



Northwoods Maple Leaf

If you are looking to create a quick house gift for a friend, this design is for you. Create an autumn leaf by filling the mold with mixtures of red, oranges, and yellows or a spring version with greens. Flip the mold to discover a custom slumping surface that changes the cast leaf into a perfect plate.



Priming the Mold

Always start by priming your molds. There are two products you can use: Hotline Primo Primer and ZYP BN Lubricat Aerosol (formerly MR-97).

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.)

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.

The first time ZYP is used on a mold, it is necessary to apply two coats of the product. Hold both the mold and the can upright about 12 inches from each other. Apply the first, light coat using a four to five-second burst of spray in a sweeping pattern across the mold's cavities. Do not saturate the surface. Set the mold aside for five minutes so it can dry. Once dry, apply a second coat using another four to 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's Learn section for more instructions about priming Colour de Verre molds with MR-97.

Filling

The suggested fill weight for the Northwoods Maple Leaf mold is 300 to 320 grams.

To accentuate the mold's details, try one to two grams of black powder sifted into the mold. Before opening the jar, put on a

dust mask as it always best to wear a mask when working with glass powders or other fine particles.

Try using different colors of red, yellow, orange, green - be creative! Use small amounts of transparents with clear so the color does not get too dark.

Fire the mold according to the Casting Schedule. The firing schedule's low target temperature and long hold will prevent the frit from becoming too liquid and balling up due to surface tension. This will keep the leaf thin and delicate.

Slumping Individual Leaves

The easiest way to shape individual Northwoods Maple Leaf castings is to use the integrated slumping surface on the mold's reverse side. Using the same methods described above, prime the slumping surface with either Primer or ZYP. Position the leaf on the primed surface with the textured side up and place the mold into the kiln. Follow the Individual Leaf Slumping Schedule below.

To create bowls, use Colour de Verre's 7-10" Bowl Slumper and follow the same Individual Leaf Slumping Schedule.

Creating Larger Pieces

Multiple leaves can be tack fused to one another and then shaped.

To tack fuse multiple pieces together, start by protecting the

kiln shelf with a primer or ThinFire™. Overlap the pieces in a pleasing manner and fire according to the Multiple Leaf Tack Fusing Schedule.

Once the combined leaves have



cooled, place them in a large, kiln-washed slumping form and fire according to the Combined Multiple Leaf Slumping Schedule.

When tack fusing or slumping combined leaves, it is important to follow the slow ramps. The larger pieces will have a wide range of thicknesses and can crack if ramp speeds are too rapid.

Casting Schedule*

Segment	Ramp	Temperature	Hold
1	300°F/165°C	1315-1335°F/713-723°C	45-60 minutes
2	AFAP	900°F/482°C	60 minutes
3	100°F/60°C	600°F/315°C	Off. No venting

* Schedule for Bullseye Glass AFAP means "As Fast As Possible", no venting.

Individual Leaf Slumping Schedule*

Segment	Ramp	Temperature	Hold
1	300°F/165°C	1215-1225°F/658-663°C	10 minutes
2	AFAP	900°F/482°C	60 minutes
3	100°F/60°C	600°F/315°C	Off. No venting

* Schedule for Bullseye Glass. AFAP means "As Fast As Possible", no venting.



Multiple Leaf Tack Fusing Schedule*

Segment	Ramp	Temperature	Hold
1	200°F/110°C †	300°F/150°C	10 minutes
2	200°F/110°C †	1000°F/535°C	30 minutes
3	200°F/110°C †	1200°F/650°C	45-60 minutes
4	100°F/60°C	1265°F/688°C	10 minutes
5	AFAP	900°F/482°C	90 minutes (180 minutes for 4 or more leaves)
6	50°F/30°C	800°F/425°C	0 minutes
7	100°F/60°C	600°F/315°C	0 minutes
8	200°F/110°C	100°F/40°C	Off. No venting

Combined Multiple Leaf Slumping Schedule*

Segment	Ramp	Temperature	Hold
1	80°F/45°C ††	300°F/150°C	30 minutes
2	80°F/45°C ††	1000°F/535°C	85 minutes
3	50°F/30°C	1215°F/658°C	5 minutes
4	AFAP	900°F/482°C	90 minutes (180 minutes for 4 or more leaves)
5	50°F/30°C	800°F/425°C	0 minutes
6	100°F/60°C	600°F/315°C	0 minutes
7	200°F/110°C	100°F/40°C	Off. No venting

* Schedule for Bullseye Glass. AFAP means "As Fast As Possible", no venting.

† Schedules were developed for side element kilns. Slow ramps by 50°F/30°C for top element kilns.

†† Slow ramps by 30°F/15°C for top element kilns and more than three leaves.