



Small Dragonflies

The Small Dragonflies with Wing Slumper mold has been one of the most popular designs. Why not devote a project sheet just to making, shaping, and tacking these designs.

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Start by cleaning the dragonfly mold with a stiff nylon brush and remove any old kiln wash. Then coat the mold with four to five thin, even coats of Hotline Primo Primer. It is the only primer we recommend because it doesn't obscure the mold's fine detail and is easy to remove after firing. Use a soft artist's brush to apply the primer and a hair dryer to completely dry each coat before applying the next. The mold should be completely dry before filling.

To keep the dragonflies delicate, use only 30 grams of frit for the large dragonfly and 20 grams of frit for the small dragonfly. (This is less than the fill weight listed on the mold's packaging.) Additionally, the molds will be fired cooler than the general instructions. Weigh the mold and note its weight. The filled mold will weigh 50 grams more.

Highlight the dragonflies' wing and body details by sprinkling just enough fine Black frit into each cavity to fill the wing veining and the head and body. Gently tap the mold to cause the frit to settle into place. Sprinkle a dark, fine frit (Pale Purple, Dark Blue, or Dark Green) into the head and down the body's length. "Feather" a little of the dark, fine frit out the dragonfly's wings. Place the mold on the scale and fill the wings with a light, fine frit (Clear, Neon Orchid, Urobium Pink, or Ming Green) until the scale reads 50 grams more than the mold's empty weight. The mold's cavities will only be about one-half full.

Gently tap the mold to level the surface. Place the mold or molds in the kiln and fire according to the following schedule:

COE 96* Casting Schedule

- Seg 1 300°F/hour to 1350-1375°F (720°C), Hold 10 minutes
- Seg 2 AFAP to 960°F (515°C) no venting. Hold 30 minutes
- Seg 3 Off, cool kiln, don't vent

* Increase 25°F (15°C) for COE 90



Shaping the Dragonflies

On the mold's reverse side is a wing slumper. A slump firing on this surface slightly bends the wings up and gives the dragonflies a much more lifelike appearance. Start by preparing the reverse side of the mold in the same way the casting surface was prepared.

Place the dragonflies, textured detail side up on the slumper. Align

Tools

- ✓ Small Dragonflies w/ Wing Slumper mold
- ✓ Soft artist's brush
- ✓ Digital scale

Supplies

- ✓ Hotline Primo Primer
- ✓ Fine frits (see text for suggestions)
- ✓ Kiln paper



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Technical sheet courtesy of Colour de Verre™

the dragonfly bodies with the crease in the slumping surface.



Fire the molds using the schedule below:

Slumping Schedule

- Seg 1 300°F/hour to 1225-1250°F, Hold 5 minutes
- Seg 2 AFAP (As Fast As Possible) to 960°F no venting. Hold 30 minutes
- Seg 3 Off, cool kiln, no venting

* Increase 25°F (15°C) for COE 90

Adding to Other Pieces

The dragonflies can also be added to plates, platters, and other larger works. To tack fire the dragonflies to the larger pieces, use the schedule below:

COE 96* Tack Schedule

- Seg 1 200°F (110°C)/hour to 1250-1275°F (675-690°C), Hold 5-10 minutes
- Seg 2 AFAP to 960°F (515°C), Hold 90 Minutes
- Seg 3 50°F (30°C)/hour to 800°F (425°C)
- Seg 4 100°F (60°C)/hour to 600°F (315°C), Off, No Venting
- * Increase 25°F (15°C) for COE 90

If you wish to tack fire dragonflies that have been shaped, you will need to support the wings during the tack firing. Use a small dab of white glue on the dragonflies' body to hold the loose pieces in place. Tuck small squares of kiln paper under the wings to support them during the firing.

Variations

Experiment with adding small, dichroic glass shards to the wings. Encase the shards between thin layers of fine frit to ensure a smooth surface.