



Using Wave Molds

Size

The mold size referred to is the size of the steel before it is bent into the wave. The mold can not handle a flat piece of glass the size of the bent form. The following size restrictions apply:

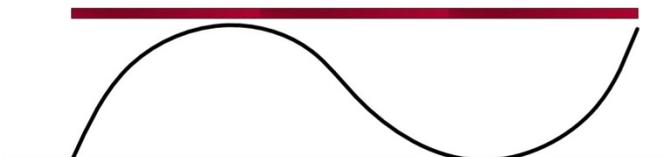
- 9"x12" mold maximum size glass 9"x10"
- 12"x18" mold maximum size glass 12"x14"
- 12"x24" mold maximum size glass 12"x18"

Kiln Wash

To prevent glass from sticking to the steel mold, you can coat it with either kiln wash or boron nitride. If you choose to use kiln wash, you will have to hand sand or sandblast the metal to give it enough tooth to hold the kiln wash. A handy trick to get kiln wash to stick is to place the mold on your kiln lid when the kiln is firing. The kiln wash will bond quickly to the heated metal. If you chose to use spray on boron nitride, there is no need to sand the metal. Just clean it to remove any oil and spray with two light coats.

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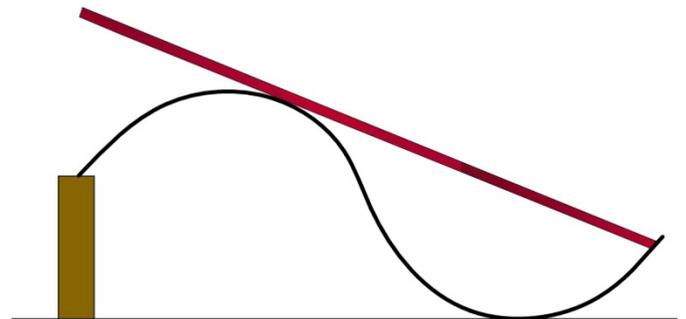
How fast glass slumps or drapes depends directly on the span. The longer the span, the faster the glass will drop. If glass is set on a wave mold as in the drawing below, the longer span on the right will drop faster than the span on the left causing it to slide down into the mold and push the glass off the left of the mold.



This is what will happen:



If you want your project to slump evenly on the mold, you must elevate one end to get the glass to drop evenly. Kiln posts or bricks work well to elevate the mold.



This will cause the glass to slump like this:



Suggested Elevation

- 12" long mold elevate 2 to 3"
- 18" long mold elevate 3 to 4"
- 24" long mold elevate 4 to 5"