF

ATTACHING WINGS

Cut out the wings per the pattern. Grind or belt sand the wings and the cast body as needed. Don't be too worried about a rough edge from grinding. It'll smooth off in the firing. Set the wings in position on your kiln shelf. Place the cast body on top of the wings.

FIRING SCHEDULE for TACK FUSE/FIRE POLISH

- Seg 1 500 dph to 1000 F hold 20 min
- Seg 2 1500 dph to 1300 F hold 10 min
- Seg 3 FAP to 960 F hold 30 min
- Seg 4 500 dph to 100 F OFF



VIDEOS

For video clips on using casting molds, visit www.glasscampus.com