

Recipe Card Basics:

Frit Casting



Before Beginning:

Treat your mold thoroughly with a suitable glass separator. For best results when heating beyond slumping temperatures, we recommend using ZYP. Apply to the mold in a well-ventilated area and wear a mask. Please [refer to this video for instructions](#) on applying ZYP.

If you are following fill weights, weigh your mold before adding frit. Keep your mold on the scale as you add. If your scale has a zero function, you can use it before adding frit and fill until you hit the suggested fill weight. If not, just remember that your desired weight will be the weight of your empty mold + the suggested fill weight.

Always wear a protective mask when spraying your mold with glass separator and when working with Powder/F1 Frits.

Following a Recipe Card:

Each recipe card will tell you the COE, grain, and color of all frits used, as well as any other necessary materials.

The “Placement Order” section lists the various areas of the mold in the order they were filled. The first color listed in a given area was the first color placed in the mold. The second color listed was the second added, etc.

The colors listed were used to create the samples pictured on each card. However, we encourage you to use your own artistic preferences!

Helpful Tips:

- If this is your first time using the mold, make sure to give it several good coats of separator. If spraying, make sure to spray in every direction. Then you only need to treat it once or twice before subsequent firings.
- Allow the separator to dry fully before adding frit, and be careful to not disturb it with tools or fingers.
- If the glass does not come out easily when your project has finished fusing and has cooled fully, invert the mold onto a soft surface and thump it on the back. The glass should pop out safely.
- If your mold has a post, it has a few extra things to keep in mind. [Please follow this link for more information.](#)
- If your glass sticks, it may mean your kiln could be firing too hot and your separator is failing, or you haven't applied enough separator or removed some during the process of adding glass.
- Make sure you know your kiln before using any suggested firing schedule, and feel free to edit suggested schedules as necessary for your kiln's quirks. For example, if your kiln fires hot, you may need to remove heat from the top temperature.
- A great way to learn about your kiln is to fire test tiles. [Please follow this link for more information.](#)

Suggested Full Fuse			
Segment	Rate	Temperature (°F)	Hold
1	300	1150	45
2	150	1300	20
3	400	1460	10
4	9999	950*	60

Suggested Tack Fire			
Segment	Rate	Temperature (°F)	Hold
1	300	1150	45
2	150	1300	20
3	400	1410	10
4	9999	950*	60

* If using COE90 Glass, change this temperature to 900°