

Creative Paradise Inc.★

Patty Gray Molds
Professional Grade
Earthenware Molds for Glass Artists
by Creative Paradise, Inc.

General Instructions for the Successful Use of Dam Molds to Create Thick Paddies of Glass.

- Spray the dam mold with a boron nitrate spray. Make sure to coat the perimeter of the mold with extra care. Allow the boron nitrate spray to rest approximately 15 minutes on the mold before proceeding.
- Place a piece of suitable kiln shelf firing paper in the bottom of the mold. This firing paper allows for glass separation from the mold and helps the air from beneath the glass to ease out around the glass to prevent eruptions during firing. It is a critical part of the process.
- Use compatible fusible glass and fill the mold according to your own artistic preferences.
- The dam mold must be elevated from the kiln shelf during the firing process. One-inch kiln posts can be placed at the extreme edge of each corner of the mold to elevate the mold from the kiln shelf. If a kiln post is too far into the center of the mold, that area of the mold will be heated and cooled at a different rate and undesirable results will occur.
- The following firing schedule has been used with great success to create fully fused thick glass panels:

Segment	Rate (degrees Fahrenheit/Hour)	Temp (degrees Fahrenheit)	Hold (minutes)
1	200	1000	15
2	300	1225	30
3	350	1470	15-20
4	9999	950	120
5	100	700	1

This mold was not designed to act as a catch pot for pot melt techniques or other techniques requiring extreme temperatures or quick heating and cooling. Failure to use kiln shelf paper in the base of the mold and proper elevation of mold during firing can result in eruptions and annealing problems.