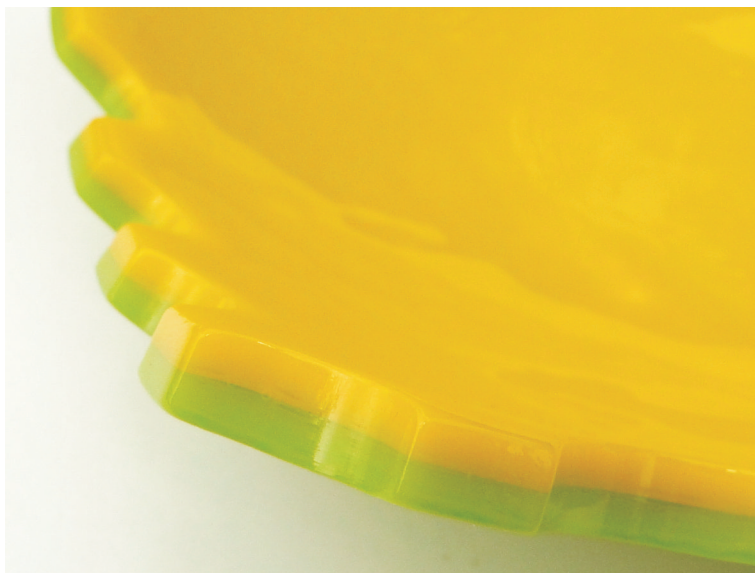


Fused glass bowl with a processed edge



glass bowl " Stamp "

approx. 18 x 18 cm (7" x 7")

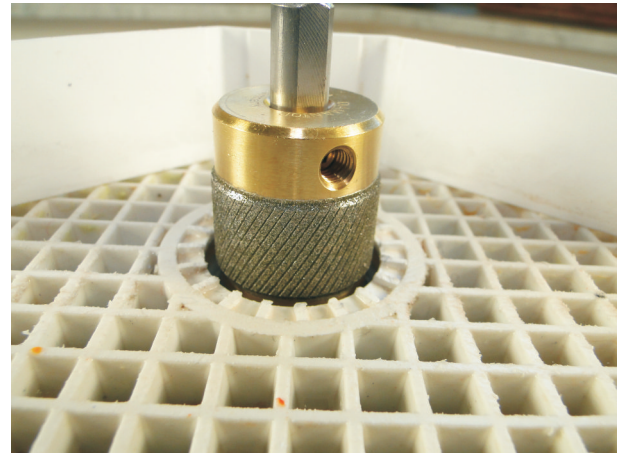


ground edge in detail

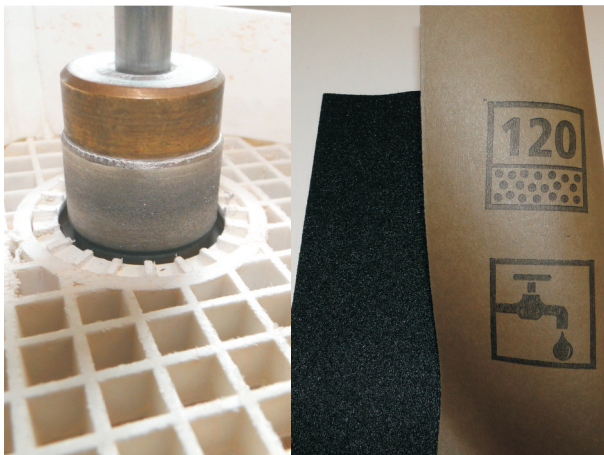




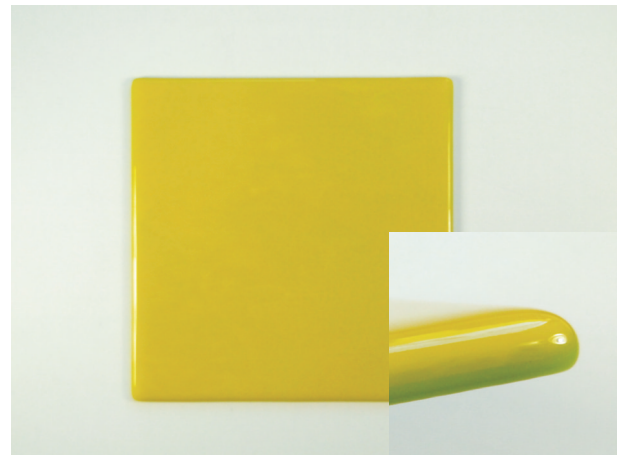
All you need is a regular glass grinder. Here the Kristall 2000S with integrated flushing system.



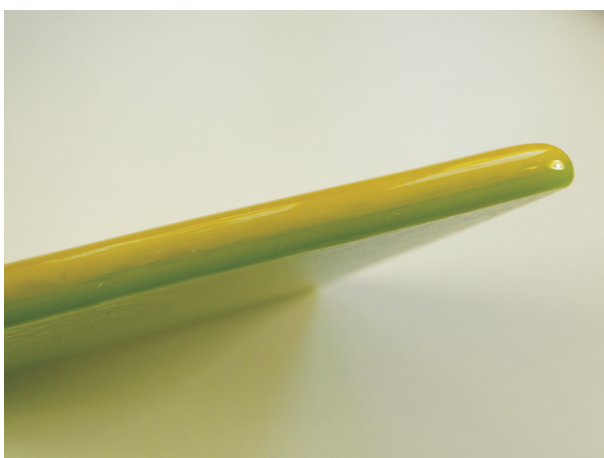
...a very rough grinding head for the preliminary work, strong but not cracking the glass edge's sides. I have the best experience with the 25mm (1") Bohle "turbo" (3020105)



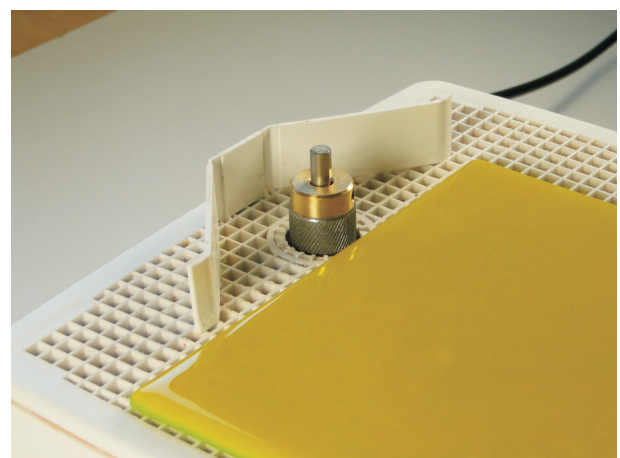
For fine regrinding a grinding head with a fine coating (same diameter as the coarse / turbo). Here Bohle 25mm (1") fine 3020101 and some 120 grit wet sandpaper.



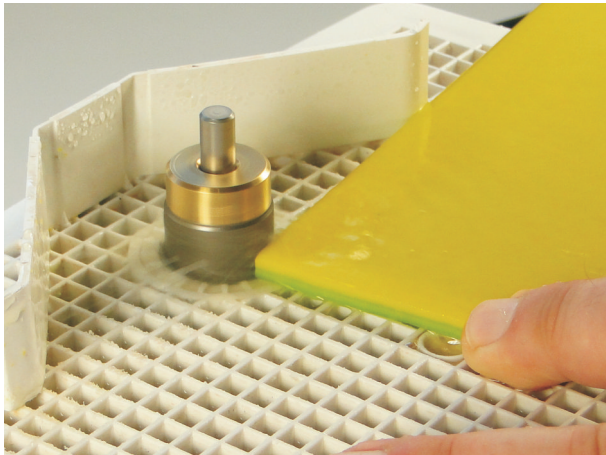
At first you fuse a 6mm, consisting of two layers 3mm, glass plate (fullfuse). Here 20 x 20 cm (8" x 8").



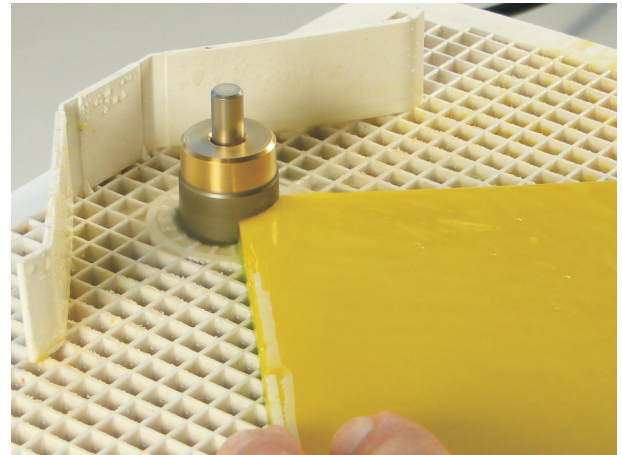
Characteristic of a two-layers-full-fused plate is the rounded edge.



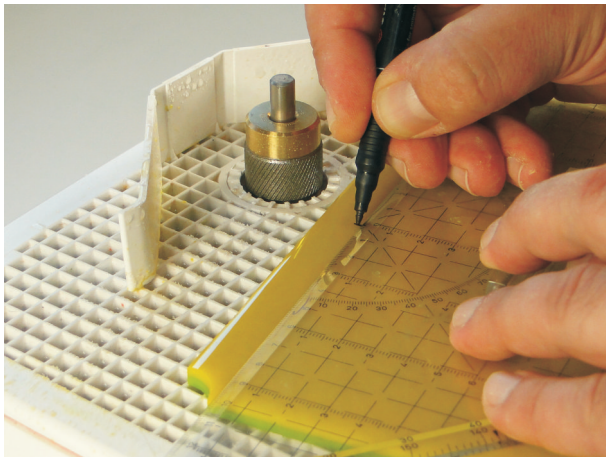
This rounded edge grind off now. Here the "turbo" head is important because this significantly grinds faster than a regular coarse head. You will have to grind off quite a lot of material ...



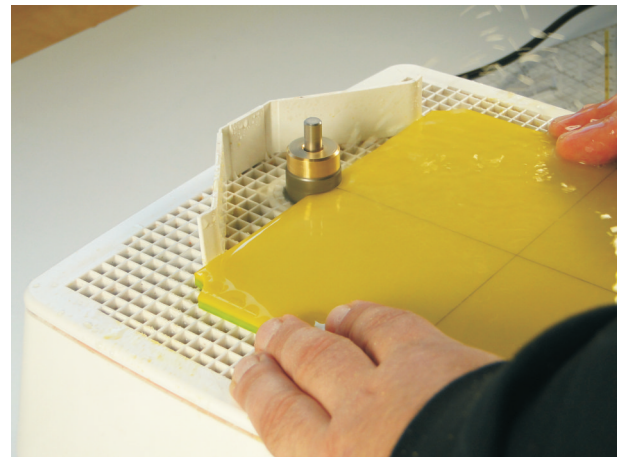
Then prefinish the edge by grinding around to plate with the the fine grinding head.
Here you can already see how the edge changed - both glass layers are clearly visible at the edge.



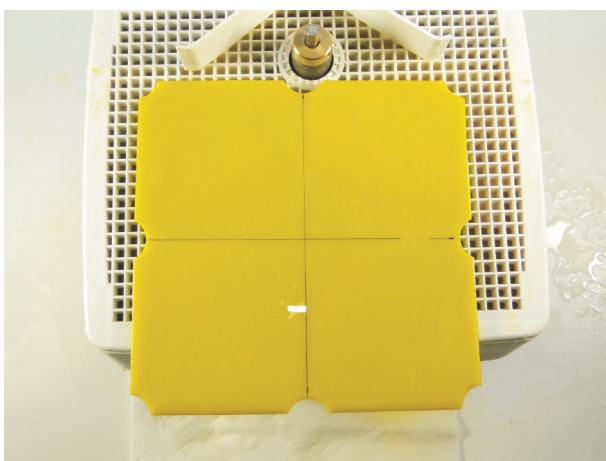
Now continue with the coarse / turbo head.
Grind the first four corners.



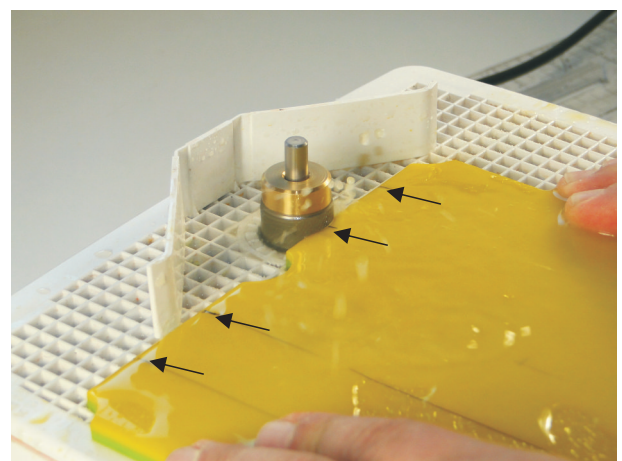
With the help of a protractor or a ruler you'll draw the next grinding position in the middle.



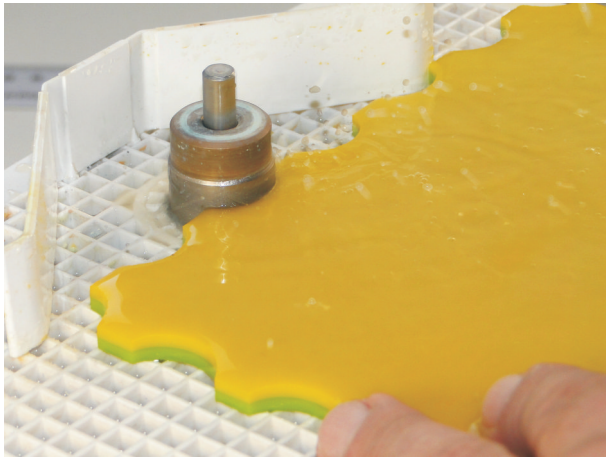
Now grind the inner arc -
With the turbo head, going faster ...



Now the corners and centers are ground.



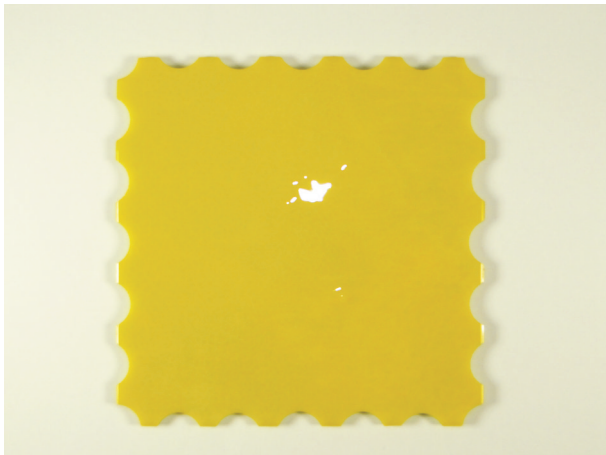
Mark the other grinding positions ...
and then grind all the internal arcs.



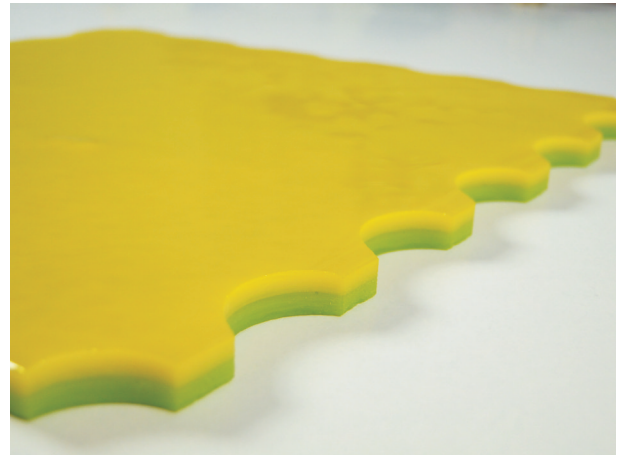
After the grinding work is complete with the coarse / turbo head, regrind with the fine head, to refine the grinding marks.



Deburr the edges with wet sandpaper. With wet sandpaper you can regrind also the ground surfaces again.



Now the plate is ready to be slumped - after the final cleaning - in a suitable ceramic mold.



Detail before slumping.



slumped - ready !



In the example used form:
3522130
Colour de Verre 7-10" Bowl Slump Form

Material and firing schedule...:

These firing schedules are guidelines only,
they must be adapted to the particular kiln, the glass used and the desired result.



Material as shown in the example...:

Bullseye 0320-30F warm yellow

Bullseye 0126-30F spring green

Full fuse of the two 3mm glass sheets to one plate:

1. 120min - 500°C
2. skip - 650°C
3. 60min - 650°C (Bubble step, bubbles are smaller and less)
4. skip - 785°C (don't go to high in temperature to minimize bubble extension)
5. 20min - 785°C
6. skip - 520°C
7. 120min - 520°C
8. 120min - 460°C
9. END

Slumping the completely edge processed and cleaned glass plate:

1. 120min - 500°C
2. skip - 680°C (Note: rather start at 10°C less and adjust the temperature)
3. 60min - 680°C
4. skip - 520°C
5. 120min - 520°C
6. 120min - 460°C
7. END