

Mold Tips: Cone Bowl Molds

Notes generated in the Bullseye Research & Education studios, firing in Paragon GL24 kilns.



Note: The following tips do not guarantee a uniform result. Because of the steep-sided nature of this mold, pieces may slump unevenly.

Prepare either the Cone Bowl (8943) or Large Cone Bowl mold (8975) as directed in *Tips for Using Bullseye Slumping Molds* at www.bullseyeglass.com.

Measure the top edge of your mold to determine the diameter. Cut your glass to the same diameter as the mold or up to 1/16" (1.5 mm) larger all around. This slightly larger size allows the mold's narrow lip to support the glass and hold it in place as it slumps into this steep form.

UNIFORM HEATING

The same characteristics that make these forms unique—depth combined with a narrow lip and flat base—make it unforgiving of uneven heat. Elevating the mold on 2" (5 cm) posts will promote even heating, slumping, and cooling. Also, make sure the mold is in the center of the kiln as these forms may slump unevenly if one side is closer to the elements.

MORE FREQUENT RE-PRIMING

Steep-sided molds like these need more frequent re-priming than forms with gentle curves (forms with gentle curves are often fired to lower process temperatures paired with shorter hold times). As glass slumps into a steep-sided form, it pulls small amounts of primer away from the surface. If the primer wears thin, glass can catch and slump unevenly. Re-prime after every two to three firings. To re-prime, gently remove the old primer with a dry scrub pad and reapply as directed.

SUGGESTED FIRING SCHEDULES

CONE BOWL (8943)

	RATE (DEGREES / HOUR)	TEMPERATURE	HOLD
1	300°F (167°C)	1200°F (649°C)	:30
2	300°F (167°C)	1225°F (663°C)	1:30*
3	AFAP**	900°F (482°C)	1:00
4	100°F (56°C)	700°F (371°C)	:00
5	AFAP	70°F (21°C)	:00

LARGE CONE BOWL (8975)

	RATE (DEGREES / HOUR)	TEMPERATURE	HOLD
1	300°F (167°C)	1200°F (649°C)	:30
2	300°F (167°C)	1225°F (663°C)	1:00*
3	AFAP**	900°F (482°C)	1:00
4	100°F (56°C)	700°F (371°C)	:00
5	AFAP	70°F (21°C)	:00

* If possible, visually confirm the slump. If you are not able to observe a slump in progress, remember that it is often easier to re-fire and increase the heatwork than to fix something that has slumped too much.

** As Fast As Possible. Allow the kiln to cool at its natural rate with the door closed.

Note on Segment 1: The purpose of this lower temperature hold is to begin the slumping process and facilitate a uniform slump before moving on to greater heatwork to resolve the form.

Note on Segment 2: We commonly hold at slumping process temperatures for over an hour, especially for molds with steep sides. This lower-for-longer approach reduces the amount of mold texture picked up by the glass and helps maintain a uniform thickness.