



Holiday Silhouettes

Make our Holiday Silhouettes to give to friends, or for studio or craft sales. Make sure you save enough for your own holiday decorating.

Our Holiday Silhouettes are actually a group of three, holiday-inspired molds:

- Holiday Tree & Stocking
- Candy Cane & Snowman
- Gingerbread Man & Gift

Cast them in “expected” colors (red for the candy cane, green for the tree) or cast them solid white or clear for a stylized look. Further, the cast glass outlines can be filled with medium frit, decorated, and fired a second time to produce truly customized pieces.

Preparing the Molds

The molds must be primed so the glass doesn’t adhere to the ceramic material from which the molds are made. There are two choices for primers: Hotline Primo™ Primer and ZYP BN Lubriccoat. The ZYP is the easiest to apply and remove. It is an aerosol and, after firing, brushes off easily from the molds and can be washed off the pieces. Castings created using ZYP have exceptionally smooth surfaces and almost never require grinding or “cold work.”

Primo is a traditional kiln wash that is applied with an artist’s brush. It’s a trusted and proven product, but requires a bit more “elbow grease” to remove after firing. Primo’s big advantages are its low cost and availability.

Brief instructions for each option follow:

To apply ZYP, hold the well-shaken can 12 inches from the mold. Hold both the mold and the spray can upright. Apply the first, light coat using a two to three-second burst of spray in a sweeping pattern across all the mold’s cavities. Do not saturate the surface. If it is the first time ZYP has been applied to this mold, it is necessary to apply a second coat of the product. Before applying the second

coat, let the mold dry for five minutes. Apply the second coat using another two to three-second burst of spray. In either case, let the mold dry for ten to fifteen minutes before filling. Again, the double coat of ZYP need be only applied the first time. Thereafter, only one coat is necessary. For more information about ZYP, visit our website. Then, download and read *Priming with ZYP Boron Nitride Aerosol*.



If you choose to use Primo Primer, give your mold three to four thin, even coats of Hotline Primo Primer kiln wash. Use a soft artist brush to apply the Primo Primer and a hair dryer to completely dry each coat before applying the next. Again, more detailed instructions can be found on our website. See *Tricks of the Trade*. When using Primo Primer, best results are obtained when using fine frit. Larger

Tools

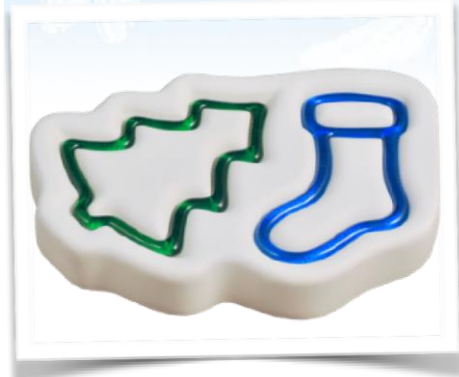
- ✓ Small artist’s brushes
- ✓ Digital scale
- ✓ One or more Holiday Silhouette designs
- ✓ Small measuring spoons

Supplies

- ✓ Assorted frits
- ✓ CBS Dichroic Flakes
- ✓ ZYP BN Lubriccoat or Hotline Primo™ primer

REUSABLE MOLDS FOR GLASS CASTING

frit can produce excessive casting spurs that require cold work.



Moss Green was used in the tree. Medium Sky Blue in the Stocking

Filling the molds

The molds can simply be filled with frit or a mixture of frits to create sweet decorations. Consult the Fill Weights table below and use the weight in the column labeled "Total Fill Weight". We find the best results are usually obtained by "diluting" colored frit with clear frit. Even dark, opaque colors like blacks and browns be-

come much more rich when mixed with clear frit. (See our document *Creating Frit "Paint Chips"*) It is important to remember that, when using frit, to wear a dusk mask.

The technique on which we concentrate in this project sheet results in a more complex look but still requires only one firing.

Consult the table below and note there are different Base, Flakes, and Clear weights for each design. Choose a fine colored frit - either



opal or transparent - to use as a base layer. Weight out the appropriate Base Color weights and put them in each cavity. Level this with a small artist's bush.

Next, evenly sprinkle a few grams of CBS Dichroic Flakes over the colored frit. Use a small artist's brush to move any dichroic flakes away from the mold's edges.

Fill the remainder of each cavity with the specified medium Clear frit. Evenly distribute it and, if necessary, gently use the artists brush to level the Clear frit.

Once all the cavities have been filled, fire the mold according to the General Firing Schedule.



Another Technique

All the Holiday Silhouettes can be "colored in" with medium frit and decorated with frit balls made from either plain or dichroic glass, and garlands made from stringers or noodles.

Place the cast outlines on a small kiln shelf protected by a sheet of kiln paper. Use medium frit to fill in the outlines leaving a small, clear space at the top of the

Fill Weights

| Design | Base Color | Dichroic Flakes | Medium Clear | Total Fill Weight |
|-----------------|------------|-----------------|--------------|-------------------|
| Stocking | 5-6 grams | 1-2 grams | 10 grams | 16-18 grams |
| Tree | 5-6 grams | 1-2 grams | 10 grams | 16-18 grams |
| Gingerbread Man | 8-9 grams | 3-4 grams | 13 grams | 25 grams |
| Gift | 8-9 grams | 3-4 grams | 13 grams | 25 grams |
| Snowman | 9-10 grams | 4-5 grams | 14 grams | 25-30 grams |
| Candy Cane | 9-10 grams | 4-5 grams | 14 grams | 25-30 grams |

General Firing Schedule*

| Segment | Ramp | Temperature | Hold |
|---------|-------------|----------------|---|
| 1 | 300°F/165°C | 1420°F (770°C) | 10 minutes for fine frit 10-20 minutes for medium frit |
| 2 | AFAP | 960°F/515°C | 30 minutes. Off |

* Schedule for COE 96. For Bullseye, increase casting temperature by 20°F/10°C. AFAP means "As Fast As Possible", no venting.

ornament for a ribbon or string to pass through.

Frit balls, stringers, and noodles can be embedded into the medium frit to serve as decorations. Fire the completed pieces to a tack fuse to adhere the medium frit pieces together, but not to melt them completely. A good starting range is between 1275 to 1300°F (690 to 705°C) and hold 10 minutes.

Reusing the Molds

Clean mold thoroughly after each firing with a stiff, nylon bristle brush. Avoid breathing any dust by wearing a proper dust mask. Reapply primer before subsequent firings.

If correctly primed and fired, a Colour de Verre mold will yield many castings.

