

General Instructions for Using Dam Molds to Create Thick Paddies of Glass

Before Firing:

- Spray the dam mold with a Boron Nitrate spray. Make sure to coat the perimeter of the mold with extra care, and allow spray to rest for at least 15 minutes on the mold before proceeding.
- Place a piece of suitable kiln shelf firing paper in the bottom the mold. The firing paper allows for easier separation of glass and mold, and allows air flow beneath the glass to prevent eruptions during firing. This is a critical part of the process.
- Use compatible fusible glass and fill the mold according to your own artistic preferences.
- The dam mold must be elevated from the kiln shelf during firing. One-inch kiln posts can be placed at the edges of the mold to elevate it properly. If a post is too close to the mold's center, uneven heating may occur and create undesirable results.

Suggested Firing Schedule:

As always, adjust the schedule as necessary to fit your individual kiln! The below schedule is for COE96 glass.

Segment	Rate (°F/Hour)	Temperature (°F)	Hold
1	200	1000	15
2	300	1225	30
3	350	1470	15-20
4	9999	950*	120
5	100	700	1

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

Please Note:

- These molds were not designed to act as catch pots for pot melt techniques or any other techniques requiring extreme temperatures or rapid heating and cooling.
- Failure to use kiln shelf paper in the base of the mold and/or proper elevation during firing can result in eruptions and annealing problems.