

BASIC SLUMPING

Creative Paradise Inc.

This general guide will walk you through some of the basics of using slump molds. Slumping molds come in a wide variety of shapes and sizes, and some do have particular usage requirements, but this tutorial will cover the basics of usage applicable to most.

To view our entire line of slumping molds, [refer to their category on our website here.](#)



Example piece from [GM263 Hi-Lo Bowl](#)

WHAT IS SLUMPING?

"Slumping" as a term is generally used to refer to the act of firing fusible glass so that it stretches and conforms into the shape of a concave mold like a bowl or dish.

Some slump molds have raised parts, like the [GMI91 Large S-Curve](#), but for our purposes we consider any mold where the majority of the glass will be conforming to a concave shape to be a slumping mold.

PREPARING THE MOLD:

We do recommend ZYP Boron Nitride as the separator best for all our molds. However, kiln wash and other water-based separators can work as well, especially for simpler slumping molds.



Still image from ZYP Application video

ZYP does now come in a brushable liquid form, though we still prefer the spray-on version. To apply spray-on separator, shake the can well before use and hold upright during application to ensure proper distribution. Wear respiratory protection during application. Several light coats with a short wait between each coat are preferable to a single heavy coat. Turn the mold as you spray to coat the mold cavity at all angles. For a video tutorial on this, [please click here.](#)

If using a brushable liquid separator, apply multiple coats in multiple directions, making sure to allow each coat to dry fully before applying the next.

SIZING THE GLASS:

Due to the mold casting process there is a small amount of variation possible between individual molds. For the size of glass most accurately sized to your specific mold, the general rule of thumb we adhere to is to trace around the base of the mold onto a piece of paper, then use the traced line as a pattern to cut the glass. Our own patterns, such as the one used in [the tutorial for the Chevron Spoon Rest](#) shown to the right, are often made in this same manner.

Tracing to create a pattern will give you the **largest** size of glass that can be comfortably slumped on that particular mold. With slumping, however, it's good to note that you can always slump a piece smaller than the mold. If slumping a smaller piece into a larger mold, keep in mind how the glass is placed onto the mold before firing if you want the final piece to sit flat, and make sure it's centered over the flat part of the mold (if applicable).



GMI91 Large S-Curve

[Example tutorial link here](#)



GMI27 Modern Spoon Rest

[Example tutorial link here](#)



[GM257 Square Cyclone Slump](#)
[Example tutorial link here](#)

ONE LAYER OR TWO?

Slumping molds can be used with a single or double layer of glass, though a double layer is recommended for stability and ease of use.

The temperatures of a standard slumping schedule are not high enough to fuse glass together, so any additional layers or decorations must be pre-fused before slumping, unless following what we tend to call a "One-and-Done" schedule, which combines some form of fusing schedule with a slumping schedule. For an example of one such schedule, [refer to our "Flame Slurry" tutorial for the GM257 Cyclone here.](#)

FIRING:

The general top temperature range for slumping is between 1230-1300°F. Where your particular project will sit within that range depends on the size of the piece, the depth and complexity of the mold, and, most importantly, your specific kiln. The most important component of any firing schedule is the kiln, so it's vital to know yours well. For suggestions and information on getting to know your kiln, [refer to our Important Firing Notes here.](#)

Most all our molds have suggested firing schedules visible on their listing on our website. It is important to note these are suggested, **and should be adjusted to best accommodate your kiln and specific project.**

We have two types of basic slumping schedule that work well as starting points to adjust from: a basic slump and a hard slump. The basic slump is a good choice for shallower, simpler molds like the [GM04 Round Slump](#) while the hard slump is a better pick for deeper or more complex molds such as the [GM254 Fluted Shelf Ring](#). Find these schedules below in **Table 1** and **Table 2**.

TABLE 1: BASIC SLUMP *

Seg.	Rate	Temp (°F)	Hold
1	300	1260	20
2	9999	950**	60

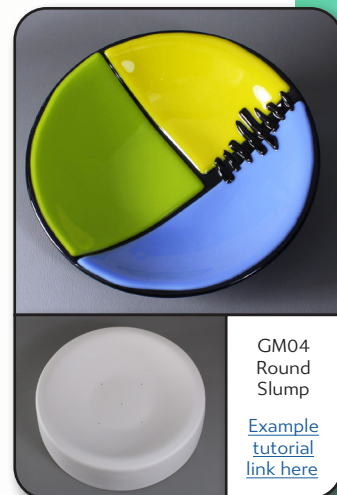
**If using COE90, adjust this to 900°F

TABLE 2: HARD SLUMP *

Seg.	Rate	Temp (°F)	Hold
1	275	1215	30
2	50	1280	20
3	9999	950*	60

**If using COE90, adjust this to 900°F

* As stated above, it's crucial to know your kiln to see if you need to adjust these suggested schedules for your use. [Please click here for our Important Firing Notes](#) for more information.



GM04 Round Slump
[Example tutorial link here](#)



GM254 Large Fluted Shelf Ring
[Example tutorial link here](#)