



Slab Server

These beautiful pieces can be used to serve cheese, hors d'oeuvres, or sushi; or as a platform to showcase an orchid or a treasured object.

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The Slab Server is a simple, elegant design that showcases glass selection and artistic technique. The mold can be filled with billet chucks for graceful simplicity, or sheet glass to create interesting collages. It is a perfect tool for experimentation and creativity.

Priming the Mold

Before each firing, always start by priming a Colour de Verre. There are two products that can be used: Hotline Primo Primer™ and ZYP BN Lubricant.

With either product, clean the mold with a stiff nylon brush and/or toothbrush to remove any old

kiln wash or boron nitride. (This step can be skipped if the mold is brand new.)

To use ZYP, hold the can 12 inches from the mold. Apply a light coat using a five-second burst of spray in a sweeping pattern across the mold's cavity. Do not saturate the surface causing drips to form. Set the mold aside for five minutes so it can dry. If the mold has never been used with ZYP before, apply a second coat using another five-second burst of spray. Let the mold dry for ten to fifteen minutes. The mold is ready to fill. ZYP will result in fewer casting spurs and crisper detail.



See our website for more instructions about priming Colour de Verre molds with ZYP.

If you are using Hotline Primo Primer, mix the product according to directions. Apply the Primo

Primer™ with a soft artist's brush (not a hake brush) and use a hair dryer to completely dry the coat. Give the mold four to five thin, even coats drying each coat with a hair dryer before applying the next. Make sure to keep the Primo well stirred as it settles quickly. The mold should be totally dry before filling. There is no reason to pre-fire the mold with either primer



Coarse frit is placed on the top surface to displace the pattern in the sheet glass

Filling Slab Server

The fill weight for the Slab Server mold is 875-1100 grams. This is the optimal amount of glass to put in the cavity to get superior results. The glass can be billet pieces, glass sheets, frit, or a combination of these. Processes for billet and sheet glass are described below.

Tools

- ✓ Colour de Verre Slab Server mold
- ✓ Digital scale
- ✓ Diamond pad or grinder

Supplies

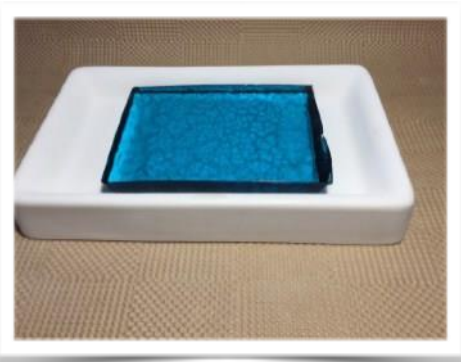
- ✓ Hotline Primo Primer™ or ZYP BN Lubricant
- ✓ Assorted frits, billets, and/or sheet glass

REUSABLE MOLDS FOR GLASS CASTING

Using Billets

Casting with billets results in a minimal number of bubbles, absolute clarity, and beautifully consistent color. While many glassworkers are intimidated by billets, they are no more difficult to cut than sheet glass.

Note: Questions about cutting billets can be answered by a wonderful video produced by Bullseye Glass. You can find that video at www.colourdeverre.com/go/billets.



A Bullseye billet piece in the Slab Server design, ready to be fired

We find that a fill weight of 1000 to 1100 grams works best when casting with billets. Below is a method for determining where to cut the billet to end up with a “chunk” of a specific weight. It works with both square and rectangular billets:

1. Weigh the billet on a gram scale. We will call the result BW, for billet weight.
2. Measure the billet’s length in inches or centimeters. It works either way. We will call this BL for billet length.

3. FW is the mold’s fill weight. Again, you will find this on the mold’s packaging or above.

4. Pull out your calculator and enter the following:

$$FW / BW \times BL =$$

5. Note the calculator’s result and measure this far down the billet and make your score.

6. If the billet does not fit in the mold, cut it into smaller pieces to stack in the mold.



The feet of the Slab Server are filled with coarse frit so the sheet glass melts evenly



Place the billet piece in the center of the mold and fire the mold according the Billet Casting Schedule. The extra heat-work of this schedule will make sure that the glass flows into the entire design.

Billet Casting Schedule (Bullseye Billet)*

Segment	Ramp	Temperature	Hold
1	100°F/55°C	300°F/150°C	30 minutes
2	150°F/85°C	1250°F/675°C	30 minutes
3	200°F/110°C	1475°F/800°C	60 minutes
4	AFAP	900°F/485°C	60 minutes
5	100°F/55°C	100°F/40°C	0 minutes. Off

Sheet Glass/Frit Casting Schedule*

Segment	Ramp	Temperature	Hold
1	150°F/85°C	300°F/150°C	0 minutes
2	200°F/110°C	1250°F/675°C	30 minutes
3	200°F/110°C	1475°F/800°C	30 minutes
4	AFAP	900°F/485°C	60 minutes
5	100°F/55°C	100°F/40°C	0 minutes. Off

*Schedule for Bullseye. For COE 96, decrease target temperature by 25°F/14°C. Anneal at 960°F/515°C. AFAP means “As Fast As Possible”, no venting.

REUSABLE MOLDS FOR GLASS CASTING

Casting With Sheet Glass

Any combination of sheet glass of various thickness can be used provided the total fill weight is between 875 and 1100 grams.

Start with a freshly primed Slab Server mold. Cut the glass pieces into rectangles approximately 5 x 10 inches or 12.5 x 25 cm.

Use a grinder or a diamond pad to remove the sharp bottom edge of the bottom sheet. This will make it less likely to scratch the primer surface. Fill the mold's "feet" with coarse frit and layer in the sheets in the mold. Fire the mold according to the Sheet Glass/Frit Casting Schedule.



Glass tiles and pieces are stacked to produce playful design. The feet are filled with coarse, black frit

Note: To add extra interest to the design, consider piecing together each layer with multiple glass sheet styles and colors.



A fiber paper cut-out was placed under the billet piece to create a "kiln carving"

Finishing the Piece

Once the kiln cools to room temperature, remove casting from the mold. Wash away any primer from the finished casting with dishwashing soap and kitchen brush with stiff nylon bristles.

To give the final piece a crafted look and to protect table top surfaces, apply Bumpons™ or cabinet door bumpers to the finished piece's feet. Apply two Bumpons™ or bumpers to one foot and a single Bumpon™ or



Multiple glass sheets were layered to create a interesting and pleasing design

bumper to center of the second foot.



Two sheets of reactive glass - Robin's Egg Blue and Petrified Wood - are combined in the Slab Server Design



Firing results in a beautiful copper red reaction

Reusing the Mold

Before every firing, any old primer should be removed from the mold and the mold should be reprimed.