



### Tricks of the Trade

*We want our customers to have a great experience and wonderful outcomes with our molds. Let us pass along these hints and advice.*

**1** There are only two primers that should be used with our molds: Hotline Primo Primer™ and ZYP BN Lubricat (formerly MR-97).

For Primo Primer: Mix one part powder with four parts water. Use a soft artist's brush – not a hake brush – to apply three to four thin coats to the mold's inside surface. Let each coat dry before applying the next. A hair dryer can be used to accelerate the drying between coats. Keep the primer well stirred. The primer's fine particles – the active components – settle out of the mixture rapidly. If the primer settles, use a stiff brush to stir the compacted particles off the bottom of the container and back into solution. It is not necessary to pre-fire the mold as long as the primer is dry.

For ZYP: Shake the container

well. Hold the can vertically, ten to twelve inches from the mold. Apply a two to five-second spray depending on the mold's size. If this is the mold's first firing, wait five minutes and apply a second coat.

**2** After firing the mold, use any nylon kitchen brush or a toothbrush to remove all traces of the primer from the mold. We strongly recommend wearing a dusk mask.

**3** Always follow the firing schedule recommended on our website and packaging. These molds are made from a specialized ceramic material.

Like glass, this ceramic will crack or shatter if it is heated or cooled too fast.

**4** Finished pieces will have much smoother edges if you use a small brush to move the frit away from the top edge of the mold. This "trough" only has to be 1/8-inch wide and deep.

**5** Use only crushed art glass or frits in Colour de Verre molds. The molds are not designed for Pyrex glass, float glass, or crushed bottles. We don't recommend firing Colour de Verre molds above 1450°F (785°C). At higher temperatures, the primer will start to fuse and becomes more difficult to remove.

**6** If the finished piece doesn't fall out of the mold, don't panic. Turn mold face-down and tap it against a hard surface cushioned with sev-

eral layers of newsprint. If the piece still doesn't fall out, the mold probably wasn't properly primed.

**7** Occasionally, a few glass spurs might be on edges of the finished pieces. These are easily removed with a wet diamond block or grinder. Following hint #4 will minimize these.

**8** Butterflies, dragonflies, flowers, and leaves can be given more life with a second, slump firing. Some of our designs have a specially designed slumping surface on the reverse side.

**9** Don't be afraid to experiment. Add CMC solution to your glass powders to make a *pate de verre* paste. Mixed crush dichroic with your frits. Tack fuse finished pieces to slumped plates and platters. Mix shredded copper, silver, or gold foil into your frits. Embed smaller forms inside of larger, clear forms. The possibilities are endless.

**10** Make use of attached PDFs and videos. There you can find not only project instructions with complete firing schedules, but helpful tips and product specific documentation.