

Prepare the mold by applying a glass separator to the mold and drying it.

Use a standard hole puncher (paper puncher) to punch 5 disks from 1/8" fiber paper. Use the nichrome post provided with the mold and skewer 5 of the disks with the post puncturing each disk in the center. Scoot the fiber paper disks to one end of the nichrome post without squashing them out of shape.



Gently, wrap a 1/2" x 1.25" piece of Thin Fire paper around the fiber paper disks on the nichrome post. Use a tiny piece of masking tape to keep the paper tight around the disks. Do not squeeze the disks out of shape by pulling the paper too tight or gripping the disks too tightly. This Thin Fire paper prevents the melting glass from seeping in between each fiber paper disk during firing.

Place the exposed wire end of the nichrome post into the hole (at the center of the cavity in the base of the knob cavity) in the mold. Adjust the wire and wrapped fiber paper disks to make sure that the wire and disks are centered and resting on the lower cavity of the mold. Also make sure that the disks and paper are at the top of the upright portion of the nichrome posts and no large portion of the post is sticking above the fiber paper disks. \* (see note below for alternative methods of making the fiber posts) Begin to fill the mold with frit. It is recommended to use medium grain frit to fill the lower portion of the cavity. Continue to fill the mold cavity with frit, pieces of dichroic, stringers, rod pieces or any other compatible pieces of fusible glass.

Before firing the glass, take a toothpick or other suitable tool and sweep the frit to the center of the mold. creating a mound of frit in the center of the mold cavity will help eliminate glass burrs. The glass will roll down as it melts and create a nice smooth edge where the glass meets the mold. If the glass is level in the cavity or if large pieces of glass are resting on the edge of the mold cavity before firing, sharp edges may be created during firing.

Place the mold filled with glass in the center of a kiln and fire using the following firing schedule:

- Rate 1 = 250 Temp 1 = 1360 degrees F Hold 1 = 20 minutes
- Rate 2 = 200 Temp 2 = 1470 degrees F Hold 2 = 15 Minutes
- Rate 3 = 9999 Temp 3 = 950 degrees F Hold 3 = 1 hour
- Rate 4 = 100 Temp 4 = 815 degrees F Hold 4 = 5 minutes

After the kiln has cooled naturally, invert the mold to demold the glass knobs

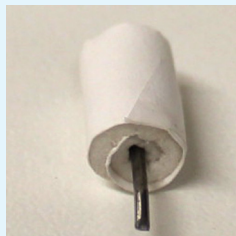
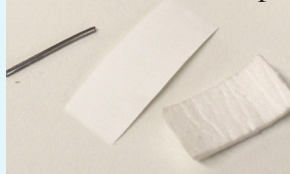
Remove the nichrome posts and fiber paper from the channel in the glass. Wash knobs with soapy water to remove all glass separator and fiber paper.

Insert the threaded anchor into the cavity to test for clearance. The threaded anchor should fit easily into the cavity. If the threaded anchor doesn't fit easily, it may be necessary to use a dremel tool and a diamond crusted bit to clear any obstructions. Place a dab of E600 glue on the end of the threaded anchor and insert the threaded anchor into the cavity. Allow the glue to dry and thread screw.



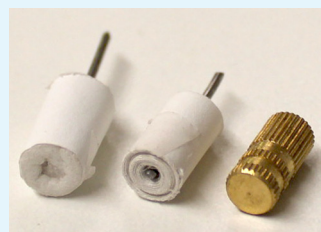
\* In response to customers asking for an easier method for making the fiber posts we would like to share the following alternatives:

**Roll Fiber Paper**

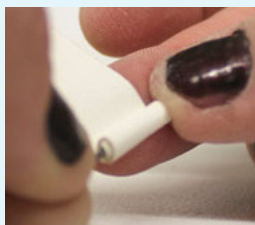
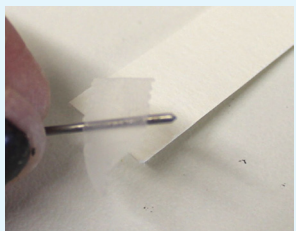


1/8" thick fiber paper cut 1/2" x 1", kiln shelf paper cut 1/2" x 1.25" rolled tightly and held together with a small piece of scotch tape.

Insert post. Proceed using directions above.



**Roll Kiln Shelf Paper**



Cut a 1/2" x 10" strip of Papyrus or a 1/2" x 12" strip of Thin Fire. Place a small piece of scotch tape on post. Tape post to very end of kiln shelf paper with tape on both sides of paper. Wind kiln shelf paper around post firmly. Place a small piece of tape on the end to secure. Proceed using directions above.

Make sure that the fiber paper posts are just slightly larger in diameter than the brass anchor (1/4") before inserting into mold.

