



## Priming Colour de Verre Molds Using ZYP Spray

ZYP BN Lubricant Aerosol (formerly MR-97) is a boron nitride (“BN”) spray. When applied to the molds, the results are superior castings, virtually no spurs or sharp edges, and a beautiful, shiny surface. Application is as easy as applying a cooking spray. So what is the hitch? This sounds just too good to be true.

The biggest considerations are:

- Application requires a bit of **fi**nesse. ZYP spray contains an ultra-**fi**ne powder. One must make sure that the entire surface is thinly, but completely covered.
- Once you start using a BN spray on a mold, you can’t go back. The spray seals the mold and traditional primers won’t be ab-sorbed evenly.

- We tested ZYP in **fi**rings up to 1440° F. We noted at higher temperatures, ZYP worked best with transparent glasses. At these higher temperatures, a cloudi-ness appeared on opal glasses. We believe this surface cloudi-ness or veiling might be mitigat-ed by reducing temperatures and, instead, increasing hold times. This cloudiness can also be reduced by mixing opals with at least 50% clear or transparent frits.

- Like all **fi**ne particle products, it is important to wear a dust mask. Also, because of the propellents, it is important to apply it and remove it outside or in a well-ventilated space.

### Not all BNs are Equal

After testing many boron nitride sprays, we discovered a clear winner: ZYP. This product gave us consistent, superior results.

ZYP is a touch more expensive than some of the other BN products. However it only takes one broken mold or stuck casting to persuade you not to use a lesser quality product. ZYP is available at our website.

### Applying ZYP

If your mold has been used before, completely remove all the old Primo Primer from the mold with a stiff nylon kitchen brush and/or tooth brush. Read the instructions on the ZYP can. The Material Safety Data Sheet can be down-

loaded from ZYP product detail page in our online store. *Note: Make sure to shake the can thoroughly for at least 60 seconds after you start hearing the ball freely rattling inside the can.*

The **fi**rst time ZYP is used on a mold, it is necessary to apply two coats of the product. Hold the can 10 to 12 inches from the mold. *Hold both the can and the mold upright.* For smaller, shallow molds, apply the **fi**rst, light coat using a two to three-second burst of spray in a sweeping pattern across all the mold’s cavities. For larger molds – our box molds for example – use a three to **fi**ve-second blast making sure to cover the deepest recesses. *Do not saturate the surface.* If you no-tice the surface looking wet, im-mediately stop spraying. Allow the mold dry and then lightly respray the wet area.

Set the mold aside for **fi**ve minutes so it can dry. Once dry, reapply a second coat using another two to three-second (three to **fi**ve-second for larger molds) burst of spray. Let the mold dry for ten to **fi**fteen minutes. The mold is ready to **fi**ll.

*Note: If a can of ZYP is less than half full it sometimes doesn’t spray product as heavily. In this case, increase spray time by a second or two.*

### Filling the Molds

The ZYP surface is delicate and care must be taken not to scratch away the primer as you **fi**ll the mold. We recommend using powder, **fi**ne, and medium frit as opposed to larger meshes or broken sheet glass. The larger frit can

scratch the surface and create potential sticking problems.

### **Cleaning Your Castings**

It is important to remove any residual boron nitride from your glass casting otherwise your cast components will not tack fuse properly in your next **fi**ring.

Wash the casting in warm water with a little dish washing liquid and a mild, abrasive cleansing powder like Bon Ami®. Rinse thoroughly and dry.

### **Subsequent Firings**

The ZYP becomes powdery after **fi**ring and it is best to remove it so that it doesn' t mix with frit on the next **fi**ring. We strongly suggest doing this outside or in a well ventilated area wearing a dust mask. Use a stiff, nylon kitchen brush and/or toothbrush – the same tools used to remove Primo Primer – to remove the BN powder. The cleaned surface will look bur-nished and shiny. Reapply *one* thin coat of ZYP as before. The sur-face should now look matte. If any areas are still shinny, touch up with a little more spray. Let the mold dry for ten to **fi**fteen minutes before re**fi**lling.