

Jayne Persico presents...

Bangle Bracelets





Bangle Bracelet Casting Mold

The Bangle Bracelet Casting Mold is made of stainless steel and is a new way to cast glass bracelets. This patent pending mold is unbreakable and allows you to cast quickly and efficiently. It can be prepared with MR-97 primer or High-Temperature shelf primer. Both primers wash out easily with soap and water. The mold is available in two sizes. (X-Sm.-Sm. and Med.-Lg.)

Preparing the mold with MR-97



Prep Supplies- Bangle Bracelet Mold, MR-97, plastic gloves, face mask.

It is important to ALWAYS wear a face mask when preparing a mold, mixing frit and filling a mold.



Apply two light coats of MR-97. Shake can vigorously until the metal ball moves freely. When the MR-97 is mixed well, hold the can 8 to 10 inches from the mold and spray. Allow the first coat to dry about 5-10 minutes. Shake the MR-97 can vigorously again before applying the next coat. Apply the second coat and set the mold aside to dry.



Be sure that the mold is completely dry before filling.

Preparing the mold with High-Temperature Primer



*Mix the High-Temperature primer:
One part primer to three parts water.*

*Next, heat the mold with a hair
dryer.*



*The primer should be a little thicker than
shelf primer mixture. Apply the primer with
a high quality soft bristle brush to prevent
brush marks.*



*While the mold is warm apply
the primer.*



*Apply the primer quickly. Wearing
a glove for protection, turn the warm
mold over to allow the excess primer to
flow out to the edges.*



*Heat the mold until the primer is
dry. Turn the mold over and apply
a second coat, turn the mold over
again and dry the second coat.*



*Be sure that the mold is completely
dry before filling.*

Casting Frit Bracelets



Prepare the bangle bracelet mold. For this project I am preparing the mold with MR-97.



Mix and weigh 40 grams of fine frit.

Note:

Medium and large frit, as well as sheet glass, can also be used in the bangle bracelet mold. The firing schedule will vary depending on frit size and glass volume. (Increase temperature and increase hold time for larger particles)



Transfer the mixed frit into a squeeze bottle. A small funnel makes this task a little easier.



Pour the frit evenly into the mold.



Sweep the outside and inside edges with a small soft brush to clean away any stray frit particles. The edges should be smooth and even.



Elevate the mold approx. 1 ½" in the kiln.



Option: The size and design of the bangle bracelet mold allows you to cast two bracelets comfortably in an 8" table-top kiln. Prepare and fill a second mold and elevate approx. 2 ½".



*Firing Schedule for casting
40 grams of fine frit - **

*First Segment-
AFAP to 1410F-1420F
Hold 8-10 minutes
(AFAP means as fast as possible)*

*Second Segment-
AFAP to 960F
Hold 30 minutes*

**For larger frit sizes increase
temperature by 10 to 15 degrees and
increase hold time by 5 to 10 minutes.*

Adding Decal Elements



Decals are a great design element for the bangle bracelets. Be sure to read the manufacturers instructions before applying the decals to the bracelet. It is important that the bracelet is clean before applying the decal. The decal must be completely dry and free of air bubbles before firing.

Clean the used bangle bracelet mold with soap and warm water. Dry and prepare the mold with MR-97 as previously instructed. Be sure that the mold is dry before placing the bracelet into the mold.

When firing the decals onto the bracelet, it is particularly important to vent the kiln during the first segment of firing. This will allow the materials from the medium to burn off gently, and insure a clean bracelet.



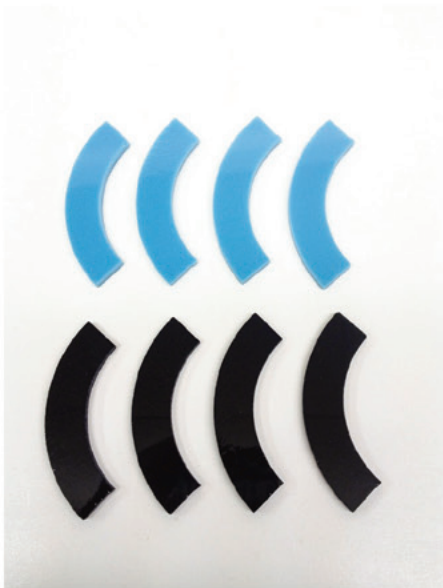
Decal Firing Schedule-

*First Segment- Vent during this segment
300 degrees per hr. to 1000F
Hold 5 minutes.*

*Second Segment –
AFAP to 1325F-1340F
Hold 8 minutes*

*Third Segment –
AFAP to 960F
Hold 30 minutes*

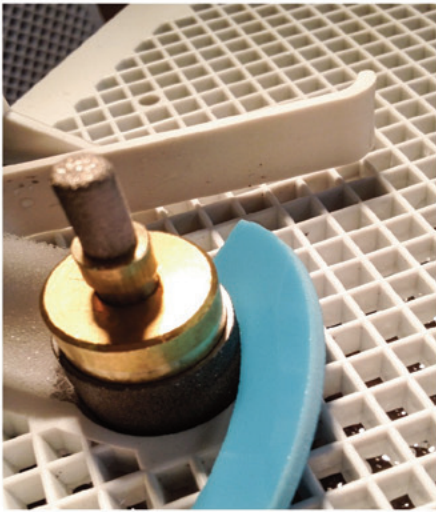
Casting Sheet Glass Bangle Bracelets Color Block Style



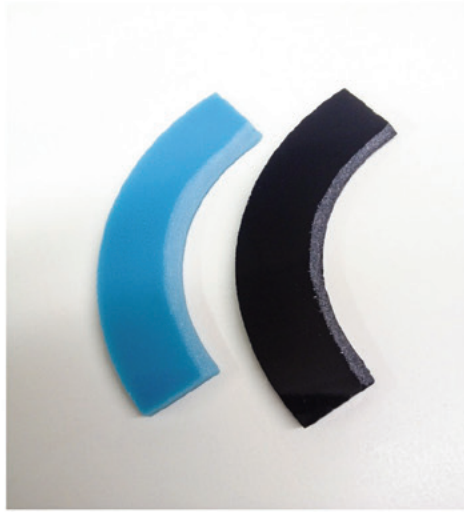
I have selected turquoise and black sheet glass for this color block design. This bracelet requires two layers of glass. Cut eight quarter sections of sheet glass. (Four quarter sections for the top layer and four quarter section for the bottom layer.)

Each layer will have two turquoise sections and two black sections. The layout on the left is the bottom layer and the layout on the right is the top layer.

The four sections that make up the bottom layer must have the inside edge of the curve beveled on one side. (The side that will be placed against the bottom of the mold.) This step will insure a tight fit on the first layer. It is not required for the top layer. Bevel the inside edge of two black sections of glass.



Next bevel the inside edge of two turquoise sections of glass.



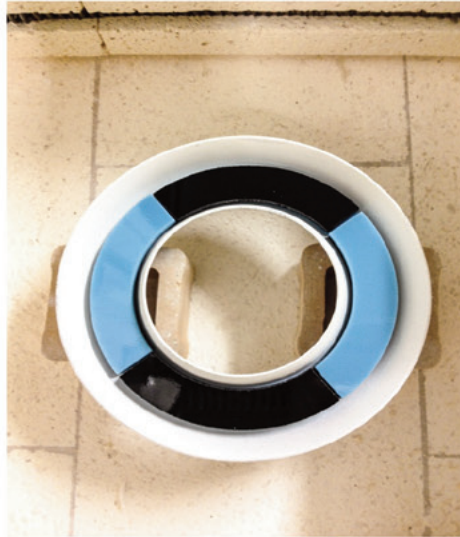
Beveling the inside edge of the curved section of glass will allow it to sit flat against the bottom of the mold and tight against the inside curve of the mold.



Prepare the bangle bracelet mold as previously instructed. Place the first four sections in the mold beveled side down. If the pieces do not fit tightly, they may need additional grinding. It is important that there are no spaces between the glass.



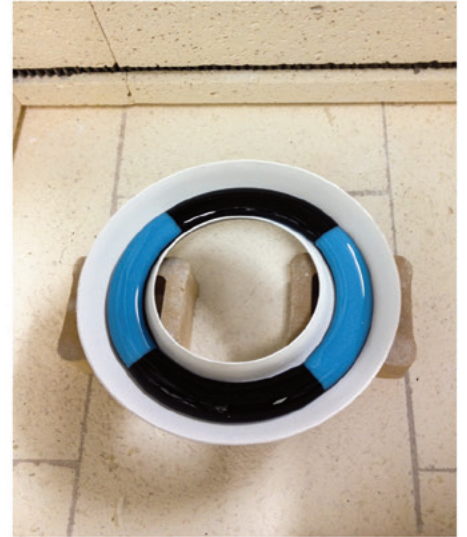
Next arrange the second layer of glass. Place the turquoise on top of the black, and place the black on top of the turquoise. This will alternate the colors on both sides of the bangle.



Carefully place the mold in the kiln and fire.

*First segment -
AFAP to 1425F-1435F- Hold 10 - 15 minutes.*

*Second Segment -
AFAP to 960F- Hold 30 minutes.*





Bangle Bracelet Casting Mold



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