

Koi Fountain Bowl

Prepare your mold thoroughly with glass separator before beginning. We recommend using spray-on ZYP and applying from multiple angles.

Make sure to always wear a mask when using spray-on separator and/or powder frits.

Material/:

- [DT29 Round Koi Wave Texture](#)
- [GM134 Large Round Slump](#)
- Fusible Compatible Glass (See Right for Suggestions)
- Suitable Glass Separator/ZYP
- Frit Placement Tools
- Kiln Posts
- Bamboo Fountain Pump Kit

Suggested Glass:

(All COE96):

- F1 Powder Black Frit
- F2 Fine Frits:
 - Marigold
 - Yellow Opal
 - Red Opal
 - Flame Opal
 - Orange Opal
 - Amber Transparent
 - White
 - Black
- Double Thick Clear Sheet Glass



Once your separator has had ample time to dry, begin by applying F1 Black to fill in the details of the koi. This includes the fins, tails, eyes, lips, and whiskers. You can use your finger to gently move powder frit around the mold but be careful to not overly disturb the separator. Since the powder is so fine it can easily fall outside the intended area. Use a clean finger or brush to gently sweep it back into place.



If you work with a lot of frit, it may be worth purchasing a small Earwax Vacuum. They're available at many drugstores and online retailers, and they work great for precise removal of unwanted frit. Try not to overwork the mold in your cleaning efforts as you do risk removing glass separator and creating areas of stickage.



The frit colors listed in the Materials portion are all suggestions. As long as all your glass is fusible and compatible, you can choose any colors you'd like! For filling the koi, we suggest "Fine" grain frits in shades of red, yellow, and orange, as well as white and black to fill in bodies and heads. Generally, opal frits are best, though transparent ones such as the Amber used here can work well when backed with another opal color.

To create primarily white or black koi, add fine red, orange, or yellow in the desired pattern then back it with fine white or black. Koi come in a huge variety of colors- experiment with your frit placement! Each koi should be filled to the top of the cavity. Mound your frit towards the center of each koi to just a bit above the cavity walls to help them fill completely. The sheet glass should touch these mounds when placed on the mold.



A fully-filled koi



For best results, either place two standard thickness/single layer 12.75" circles or one double thick 12.75" circle over the frit. This example uses Clear, but any compatible color could be used. Place the project on 1" kiln posts on a level shelf in the kiln with most of each kiln post placed outside the mold to avoid hot spots. Full Fuse using the suggested schedule in **Table 1** or your own preferred Full Fuse with a bubble squeeze.

Slumping:

To slump your fused koi texture, first prepare your desired slump well with separator. The [GM134 Large Round Slump](#) was used here. Place the treated mold on a kiln shelf, and make sure both the mold and shelf are level. If you find your mold is off-kilter, small folded sheets of fiber paper under the mold can help balance it out. Once level, center your fused texture with the texture side facing up on the mold and Slump using the suggested schedule in **Table 2** or your own preferred Slumping schedule.

Segment	Rate	Temp (°F)	Hold
1	200	1215	45
2	50	1250	30
3	250	1330	10
4	300	1465	10
5	9999	950**	90
6	100	500	05

**If using COE90, adjust this to 900°F

Segment	Rate	Temp (°F)	Hold
1	250	1215	60
2	275	1250	05
3	9999	950**	90
4	100	825	05
5	100	500	00

**If using COE90, adjust this to 900°F

*Before firing, it's important to know your kiln to see if you need to adjust our suggested schedules for your use. For tips on how to do that, [please click here to see our Important Firing Notes!](#)

Assembling the fountain:

A fountain kit is available from Bamboo Accents that includes a three arm 12" bamboo span and spout with submersible pump and tubing. Cut 5" of the tube and attach to the bottom of the spout and pump. Lay the pump in the center of the bowl. The pump can lay on its side and operate without an issue. Place the three arm span across the bowl resting on the edges of the glass. Add river rocks or glass pebbles around and over the pump to disguise it, then add enough water to cover the pump with a minimum of 1/2" of water. Plug the pump in and enjoy your serene new koi fountain!

