

Opal Koi Fish Bowl

Traditionally, frit castings have been added to the surface of a glass project. In this project we use frit castings as inclusions inside a glass project to create a whimsical oval shaped bowl featuring two delicate Koi Fish.



Always wear a mask when using powdered frits. Spray your CPI molds with ZYP glass separator before using.

Creative Paradise Inc.

Step 1: Make the Koi Fish.

You will need: CPI mold LF146. A powder vibrate or frit sifting equivalent. An arrangement of F1 frit powders and F2 Medium frit colors for the Koi fish. The frit colors we used you will find mentioned below.



Use a frit sifter, powder vibrate or pipette to place powdered Black Opal frit in the fins, lips and eyes of each koi. Place powdered Flame Opal at the top of the head and here and there in the Koi cavities.



Place powdered or fine frit in bright Orange and Yellow Hues such as Orange Opal or Orange Transparent and Yellow Opal or Marigold here and there in the Koi cavities.



Place fine Transparent Amber here and there in select sections of the Koi to suit your own artistic preferences.



Fill the cavities with fine White Opal until the cavities hold between 1/4" and 3/8" of frit. Fire the mold with the glass using the firing schedule found in Table 1.



Allow the kiln to cool. The back of the castings (up in the mold) will be slightly textural because they were fired using the schedule in Table 1 which does not fire to a full fuse. If fired to a full fuse, the glass will roll back significantly because more glass must be added to the cavities to create thick full fuse castings. Use soap and water and a scrub brush to remove any excess glass separator from the top of the castings.

| Segment | Rate | Temp | Hold |
|---------|------|------|------|
| 1 | 300 | 1150 | 20 |
| 2 | 350 | 1400 | 05 |
| 3 | 9999 | 950 | 60 |

Step 2: Make the bowl.

You will need: CPI mold GM236 Small Oval Dam. A Mosaic Nipper. An arrangement of colored sheet glass and frit to suit your artistic preferences for the pond water themed bowl. The colors we used are mentioned below.



Use a mosaic nipper to fill the bottom of the oval dam with pieces of Ming Green, Citron, Sea Green or other transparent green colors. There will be small gaps here and there between the nipped glass pieces.



Fill the gaps and crevices between the nipped glass pieces with medium and/or fine Citron, Ming Green and Amber frit.



Arrange two of the Koi in the dam over the first glass layer.



Use a mosaic nipper to create small pieces of Ming Green, Citron, Sea Green, and/or other pieces of glass to fill the dam around the Koi frit castings.



Add medium grain Clear frit over all of the glass and frit castings filling the dam mold with 280 grams of glass. Make sure that the frit castings have a thin layer of clear frit over them to assure a smooth glossy fuse.

| Segment | Rate | Temp | Hold |
|---------|------|------|------|
| 1 | 300 | 1150 | 60 |
| 2 | 50 | 1310 | 30 |
| 3 | 350 | 1465 | 10 |
| 4 | 9999 | 950 | 90 |
| 5 | 100 | 700 | 05 |

Place the dam filled with glass on 1" kiln posts on a kiln shelf and fire using the firing schedule found in table 2.

Step 3: Drop it likes it hot.

You will need: CPI mold GM234 Small Oval Shelf Ring and Kiln Shelf Paper.



Remove the fused glass from the dam.



Place the Oval Shelf ring onto a piece of kiln shelf paper. Center the fused glass over the ring on the shelf and fire using the firing schedule found in Table 3*.

| Segment | Rate | Temp | Hold |
|---------|------|-------|------|
| 1 | 275 | 1150 | 20 |
| 2 | 350 | 1250* | 05 |
| 3 | 999 | 950 | 90 |
| 4 | 100 | 700 | 05 |

*to create a more severely angled piece of glass from this slumping process, increase the temp in segment two to 1300 degrees.



Slumped to 1300 Degrees.



Slumped to 1250 Degrees.



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