



Large Bowl or Sink Project

Items you will need for Bowl creation:

20" Casting Ring
 Large Fiber Strip
 Fiberfrax Duraboard 22" sq.
 Boron Nitride Spray
 Stainless Steel Round Bowl
 Desired Glass (Glass Blanks or Frit)
 Grinder or Diamond Glass Sanding Block
 Glass Cutting Tools (if needed)

Additional materials for Sink creation:

Durablanket (optional)
 2 in. Diamond Drill Bit
 2 in. Drain Hardware
 Drill

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Glass Bowl



Step 1-Getting Ready!

Collect your Casting Ring, Fiberstrip and Fiberfrax Duraboard. Center your Casting Ring on the Fiberfrax Duraboard and place the Fiberstrip within the inside walls of the Casting Ring. This fiber strip will keep the glass from sticking to the mold.



Step 2-Setting the Frame

Place either one 20" dia. clear glass black within your casting ring or, you may use glass peices to fill the bottom layer of your casting ring. Clean glass or glass blanks are recommended for a clean design. Remember cut glass circles smaller than your casting ring to insure they will fit inside the casting ring.



Step 3-Start Your Design.

When you fuse within your Casting Ring the shiny side of the glass will be on the top. You will want to slump shiny side down to ensure both sides of your bowl are fire polished. So design within your casting ring for the bottom facing the Fiberfrax Duraboard will become the inside of your bowl.

Also, think about how you want to present your piece; above the countertop or below, and will you be wanting a rim to your sink? Design accordingly.



Note: Smaller pieces of glass will create more empty spaces in which air may be captured; this may create bubbles to appear within your design. Use glass blanks or large pieces of glass if avoiding bubbles.

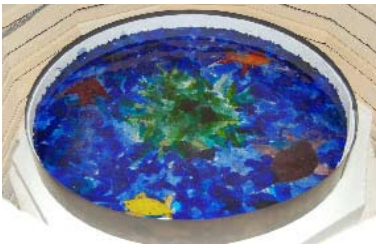
With your casting ring you may build your glass up to the top of your fiber strip creating a very thick border to your piece. Remember to adjust your firing schedule according.



Step 4-Finish Design

After you have finished your design. If you'd like you may add an additional layer of clear glass this will help protect your glass and add a professional finish. When all is complete carry your project into the kiln to fuse. See Page 3 for 20" Casting Ring Full Fuse Firing Schedule Guide.

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Step 5-Fused Sink

Congratulations! You have just completed the first part of your project. Now it's time to clean things up. Wear a dust mask and remove your fused glass piece from its Casting Ring and Fiber Strip. Wash with warm water.



Step 6-Tighten

Remove sharp edges from your borders and smooth with grinder or diamond pad. To make your piece as professional as possible you may want to use a grinder to smooth your glass. You can use a hand held grinder or a stationary machine to work your magic. Smooth edges and face to your liking.



Step 7-Prime

Prime your Stainless Steel Mold by spraying Boron Nitride Spray. Apply three or four light coats. Follow directions for application, safety, and handling. With applying coats it is okay to see the grey of the steel; a light coat will allow the Round Bowl's curvy design to become more apparent onto your slumped glass project.



Step 8-Slump It!

When your Glass is smooth and clean, or edgy and organic to your liking your ready to slump! Place your Fiberfrax Duraboard and Primed Stainless Steel Round Bowl into the kiln. If wanting a more curvy bottom for better drainage add thick fiber paper to create an hump. Place your glass shiny side down and center. Take a ruler under glass rim and circle to insure centered. Follow Slumping Firing Guide on Page 3.



Step 9-Pretty Bowl!

Check out your bowl! Wash with warm water and clean with Hotline Wash Away to remove primer. If you choose to slump a rim additional grinding and polishing maybe needed; you may want to fir polish as well. Otherwise enjoy!

For drilling a drain continue...



Step 10-Drill a Drain

Mark your center and where you will drill. Fill your glass bowl with the equivalent of your glass thickness or more of warm water. Take your Drill and 2" Drill Bit and drill your drain hole. Place in your hardware and your ready to install.

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Send your Feedback

Let us know how you liked this month's "Featured Project." Email amanda@slumpys.com with all feedback and creative suggestions!

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Share and compare your own work with other's in our Art Glass Gallery. View the Gallery at: www.slumpys.com/SlumpysStore/ArtGlassGallery.aspx. Email your submissions to amanda@slumpys.com, please include your name/company, location, and website!

Check back NEXT MONTH

Every month we'll feature a new special project complete with what you will need and detailed instructions on how to make your own glass creation!

Below are several firing schedules that can be used as a guide for the full fuse and slump of Slumpy's August 2007 Feature Project Glass Sink. These schedules are based around using an Olympic Kiln, 96 COE Glass, and a 20 x 20 inch glass project. Different schedules are listed for desired thickness of casting ring.

Full Fuse

3 Sheets .375" Thick	Segments	1	2	3	4	5	6
	Rate (F/Hr)	400	50	850	9999	50	400
	Temp.	1000	1200	1425	950	815	200
	Hold Time	20	25	25	60	5	0

4 Sheets .5" Thick	Segments	1	2	3	4	5	6	7
	Rate (F/Hr)	200	200	50	450	9999	25	200
	Temp.	500	1000	1200	1425	950	815	200
	Hold Time	40	40	35	50	120	10	0

5-6 Sheets .625"-.75" Thick	Segments	1	2	3	4	5	6	7
	Rate (F/Hr)	200	200	50	450	9999	25	200
	Temp.	500	1000	1200	1425	950	815	200
	Hold Time	40	40	45	50	120	10	0

7-8 Sheets .875"-1" Thick	Segments	1	2	3	4	5	6	7
	Rate (F/Hr)	200	200	50	450	9999	25	200
	Temp.	500	1000	1200	1425	950	815	200
	Hold Time	40	40	60	50	120	10	0

For projects that are thicker than 1 inch add additional hold time to Segment 3, add 5 minutes per sheet or .125" thickness.

Slump

3 Sheets .375" Thick	Segments	1	2	3	4	5	6
	Rate (F/Hr)	400	50	850	9999	50	400
	Temp.	1000	1200	1350	950	815	200
	Hold Time	20	25	15	60	5	0

4 Sheets .5" Thick	Segments	1	2	3	4	5	6	7
	Rate (F/Hr)	200	200	50	450	9999	25	200
	Temp.	500	1000	1200	1350	950	815	200
	Hold Time	40	40	35	30	120	10	0

5 Sheets .625" Thick	Segments	1	2	3	4	5	6	7
	Rate (F/Hr)	200	200	50	450	9999	25	200
	Temp.	500	1000	1200	1350	950	815	200
	Hold Time	40	40	45	50	120	10	0

6 Sheets .75" Thick	Segments	1	2	3	4	5	6	7
	Rate (F/Hr)	200	200	50	450	9999	25	200
	Temp.	500	1000	1200	1350	950	815	200
	Hold Time	40	40	50	50	120	10	0

7-8 Sheets .875"-1" Thick	Segments	1	2	3	4	5	6	7
	Rate (F/Hr)	200	200	50	450	9999	25	200
	Temp.	500	1000	1200	1350	950	815	200
	Hold Time	40	40	60	50	120	10	0

For projects that are thicker than 1 inch add additional hold time to Segment 3, add 5 minutes per sheet or .125 thickness. If wanting a rim to slump add 10, 15, or 20 additional minutes to Segment 3. Keep a watchful eye during additional rim slump time in case of run off.

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