



C105 Circle Foot Casting Mold



F500 Stackable Fusing Foot Rings

The Graffiti Bowl shown below was created on an M35 Starfire Drape Mold manufactured by Wardell Products. The bowl was draped and the foot was attached during the same firing. Use this **C105 Circle Foot Casting Mold** to create a 3 1/4" (83 mm) diameter cast glass disk then use the **F500 Stackable Fusing Foot Rings** (one set included with this mold) to shape the foot and fuse it to a bowl during a standard drape-form firing schedule.



Visit: www.joyoffusing.com to download this eProject for FREE, with complete instructions and a video showing the entire process.



Make scrap glass shards using mosaic nippers



Prepare the C105 using mold release



Use a digital scale to fill the casting mold



Place the filled casting molds in the kiln

C105 Circle Foot Casting Mold

To add a stemmed foot to a draped bowl, you'll need a 3 1/4" (85mm) x 1/4" (6mm) glass disk and the easiest way to get one is to cast it in a C105 Foot Casting Mold using our 'Scrap Casting' technique. Use mosaic nippers and a catcher box to break left-over scrap glass pieces into shards approximately 1/4" to 3/4" (65 to 20mm).

Prepare the mold by coating it with a mold release. We recommend either Primo Primer or MR-97. Be sure to follow the manufacturers directions when applying these products to your mold.

Place your prepared C105 Foot Casting Mold on a digital scale and zero the tare weight. Then place your glass shards in the mold, allowing them to pile up in the center as much as possible. This will help to reduce the formation of edge spikes. Fill the C105 mold with 3.5 ounces (100 grams) of glass shards. You can use all clear glass or all one color to match your bowl design. Or you could mix clear with cathedral colors or opal combos to get an interesting stippled color effect.

Place the glass-shard filled mold(s) into your kiln then set the kiln controller to fire the SCS - Scrap Casting Schedule on the next page.

SCS - Scrap Casting Schedule

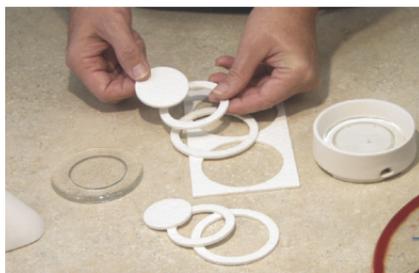
Segment	#	Degree/Hour	Target Temp	Hold Minutes
Primary Heat	1	300°F - 165°C	1250°F - 675°C	30
Intention Heat	2	300°F - 165°C	1430°F - 777°C	30
Drop to Anneal	3	Full/AFAP	950°F - 510°C	60
Slow Cool	4	100°F - 53°C	600°F - 315°C	0
Power Off	5	Kiln Off	Room Temp	~

F500 Stackable Fusing Foot Rings

Now we'll create the tapered Foot Ring cone assembly using one set of F500 Stackable Fusing Foot Rings. Carefully remove the precut rings from the fiber rectangle. Place the largest ring on your bench, smooth side down and apply 4 drops of craft glue towards the inside edge. Then center the 2nd largest ring on top and press it into the glue. Apply some glue to this 2nd ring and place the next smaller ring on top. Then glue the 4th and final ring to the top to create a 4-step tapered cone. Allow the glue time to dry.

Measure and mark the center of your 'Bowl Design' fused blank using a Sharpie marker (the ink will burn off during firing). Then place a prepared drape mold into your kiln, such as an M35 Starfire mold then center your bowl blank on the mold.

Now position the Foot Ring cone assembly over the X, with the smallest ring down, to create



Pop the precut fiber rings out of the jacket



Create the tapered cone foot ring assembly



Assemble all components on the drape mold

a funnel shape. Finally center the cast glass foot disk, recessed side facing up, on top of the tapered fiber cone. Check to ensure everything is centered then gently close the kiln.

Program your kiln controller to fire the FFS - Foot & Forming Schedule shown on the next page.

FFS - Foot & Forming Schedule

Segment	#	Degree/Hour	Target Temp	Hold Minutes
Primary Heat	1	150°F - 80°C	500°F - 260°C	20
Intention Heat	2	350°F - 190°C	1230°F - 665°C	10
Drop to Anneal	3	Full/AFAP	950°F - 510°C	60
Slow Cool	4	125°F - 65°C	650°F - 345°C	0
Power Off	5	Kiln Off	Room Temp	~

Fire When Ready

The extra slow initial ramp speed is **ABSOLUTELY ESSENTIAL** to prevent setting up a thermal shock incident that will shatter your prefused glass design disk. A little less speed and a little more patience will be rewarded.



Lift the bowl from the mold



The fiber collar around the foot after firing



Use a craft knife to cut the fiber collar



Spread the fiber sections until they drop off

After the drape firing is complete and the kiln has cooled, open the kiln to admire your masterpiece. Separate the bowl from the mold by prying up gently on the rim of the bowl, then straight up off the mold.

Use a craft knife (i.e. X-Acto), to remove the tapered cone assembly. Slice through the soft fiber cone from the top to the bottom then use the knife blade to spread the sections apart until the whole assembly falls off onto the bench.

The final step is to clean your new Footed Bowl using a soft cloth and dish soap under running water.

Visit: www.joyoffusing.com to download this eProject for FREE, with complete instructions and a video showing the entire process.