

# KOI POND

**MATERIALS:**

- LF146 Koi Fish
- GM132 XL Sushi
- COE96 Glass (See Right for Frit):
  - Sheets:
  - Uroboros Ming Green
  - Uroboros "Uncat" Off-White with Green Streaky\*
  - If above unavailable, White with Fern Streaky
- Confetti Pieces:
- White Opal
- Forest Green
- Yellow Green
- Suitable Glass Separator/ZYP
- Frit Placement and Glass Cutting Tools

- F1 Powder Black Frit
- F2 Fine Frits:
- Black
- Red Opal
- Marigold
- Yellow Opal
- Medium Amber
- White
- F3 Medium Clear Frit

\*Many distributors will have an array of "uncat" glass on hand. Uncat glass from Uroboros is made by the glass makers in limited runs and is never the same twice.



**Before beginning, make sure to treat your molds thoroughly with separator.** If using spray-on separator and/or powder frits, make sure to wear a mask!



Place F1 Black in the lowest portions of each fish, including the fins, eyes, and mouth. Use a small brush or your finger to gently sweep any stray frit back to its proper place but be careful to not disturb your separator.



Place F2 Black over the F1 Black in the side and tail fins until each fin is about 1/8" full. Scatter a bit of F2 Red Opal here and there in the koi bodies for patterning.



Scatter some F2 Marigold and F2 Yellow Opal similarly to the Red Opal in the previous step. Place a bit of F2 Medium Amber over the dorsal fins and bodies of each fish.



Fill the koi bodies with F2 White until they're each roughly 1/8" full.



Back everything with F3 Clear. If using fill weights, each koi should hold roughly 33g each for a total fill weight of 99 grams. Fire to a Full Fuse using the suggested schedule in **Table 1** on **Page 2** or your own favorite Full Fuse with a bubble squeeze.



Once cooled, remove the fish from the mold. Use running water and a stiff brush to remove any separator residue.



Cut the shape from **Pattern 1** found on **Page 3** out of the Ming Green sheet glass. Cut the shape from **Pattern 2** from the Off White/Green Streaky Uncat sheet (or the White/Green Streaky if using that instead). Clean each piece well and place the Ming Green oval in the center of the slightly larger Streaky Oval.



Arrange the koi on the ovals of sheet glass as desired. Use pieces of Yellow Green confetti to create areas of pond flora and accent them with smaller pieces of White Opal and Forest Green confetti.



Place the project on a piece of kiln shelf paper and Tack Fire using the suggested schedule found in **Table 2** on **Page 2** or your own preferred Tack Fire.



Once the project has cooled, center it on the GM132 XL Sushi as shown above and Slump using the suggested schedule in **Table 3** below or your own favorite gentle Slump.



The final, fully fused pond! If you need inspiration, try looking at pictures of different varieties of koi. They come in many more colors and patterns than the ones we chose to portray here.

<b>Table 1: Frit Cast Full Fuse Schedule*</b>			
Segment	Rate	Temp	Hold
1	275	1215	30
2	50	1250	20
3	300	1465	05
4	9999	950**	60

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

<b>Table 2: Tack Fire Schedule*</b>			
Segment	Rate	Temp	Hold
1	275	750	15
2	250	1215	60
3	50	1250	30
4	275	1405	05
5	9999	950**	90
6	100	600	05

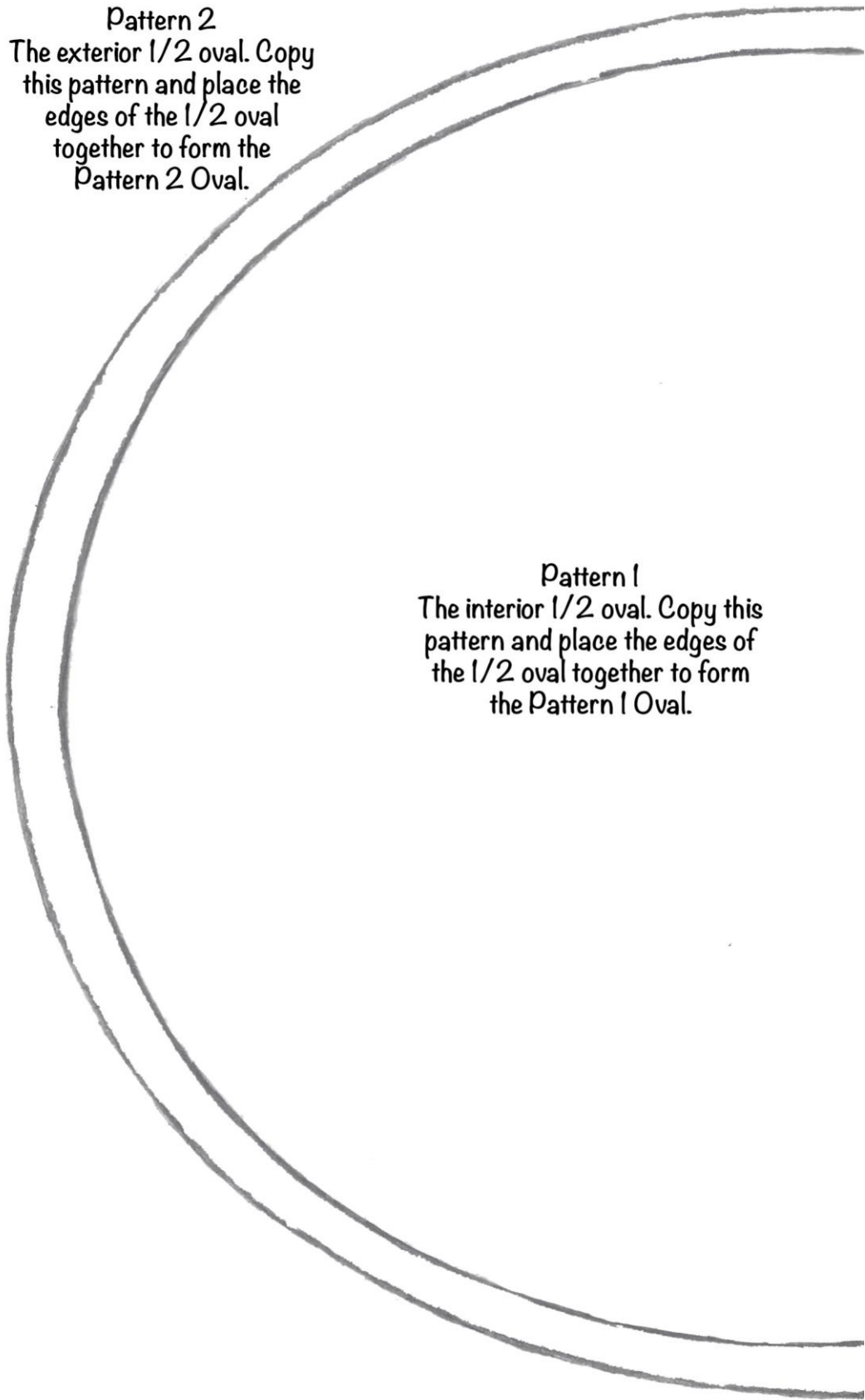
\*\*If using COE90, adjust this to 900°F

<b>Table 3 Slump Schedule*</b>			
Segment	Rate	Temp	Hold
1	200	600	10
2	250	1220	30
3	9999	950**	90
4	100	600	05

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

\*Before firing [click here for our Important Firing Notes](#) on getting to know your kiln to see if you need to adjust our schedules!

Pattern 2  
The exterior 1/2 oval. Copy  
this pattern and place the  
edges of the 1/2 oval  
together to form the  
Pattern 2 Oval.



Pattern 1  
The interior 1/2 oval. Copy this  
pattern and place the edges of  
the 1/2 oval together to form  
the Pattern 1 Oval.