

Bonny Doon Fused Glass Tools

<http://bonnydoonfusedglasstools.com>

Pattern Bar Flow Technique

(using our stainless forms!)

Start by making strips of glass and tac fusing them together. In this example I have cut strips 1" wide by 20" long. Tac fuse them together using this schedule. You can line them up close as they will not melt or move. If you have a small kiln....no worries. Just make them the lengths you can as you are going to slice them up anyway! Use 90 or 96.

Tac Fuse:

300 degrees to 1300 degrees hold 10 min

9999 (as fast as kiln will go) to anneal 900 (Coe 90) 950 (coe 96)

3 hour hold

50 degrees an hour to 800 no hold

100 degrees to 700 and off. Do not open....cool to room temp. This is alot of glass!!

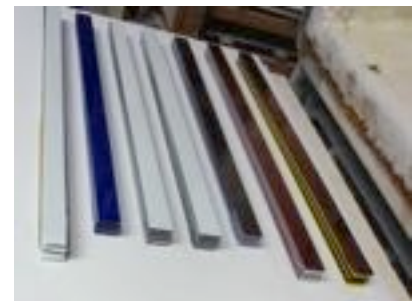
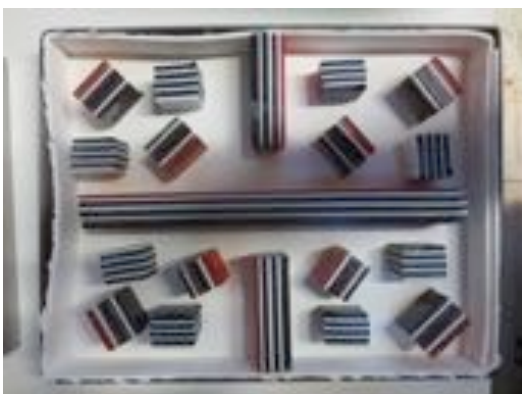
Slice them up on your wet saw and clean on sliced edges with a diamond pad or

scrubie. Do not let them dry between slicing and cleaning. Drop in a bucket of water as you go! Only use fusible glass on these....any glass that will devitrify easily should not be used!!



Prepare your shelf with fresh kiln wash. Place your stainless steel ring on the shelf and line the inside edge with 1/8" fiber paper as shown in this picture. There are so many ways to place

your bars..... experiment! Take a before and after picture as I have done here! The more negative space that you have between your bar segments the more flow you will have.





The important thing to remember in this technique is to put in enough glass by weight that it will flow to fill your ring. To do that we are constructing a chart with our rings that will make it easy for you. These will be apx 3/8" to 1/2" thick. When you have perfect

success with a ring and a weight of your final piece shoot me an email so I can compare!

Full fuse Schedule

300 degrees to 1225 hold 45 min (to let any air escape)

600 to 1525 hold 1 hour 30 min (this works great in my kiln but since all kilns are different soak here up to 2 hours if needed) I go 1 hr 30 min

9999 to anneal 1 hour 30 min (if thicker anneal for 2 hrs)

100degrees to 700 degrees no hold and off

Do not be tempted to open this before room temp!!

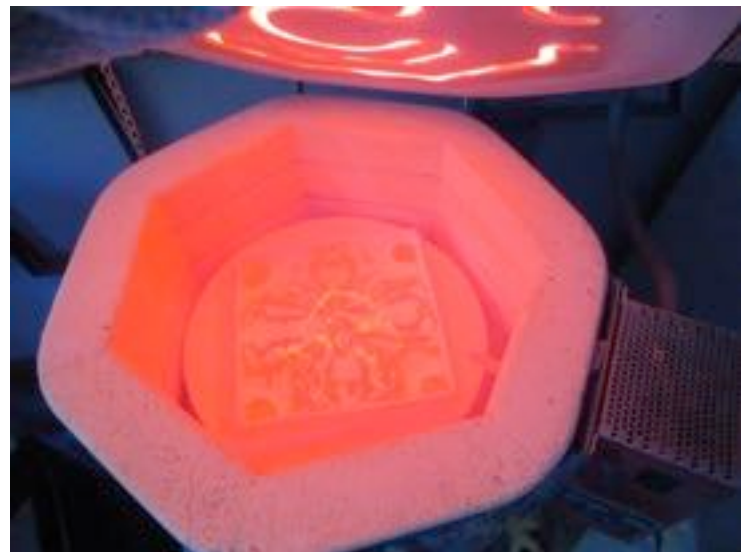
Slump Schedule

300 degrees to 1225 hold 5 min

9999 to anneal hold 2 hour

100 to 700 and off

Again....let it cool well....this is a thick piece of glass!!



Extras....

If there is any kiln wash on the bottom of the piece due to the high heat it should come off with a diamond hand pad, sand blast or flat lap.



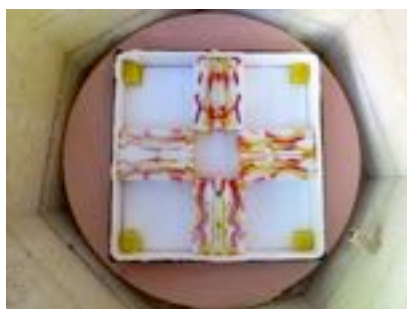
I have found if I place the pattern bars on the exterior at least 1/2" away from the fiber paper...when it flows out it does not have such a rough edge to deal with. Here is one that ended up with a slightly scalloped but beautiful smooth edge!

Pattern bars made in our formers can also be used in this technique! I am going to try a pot melt pattern bar in the next few days.

You can place a blank of color or clear glass onto your shelf and put your pattern bar pieces onto that. This eliminates the sticking kiln wash! Yeah! It also works well on shelf paper when using a full sheet of glass as the bottom layer. Do not use shelf paper if putting the pattern bars directly on the shelf as the movement will gather the paper into the glass.

When slicing patterns bars for this technique I like to make them at least 3/4 inch so they will have movement as you can see in the next picture. These were made in our 8" pattern bar former. Woweeeee!!!

Thanks to Bullseye for this idea.....one of the folks that work at Bullseye Emeryville that uses my rings turned me onto it.





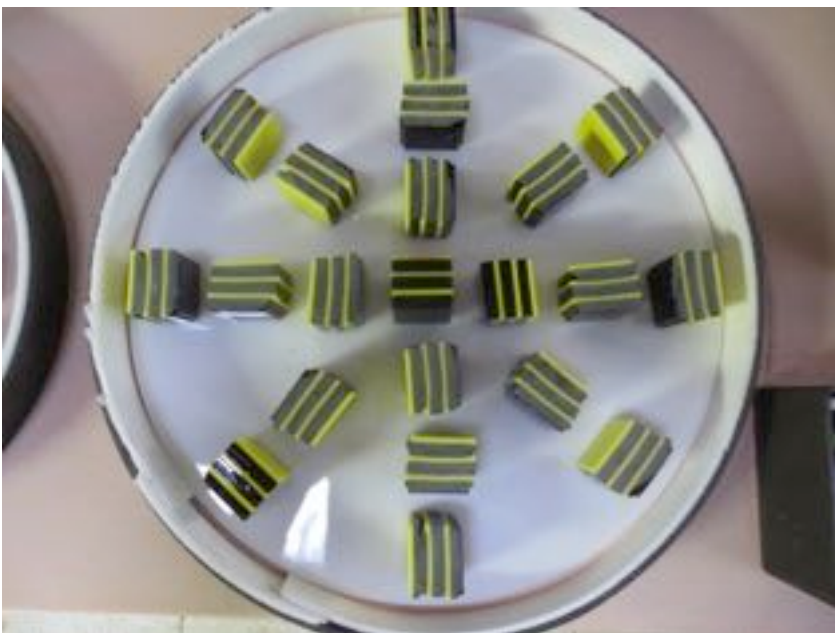
Kiln getting prepared for loading. Fresh Bullseye kiln wash 3 layers liberally applied.....next picture 1/8" fiber paper on the insides of all the forms. Make to put a scrap of thin fire behind the joint and the fiber is pressed against the shelf. I could add more forms and pack it tighter but it is alot of glass and I like to give it a little room!

On the load below I added a couple of stilts with a small shelf and a couple of pattern bars in our formers. Worked out great. Next load I will probably add 2 more!





This white/orange bar turned into the pattern bars above.





Here is a list of stainless steel formers that we make and use in our studio!!

Stainless Steel Rings, Squares and Pattern Bar Formers

ROUNDS!! All 1" deep

6 1/2" Round \$32.00

8 1/2" Round \$36.00

10 1/2" Round \$42.00

12 1/2" Round \$48.00

14 1/2" Round \$54.00

SQUARES!! All 1" deep

5 1/2" BY 5 1/2" Square \$32.00

6 1/2" x 6 1/2" Square \$34.00

7 1/2" x 7 1/2" Square \$38.00

8 1/2" BY 8 1/2" Square \$38.00

10 1/2" BY 10 1/2" Square \$48.00

12 1/2" x 12 1/2" Square \$52.00

14 1/2" BY 14 1/2" Square \$56.00

PATTERN BAR FORMERS!! All 2" deep

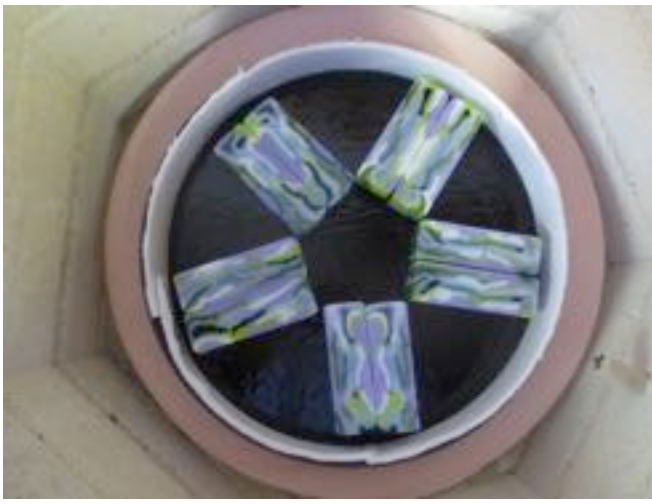
12" x 4" x 2" deep \$48.00

HEARTS 2" DEEP

6" \$2800

10" \$39





Here is one that came out a few days ago.....I will continue to add pics as these evolve!

Updating Aug 9th 2020!

Here is a new group of bars. Each one is around 24" long by 1" wide stacked in 6, 8, 10 high stacks.....tack fused according to the schedule above.

I have just loaded the kiln. A full kiln load only took around 1/3 of the bars that I made.....This load I decided to use Bullseye shelf paper with a full sheet of glass on the bottom of each piece after putting 1/8" fiber in the stainless steel formers. You can also put a stack of clear under the bars to add extra flow.

Here is a shot of the loaded kiln. There are also 2 of our pattern bar formers loaded up with scrap.....We like to use all the space in every load. Now a prayer to the





Kiln Gods! You can also put stacks of clear underneath the bars for them to flow further.

Here I have put clear stacks under the frit and twisted vitrified and flowed.

firing fast

600/1520/2 hrs

9999/950/3 hrs

100/600 off

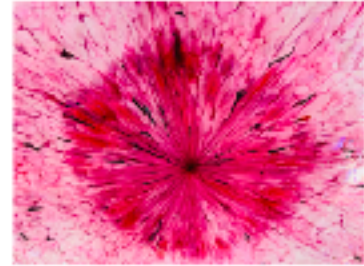
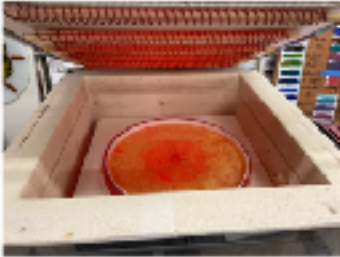


June 2021

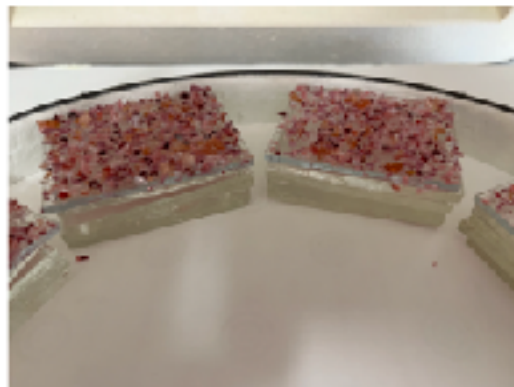
Here is one where I fused a thick block of clear with the colors on top and flowed the block all by itself. The clear was over an inch deep. The block was around 9 1/2" square. Since I did not know how far it would flow I fired it on a 24" shelf. love it!!



New for 2022. Here I am using Val Cox's Frit Blends for the topping on stacks of clear glass. Her frits are very concentrated and make wonderful flows. <http://www.valcox.com/> You



You can arrange your stacks in all kinds of ways.....I am firing these fast...600/1520/holding 60-120 min depending on the volume and your kiln. anneal 3hrs and 100/600 off These are done best in our Stainless Steel formers as then they have room to "breathe". In a solid clay form you can get bubbles that you may not want.



How fun is this????? Please let us know if you have enjoyed the information in this tutorial!!! Hope you will order some stainless steel formers soon!!!! send emails and orders to Bkpottery@aol.com or call 831-454-0103