# Lesson Plan:
# Cast Glass Jewelry

## Mold Options

| Item # | Description | # of castings mold creates |
|---|---|---|
| 24653 | Traditional Cabochon Mold 6”x4”-create 8 different cabochons (Delphi Exclusive!) | |
| 24664 | Studio Essential Mold 5”x5”-create 12 different cabochons/earrings (Delphi Exclusive!) | |
| 24657 | Fun and Funky Cabochon Mold 6”x4”-create 8 different cabochons (Delphi Exclusive!) | |
| 80610 | Circle Pendant Mold – creates 4 pendants | |
| 80622 | Circle Earring Mold – creates 3 pairs of earrings | |
| 80643 | Teardrop Pendant Mold – creates 4 pendants | |
| 80644 | Teardrop Earring Mold – creates 3 pairs of earrings | |
| 80611 | Square Pendant Mold – creates 4 pendants | |
| 80623 | Square Earring Mold – creates 3 pairs of earrings | |
| 80618 | Oval Pendant Mold – creates 4 pendants | |
| 80619 | Oval Earring Mold – creates 3 pairs of earrings | |
| 80641 | Rectangle Pendant Mold – creates 4 pendants | |
| 80642 | Rectangle Earring Mold – creates 3 pairs of earrings | |
| 80645 | Diamond Pendant Mold – creates 4 pendants, with 2 style choices | |
| 80646 | Diamond Earring Mold – creates 3 pairs of earrings, with 2 style choices | |



## Other Materials

| Item # | Description |
|---|---|
| Assorted 96 COE colored frit | |
| 48235 | Hotline Primo Primer - **1.5** lbs |
| 48230 | Hotline Primo Primer - **5** lbs |

*Teacher’s note: Although a small amount of this primer goes a long way, you may want to have a larger size quantity depending on the number of students and how readily the class is taught.*

| | |
|---|---|
| 7466 | Haik Brush (for applying the primer) |
| 77201 | Triolyse Adhesive Kit |

## Bail Options

| Item # | Description |
|---|---|
| 63911 | Sterling Silver Plated large, 25 piece pack |
| 63912 | Sterling Silver Plated small, 25 piece pack |
| 63913 | 18K Gold Plated large, 25 piece pack |
| 63914 | 18K Gold Plated small, 25 piece pack |
| 63919 | Sterling Silver Plated Earring, 12 pair pack |
| 63929 | 18K Gold Plated Earring, 12 pair pack |
| 63937 | Gold Colored large, 25 piece pack |
| 63938 | Gold Colored small, 25 piece pack |
| 704523 | Silver Round Pendant Plates, 18 piece pack |
| 704553 | Silver Square Pendant Plates, 18 piece pack |
| 704613 | Silver Oval Pendant Plates, 18 piece pack |
| 704614 | Gold Oval Pendant Plates, 18 piece pack |

(Other bails and jewelry findings can be found on our website: www.delphiglass.com)


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**Directions:**

**1). Preparing the Mold**

**a).** Clean previously used molds by using a soft brush like an old tooth brush; something that will not mar or take away any of the fine detail inside the mold.

**b).** Washing- 4-5 layers of Hotline Primo Primer mixed 1 part powder to 5 parts water. Wait a couple of minutes between layers.

**c).** Drying – be sure the kiln wash/primer on the mold has plenty of time to dry. You may dry in the kiln by ramping up 500°F/hour to 550°F for 20 minutes – cool but do not crash/rush to room temperature.

**2). Filling the Mold**

**a).** Choose respective fine frit colors for desired project. All casting molds have suggested gram weights on the packages to help you fill each mold perfectly.

**b).** Heaping the mold – be sure to keep the edges of the filled mold flush to the top of the mold and heap the frit in the center, since as air escapes this heaped portion on top will shift down accordingly.

**3). Firing the Mold**

**a).** If you desire air bubbles ramp kiln up 500°F/hour to 1435-1445°F, soak for 10 minutes and as fast as possible to 980°F, soak for 30-60 minutes. Use larger frit.

**b).** When desiring less obvious or fewer bubbles use the following firing recommendation:

500°F/hour to 1225, soak 20 minutes
50°F/hour to 1275, soak 20 minutes
300°F/hour to 1440, soak 20 minutes
And then, as fast as possible to 980°F, soak 30-60 minutes
Do not flash vent

Use smaller frit; but the use of fine frit will produce tiny pin point bubbles that may be seen and powder will look opaque because of the tiny bubbles inherent with its size.

*Teachers Note: Jewelry molds as listed in this plan can have soak times cut in half, since they are smaller molds. The schedule and soak times above are typical for average size casting molds.*

**4). Demolding the Sculpture**

**a).** Do not remove from kiln until at room temperature.

**b).** Invert over newspaper. Lightly tap if necessary.

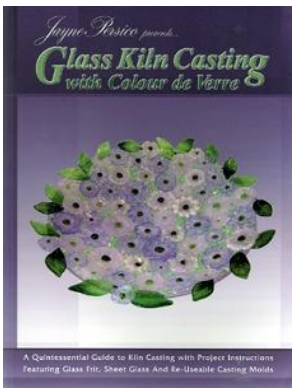
**c).** May need to grind off sharp fins.

**d).** Rinse in warm water and scrub with soft brush to remove kiln wash.

**e).** Be sure to scuff both the back of the glass as well as the bail and glue together with Triolyse.

**5).Clean Mold for Next Time**

Follow instructions 1a from above.




**For more Casting Instruction and Project Ideas:**

**<u>Glass Kiln Casting with Colour de Verre</u>**

This introduction to frit casting techniques guides the beginner through from start to finish with easy-to-follow instructions and an abundance of color photos. This inspirational yet thoroughly practical guide presents lush photographs of beautifully finished pieces that will capture the imagination. The clear and simple instructions will enable fusers of any skill level to achieve amazing 3-dimensional creations. Topics include tools, materials and programming your kiln for ideal firing. 80 pages, with more than 260 color photographs.


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