



Pillow Pendants with CBS Dichroic Glass

Create beautiful dichroic pendants and stunning beads by combining CBS Coating by Sandberg patterned sheets with Colour de Verre's Pillow Pendant molds.

This document outlines a second way to fill our Pillow Pendants and other bead designs. Our technique is a two step process and requires a glass grinder and a little more finesse. The results are well worth the extra step - and the best part: This technique requires no glass drilling.

Preparing the Molds

The molds must be primed so the glass doesn't adhere to the ceramic material from which the molds are made. For this technique we only

suggest using ZYP BN Lubricant (formerly MR-97). It will yield smooth edges and a fine surface. ZYP, after firing, brushes off easily from the molds and can be washed off the pieces. Castings created using ZYP almost never require grinding or "cold work."



To apply ZYP, hold the well-shaken can and the mold vertically, 10 to 12 inches from each other. 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. Pay special attention to make sure the cones are evenly coated. Let the mold dry for ten to fifteen minutes be-

fore filling. Again, the double coat of ZYP need be only applied the first time. Thereafter, only one coat is necessary.

Shaping the Dichroic Glass

Cut out the templates that are on the final page of this document. If you are using CBS' Crinkled Dichroic patterns, choose sheets that *are not* pre-fired. On the non-dichroic side of the glass, place the template pieces. Mark the glass and roughly cut the glass to fit the templates. Turn the rough shapes over - dichroic side up - again trace the templates. (Craig's favorite tool for this is a Sharpie brand white paint marker. The line it leaves stays in place during



Tools

- ✓ Small artist's brushes
- ✓ Digital scale
- ✓ Colour de Verre Pillow Pendants molds
- ✓ Glass marker
- ✓ Power Grinder

Supplies

- ✓ Medium Water Clear frit
- ✓ Coatings by Sandberg Borderline Pattern Dichroic on thin, Black glass
- ✓ ZYP BN Lubricant (formerly MR-97)

the grinding process and can easily be removed with rubbing alcohol.)



Shaping and Second Firing

Remove the cooled mold from the kiln. Each of the dichroic pieces will have slumped over the center cone. Remove the pieces from the mold.



Fill Weight

Design	Grams of Frit per Cavity
Pillow Pendants	
Large rectangle	20 to 24
Medium rectangle	16 to 18
Small rectangle	12
Large square	14
Small square	10
Simple Round	
Large	17
Medium	11
Small	7

Use a power glass grinder to shape the glass pieces to the exact shape of the template. Grinding with the dichroic side up prevents the dichroic surface from being scratched by the grinder platform. Finally, use the grinder to bevel the pieces' back edges. This prevents the sharp edge from scratching away the primer.

First Firing

Place the dichroic shapes in the prepared mold, dichroic side up. The glass cutout will not lie flat because of the cavities' cones.

Fire the pieces according to the First Firing Slump Schedule.

If the pieces don't fall out easily, turn mold face-down and tap it against a hard surface cushioned with several layers of newsprint.



First Firing Slump Schedule*

Segment	Ramp	Temperature	Hold
1	350°F/195°C	1275 - 1300°F (690 -705°C)	25-30 minutes
2	AFAP	960°F/515°C	30 minutes. Off

Second Firing Schedule*

Segment	Ramp	Temperature	Hold
1	300°F/165°C	1250°F/675°C	30 minutes
2	300°F/165°C	1350°F/730°C	45-60 minutes
3	AFAP	960°F/515°C	30 minutes. Off. No venting

*Schedule for COE 96. For COE 90, increase casting temperature by 20°F/10°C. AFAP means "As Fast As Possible", no venting.

The pieces should be flat except for the small "mountain" that has been created by the cone. Using a power grinder remove the "mountain," making sure not to damage the dichroic on the flat portion of the piece. (We found it easiest to remove the grinder's platform.

It's still important to make sure that the grinder head remains wet while grinding. Use a sponge to

keep the bit constantly wet.) It is all right if a little bit of the mountain base remains.

After grinding and cleaning each piece, weigh it, and note the weight.



Clean and re-prime the mold with ZYP. Let the mold dry for 15 minutes.

Place the ground dichroic shapes back into the mold. Add enough medium Water Clear frit to each cavity to reach the weight shown in the Fill Weight table.

Level frit with a small artists brush. Place the filled molds on a *leveled* kiln shelf and fire according to the Second Firing shown below.

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.



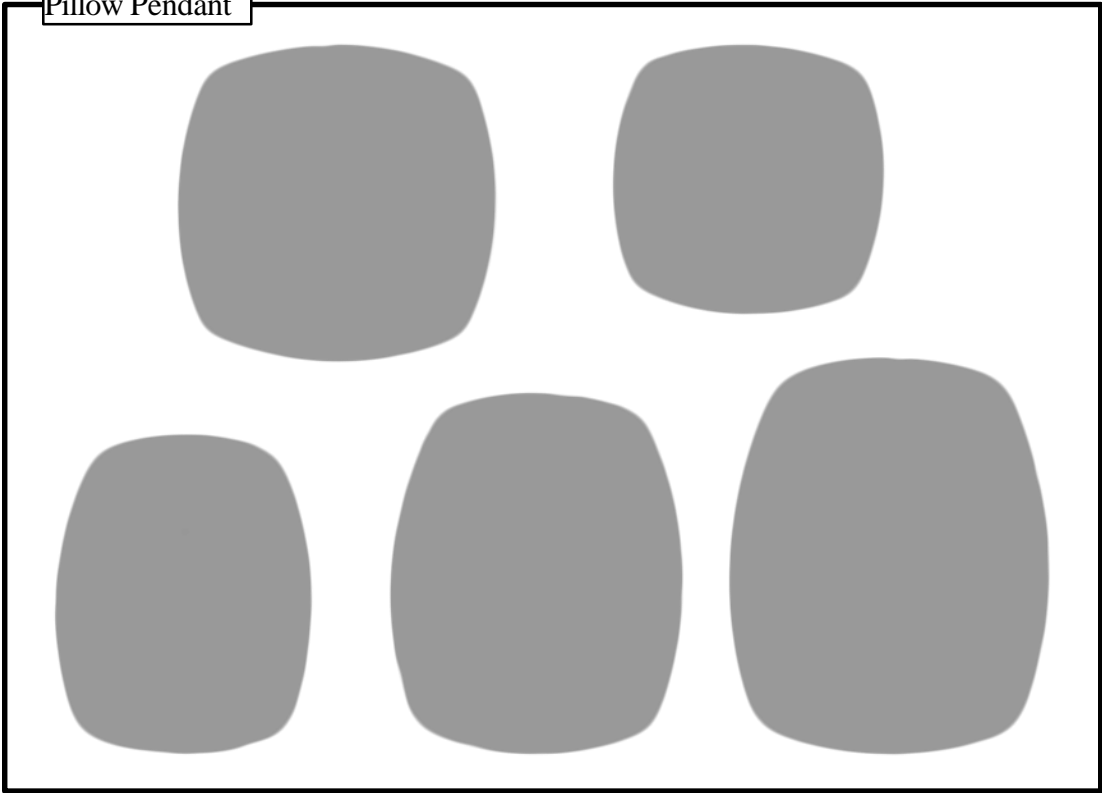
Variations

This technique can be used with our Simple Round Beads design. When using this design, it is very helpful to mark the center of each glass cutout and to grind a small depression in the uncoated side of the cutout. This helps keep the cutout centered during the first firing. This can be easily done using a small grinding bit like shown in the image below.



Templates

Pillow Pendant



Simple Round

