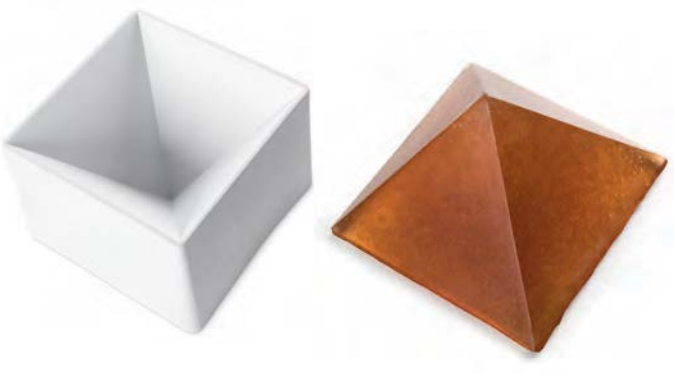
Mold Tips: Pyramid Casting Mold (8948)

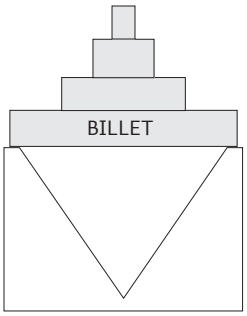
Notes generated in the Bullseye Research & Education studios, firing in Paragon GL24 kilns.

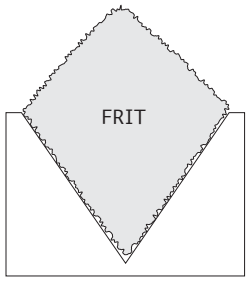


Prepare the Pyramid Casting Mold with primer/separator and kiln-dry as directed in *Tips for Using Bullseye Slumping Molds* at bullseyeglass.com. This mold should be re-prepared before each casting.

To promote even heating and cooling, place the Pyramid Casting Mold centrally in the kiln and elevate on 2" (5 cm) shelf posts.

It takes 2090 grams of glass to maximize the mold form. Billet or frit may be used. For smoother edges around the finished base, heap material in the center as shown. (We have not yet tested this mold using sheet glass, which will involve more complex preparation for successful casting.)





SUGGESTED FIRING SCHEDULE

Suggested firing schedule following a 2" (50 mm) anneal profile appropriate for thickness of glass and hollowed mold structure:

	RATE (DEGREES / HOUR)	TEMPERATURE	HOLD
1	200°F (111°C)	1225°F (663°C)	2:00 for billet 1:00 for frit
2	600°F (333°C)	1525°F (829°C)	2:00*
3	AFAP**	900°F (482°C)	1:00
4	6°F (3.8°C)	800°F (427°C)	:00
5	12°F (6.8°C)	700°F (371°C)	:00
6	41°F (22°C)	70°F (21°C)	:00

* Visually inspect after :20. Skip segment once cast is complete. If bubbles have collected at the top surface, a continued hold will allow them to break open. Visually inspect bubble activity.

** As Fast As Possible. Allow kiln to cool at its natural rate with the door closed.

The topic of the firing cycle as it relates to the glass and kiln conditions is covered in depth in *TechNotes 4: Heat and Glass* at bullseyeglass.com.

Expect matte surfaces where the glass is fired in contact with the mold.

Re-preparation: Due to the high process temperatures and long hold times required, this mold must be re-prepared before each use. Primer is no longer effective once fired to these temperatures. Re-prime after every two to three firings. To re-prime, gently remove the old primer with a dry scrub pad and reapply as directed.

Glass selection: The form of glass used (billet or frit) will have a direct impact on the clarity of the casting. Color is also a major consideration when choosing glass for thick works. To learn about selecting glass for casting, see *TipSheet 8: Basic Lost Wax Kilncasting* at bullseyeglass.com.