

Pattern for “XL Lily” formed on GM139 Cone Former Mold

Arrange 3 large, 3 thin and 6 small diamond shaped petals as indicated in figure 1. Figure 1 is provided to indicated petal placement and is much smaller than the size of the actual flower. To create a flower with a hole in the center to place on a stem, create a void where all of the petals meet in the center as indicated in Figure 1. The glass was tack fired using the tack fire schedule given in table 1and then placed on GM139(treated with glass separator) and draped using the drape firing schedule given in table 2.

Be sure to print PDF as “actual size”.

Table 1 Tack Fire

| Seg | Rate<br>(min/hr) | Temp<br>(degree F) | Hold<br>(min) |
|-----|------------------|--------------------|---------------|
| 1   | 275              | 1100               | 15            |
| 2   | 200              | 1225               | 10            |
| 3   | 200              | 1400               | 10            |
| 4   | 9999             | 960                | 90            |

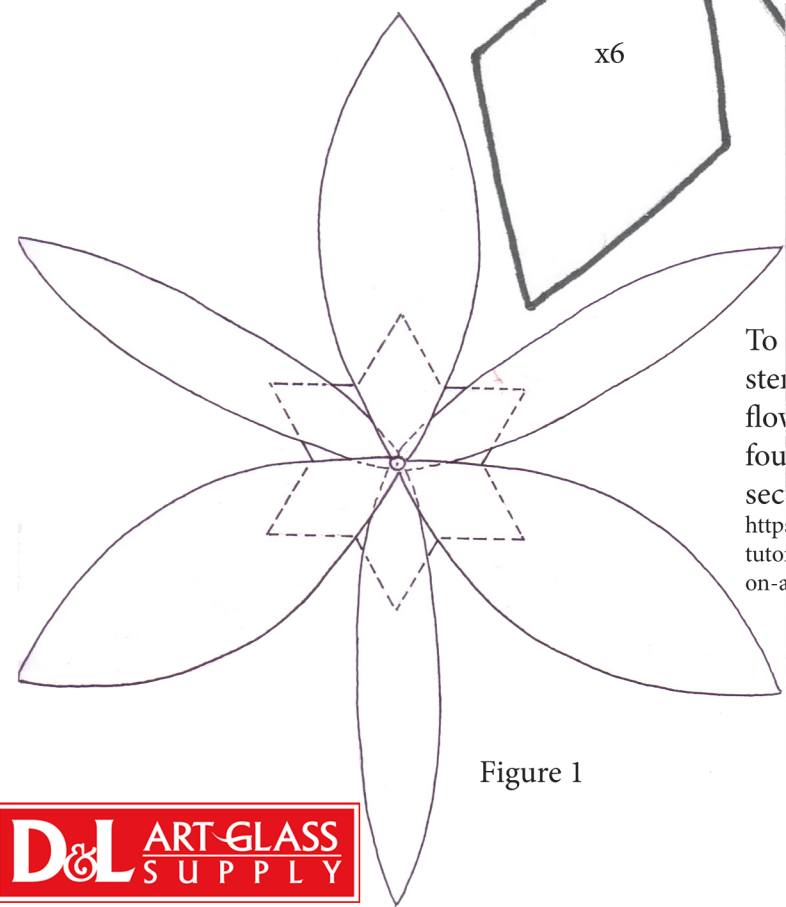


Figure 1

To place the flower on a stem, follow the general flower stem directions found in the tutorial section of our website.  
<https://creativeparadise.biz/glass/tutorials/videos/putting-a-flower-on-a-stem>

Table 2 Drape on GM139

| Seg | Rate<br>(min/hr) | Temp<br>(degree F) | Hold<br>(min) |
|-----|------------------|--------------------|---------------|
| 1   | 275              | 1000               | 10            |
| 2   | 275              | 1215               | 20            |
| 3   | 275              | 1230               | 2             |
| 4   | 9999             | 960                | 90            |