



Slumpy's glass slumping and fusing molds are produced using high quality clay materials and industry process standards. Our molds are made with great care placed on quality control and creating the best slump mold possible. Below are instructions on caring for Slumpy's molds. Please read the following to provide the longest life for your mold.

Slumpy's Ceramic Mold Care Instructions

Initial Check —

Upon receipt of your mold, check for any possible damage that may have occurred during shipment. Our molds are very durable, but shipping can potentially result in chipping or cracking. If your mold is damaged during shipping, **notify Slumpy's within 5 days of delivery.**

Some Slumpy's molds have a product sticker on the mold. Carefully remove this sticker from the mold prior to firing. If sticker is left on during firing it may leave a residue or colored spot.

In Use —

If debris is present on the mold it will adhere to glass during fusing or slumping. **Clean the mold** by blowing off debris, or wiping the surface of mold with water.

Primer should be applied to the mold before slumping glass into the form. Apply 3-4 coats of primer evenly over the surface of the mold, including the lip and any portion of the mold that may come in contact with hot glass. Slumpy's provides several types of mold primer. Be sure to carefully follow all manufacturer's instructions for applying, drying, and curing the primer prior to slumping or fusing.

Before firing **make sure base of mold is not in contact with residual glass** on kiln shelf. If the base contacts glass during firing, the mold may fuse to the shelf and damage the mold and/or shelf. Also **check for a uneven shelf surface.** Uneven distribution may cause tension within the mold and may weaken or cause the mold to break while in storage or during firing.

The kiln wash needs to be completely dry before you slump glass into the mold!

Avoid thermal shock caused by subjecting mold to drastic changes in temperature over short periods of time. Avoid raising temperature of molds from ambient conditions to hot kiln environment too quickly. When cooling, ramp the temperature of the kiln slowly to avoid abrupt changes in the temperature of the mold body, which could cause the mold to crack. **It is recommended a ramp up of no more than 400°F (204°C) and for a ramp for cooling it is best to avoid leaving the kiln open to cool it down, especially with double sided molds such as the Belmont Series. To be safe, Slumpy's recommends not opening the kiln prior to 100°F (37°C).**

Avoid excessive loading and pressure points on the molds. These conditions may cause molds to fracture.

Storage —

Store molds with care to prevent damage. **Store in a dry place. Avoid stacking molds.** Possible damage to mold and/or degradation to primer layers may occur. If stacking molds is necessary, take care to prevent possible damages by use of a barrier between molds. Always allow mold to cool before storing.

Other Specifics —

Clay slumping molds can fire to 2000 °F (1100 °C). If mold cracks or chips, it may be possible to repair some damages. Use Slumpy's Magic Mender to repair minor fractures. Product and instructions are available on www.slumpys.com








Slumpy's Firing Guide

Slumpy's would like to recommend a firing schedule to prolong the life of your Slumpy's Molds. Below are instructions for firing your 12" dia. or less Slumpy's mold and 12" dia. x 3/8" 96 COE glass. **Please prepare to adjust the firing program as needed for your specific kiln, size of project, and type of glass.**

Process	Description	Temp °F	Cone
Full Fusing Kiln Casting	With using heat and time, merging two or more layers of glass in in of any size or shape to form one solid smooth piece.	1450-1550	014
Contour Fusing	Using a lower temperature than a Full Fuse; to conjoin layers of glass enough so that the individual characteristics of the glass pieces remain and are smooth at the edges.	1380-1440	016
Tack Fusing	Using a lower temperature than a Contour Fuse; to conjoin layers of glass enough so that the individual characteristics of the glass piece remain somewhat intact.	1350-1370	017
Fire Polishing	Heating glass enough to heat the glass surface; creating rounded edges and providing a shiny appearance.	1300-1400	017
Slumping	Conforming glass to a shape by either sinking into a mold with heat, gravity, and time.	1200-1300	019
Draping	Conforming glass to a shape by bending it over the backside of a mold with heat, gravity, and time. In most cases the mold is stainless steel because of its coefficient of expansion with glass.	1140-1240	020

Slumpy's Firing Schedule:

These schedules focus on a slow ramp up and ramp down. The life mold is prolonged by gradual changes in temperature. This schedule will also protect your glass from bubbles and devertification. Please refrain from opening your kiln until the temperature is below 100 °F

Full Fuse	Segment	1	2	3	4	5	6	
	Rate (F/HR)	300	200	400	9999*	150	300	
	Temp (°F)	1150	1370	1480	950	800	100	
	Hold Time (Hr.Min)	00.30	00.20	00.20	00.60	00.10	00.00	
Contour Fuse	Segment	1	2	3	4	5	6	
	Rate (F/HR)	300	200	400	9999*	150	300	
	Temp (°F)	1150	1370	1440	950	800	100	
	Hold Time (Hr.Min)	00.30	00.20	00.20	00.60	00.10	00.00	
Tack Fuse	Segment	1	2	3	4	5		
	Rate (F/HR)	300	200	9999*	150	300		
	Temp (°F)	1150	1325-1370	950	800	100		
	Hold Time (Hr.Min)	00.30	00.20	00.60	00.10	00.00		
Slump	Segment	1	2	3	4	5	6	
	Rate (F/HR)	150	300	150	400	150	300	
	Temp (°F)	300	1100	1240	950	800	100	
	Hold Time (Hr.Min)	00.15	00.20	00.15	00.60	00.10	00.00	
Drape <small>Recommended for Drape Molds & Stainless Molds</small>	Segment	1	2	3	4	5	6	
	Rate (F/HR)	150	300	150	400	150	300	
	Temp (°F)	300	1100	1200	950	800	100	
	Hold Time (Hr.Min)	00.15	00.20	00.15	00.60	00.10	00.00	

*Means as fast as possible
12/2/2011 REV