



Use compatible glass throughout. Apply Zyp BN Spray to the shelf ring and the dam mold.

Place a 7.75" circle of kiln shelf paper inside the GM131 dam mold. Use a mosaic nipper and scrap glass to fill the bottom of the dam mold with one layer of glass. There will be gaps between the various shapes and pieces of glass. Fill gaps with fine and medium grain frit until the bottom of the dam mold is filled with a layer of glass. Gaps in the bottom layer may cause air to be trapped and eruptions may result. This bottom layer can also be created by placing a 7 7/8" circle of clear glass in the bottom of the mold. Use the mosaic nipper and glass to cover that base layer with another layer of glass. At least partially cover the second layer of glass with more glass pieces. Fire the mold with the glass using the firing schedule in Table 1.

After the glass has cooled, place the GM232 Shelf Ring on a piece of kiln shelf paper resting on a level kiln shelf. Fire the glass using the firing schedule found in Table 2.

Table 1			
Segment	Rate	Temp	Hold
1	275	1150	60
2	50	1330	30
3	350	1470	10
4	9999	950	90
5	100	500	0

Table 2			
Segment	Rate	Temp	Hold
1	250	1250	30
2	200	1370	30
3	9999	950	90
4	100	500	0

