

larger glass formats like billets and casting rocks, we suggest that the “hold” at the maximum temperature be increased to give the glass a chance to conform to the mold.

The table below lists how much glass (in grams) should be arranged in each design’s base and lid. We often refer to these weights as “fill weights.”

Design	Base	Lid
3½” Round	295	115
4x5” Rectangle	450	220
6” Elliptical	375	180
5” Kidney	385	180

Place a container on the digital scale. Zero the scale and measure out the frit for the base. If your scale doesn’t have a zero or tare function, simply account for the container’s weight in your measurements. With a second container, repeat the process weighing out enough frit for the design’s lid. Carefully pour the weighed glass into the primed molds. When casting, glass spurs can be formed when the hot glass – as it melts and compacts – drags down the mold’s interior. To reduce or eliminate spurs, mound the glass towards the design’s center. Fine frit produces fewer spurs than larger frit or cut sheet glass. Spurs can be ground and the pieces fire polished.

For projects where different types of glass is combined, it is often easier to weigh the glass in the mold.

Place an empty mold on the scale, zero the scale, and fill the mold directly stopping when the fill weight is reached.



When arranging larger glass frit or cut glass pieces in the molds, load and arrange the glass gently as the sharp edges can scrap away the kiln wash from the mold. This could contaminate the glass or cause the casting to stick.

Firing the Molds

Place the two filled molds into the kiln. Use the Casting Schedule below as a guide.

Don’t rush the schedule’s slow cooling ramp as this allows for proper annealing. Also note that the schedules need to be modified for kiln load, COE, and glass color. Heating element position can also effect firings. Use lower temperatures when using a lid element kiln.



Another factor is whether the glass is opal or transparent. For opal glass, reduce firing temperature by 25°F (15°C) and use shorter hold times. Opal glass has a tendency to

Casting Schedule*

Segment	Ramp	Temperature	Hold
1	300°F/165°C	1250°F/675°C	30 minutes
2	300°F/165°C	1410-1430°F/765-775°C	30-60 minutes
3	AFAP	960°F/515°C	90 minutes
4	50°F/30°C	800°F/425°C	None
5	100°F/60°C	600°F/315°C	Off. No venting

*Schedule for COE 96. For COE 90, increase casting temperature by 25°F/15°C. AFAP means “As Fast As Possible”, no venting.

Fire Polish Schedule*

Segment	Ramp	Temperature	Hold
1	200°F/110°C	1300-1325°F/705-715°C	10-20 minutes
2	AFAP	960°F/515°C	90 minutes
3	50°F/30°C	800°F/425°C	None
4	100°F/60°C	600°F/315°C	Off. No venting

*Schedule for COE 96. For COE 90, increase casting temperature by 25°F/15°C. AFAP means “As Fast As Possible”, no venting.

absorb more heat. These high, prolonged temperatures can make the kiln wash difficult to remove from the mold. If this occurs, fine sandpaper or a dry, non-scratch, nylon, kitchen scouring pad, e.g. Scotch-Brite™, can be used to remove stubborn kiln wash.



Glass Courtesy of Uroboros

Fire Polishing

With any casting process, there is a chance for glass spurs to develop. If the casting has any spurs, remove with a power grinder or a diamond pad. Clean and re-prime the molds, and place the smoothed pieces into the freshly primed molds. Re-fire the piece according to the Fire Polish Schedule. The lid should always be placed in its mold whenever it is being fire polished or when tack fusing embellishments to it.

High Gloss Firing

Most people like the subtle contrast between the lid's high gloss surface and the satin surface of the base. However, people occasionally wish to have the base's surface perfectly mimic the lid's gloss. If you wish to "gloss" the box's base, place the cast, glass base into the kiln without its mold, right side up, on a piece of ThinFire™, fiber paper, or a freshly-primed kiln

shelf. Follow the High Gloss Firing Schedule.

This firing is designed to melt the piece's outer surface without softening the piece's core and causing it to loose shape. Remember that darker and opalescent colors absorb more energy and will heat faster and hotter. For darker and opalescent glass, use temperatures in the lower range of Segment 2. For transparent, light, and iridized glass, use temperatures in the higher range of Segment 2.

Tack Fusing Components To Lids

Boxes can be embellished by tack fusing elements to the lids. Possibilities include Colour de Verre castings; frit balls; slumped rods; and shaped noodles, streamers, and stringers.

Place the lid in a freshly-primed mold. (This prevents the lid from

warping.) Arrange the glass elements on the lid. A drop or two of white glue can be used to temporarily hold the piece in place. If the elements have been slumped or shaped, support the pieces with wedges of kiln paper. Fire according to the Tacking Schedule.



Glass Courtesy of Uroboros

Base Feet

Give cast boxes a professional finish with the addition of feet. Use peel-and-stick, silicon cabinet bumpers, e.g. 3M Bumpon™, available from most hardware stores. This will also protect tabletops.

High Gloss Firing Schedule*

Segment	Ramp	Temperature	Hold
1	200°F/110°C	1150°F/620°C	5 minutes
2	AFAP	1275-1300°F/690-705°C	None
3	AFAP	960°F/515°C	90 minutes
4	50°F/30°C	800°F/425°C	None
5	100°F/60°C	600°F/315°C	Off. No venting

*Schedule for COE 96. For COE 90, increase casting temperature by 25°F/15°C. AFAP means "As Fast As Possible", no venting.

Tacking Schedule*

Segment	Ramp	Temperature	Hold
1	200°F/110°C	1250-1275°F/675-690°C	5-10 minutes
2	AFAP	960°F/515°C	90 minutes
4	50°F/30°C	800°F/425°C	None
5	100°F/60°C	600°F/315°C	Off. No venting

*Schedule for COE 96. For COE 90, increase casting temperature by 25°F/15°C. AFAP means "As Fast As Possible", no venting.