

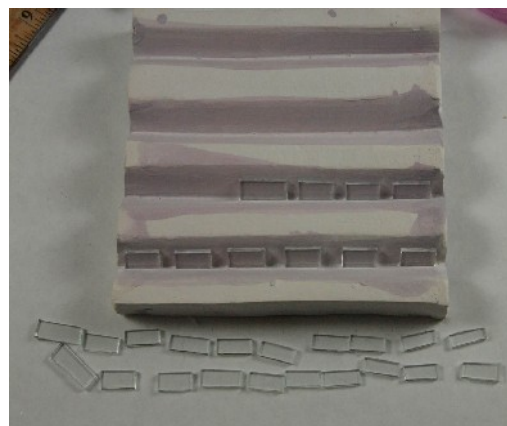


Triangle Bead Mold and Mandrels

This innovative 2-sided bead mold is designed to make fused kiln formed beads. **Both sides of the bead mold must be kilnwashed before use, and mandrels must be coated with bead release before use.**



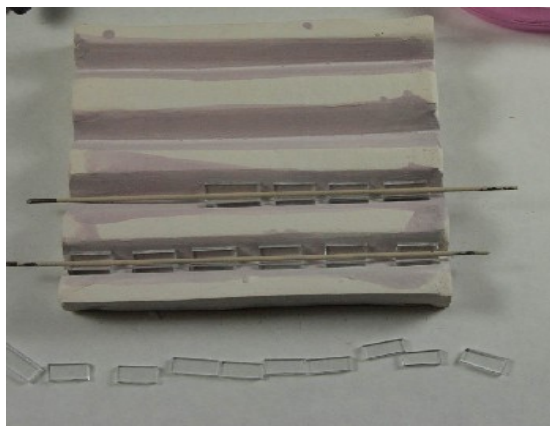
Step 1: Cut strips of glass according to the sizing chart, then cut the strips into rectangles. The length of the pieces will determine your bead size.



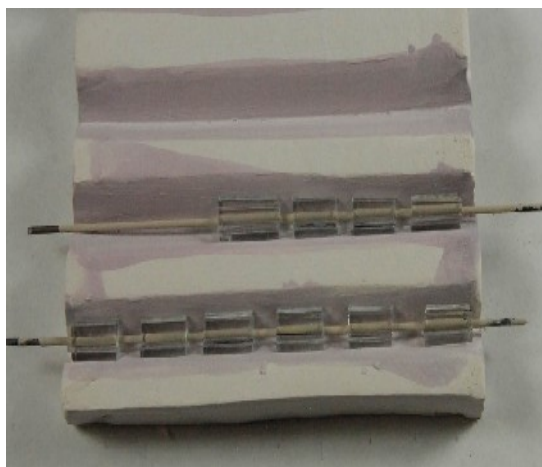
Step 2: Place the larger $3/8$ " (.93 cm) against one side of the V shaped mold channel. Continue as desired. Leave a small space between pieces of glass. This glass will form one side of the triangle bead.



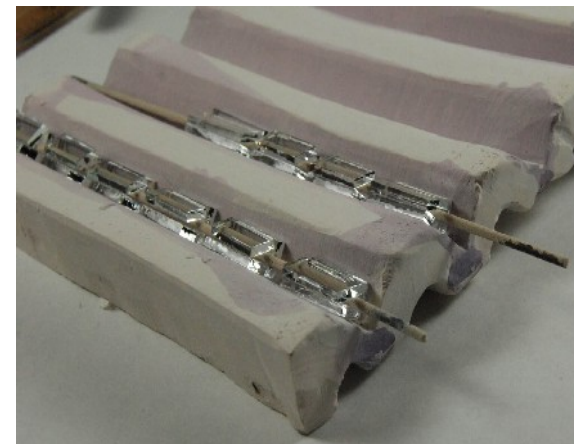
Step 3: Add a smaller ($1/4$ " .64 cm) piece to the other side of the V channel. This piece of glass will form the second side of the triangle bead.



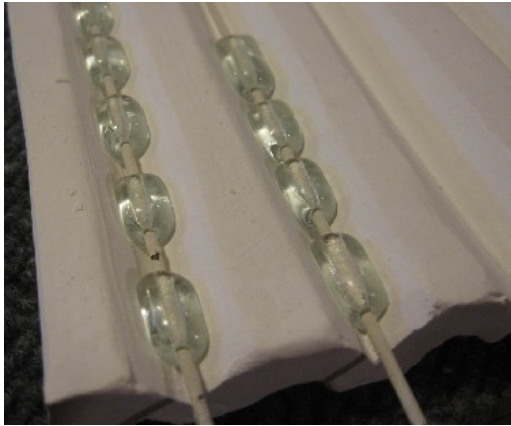
Step 4: Add a prepared mandrel to each V channel, the glass will hold it in place.



Step 5: Add remaining glass piece to the top of each bead.



Step 6: place in kiln and fuse using schedule on pg. 3



Fusing with the curved side of the mold.

Step 7: After fusing and beads are cool, twist beads off mandrels. Take care to avoid any sharp edges.



Step 1: Place the larger piece of glass in the U channel first.



Step 2: Add a prepared mandrel to the glass, brace it with a bit of fiber paper on each end if necessary. Add one smaller piece of glass to each bead on top of the mandrel.



Step 3: Add a second piece of smaller glass to each bead. The small pieces should meet at an angle over the mandrel.



Step 4: Fuse using the firing schedule of page 3. Remove beads from Mandrel after cooling.

Cutting Chart

Thin glass for triangle beads	3 strips @ 1/4" each (.64 cm)
Bottle Glass for Triangle beads	1 strip @ 3/8" (.95 cm) 2 strips @ 1/4"
All glass for curved beads	1 strip @ 3/8" 2 strip @ 1/4"

Firing Schedule for float/bottle glass

For other glass, please use manufacturers recommended fusing schedule

Ramp Rate (F)	Hold Temp (F)	Hold Time	Ramp Rate (C)	Hold Temp (C)	Hold Time
300/hr	500	10	148/hr	260	10
300	1100	10	121/hr	593	10
300	1550	8	121/hr	843	8
9999/hr	1060	20	9999/hr	571	20
50/hr	900	0	10/hr	504	0
100/hr	740	off	38/hr	393	off

Tips, Tricks and Troubleshooting

- Thicker glass will produce larger beads, thinner glass will produce smaller beads.
- Cutting the strips into lengths will determine how long the beads are. The recommended length is no shorter than 1/4" (0.64 cm). 1/2" (1.25 cm) is a good length to begin with.
- Beads can be the full length of the bead mold.
- Putting bead release into a plastic test tube will make it much easier to dip mandrels.
- If your mandrel won't stay centered, brace it on each end with a tiny piece of fiber paper or fiber blanket

Q: My beads have gaps between the glass pieces.

A: Cut the glass strips slightly wider for the next batch.

Q: My beads are stuck on the mandrel.

A: An even coat of bead release is critical, dip twice if your release is very thin.

Q: My beads have sharp edges.

A: Sharp edges are often caused by the glass pieces being a tiny bit too large. The sharp bits can be filed off and the bead fire polished for a smooth finish.

Q: The glass bits won't stay balanced on the mandrel.

A: Try glueing the corners of the glass pieces as you set them up. A tiny bit of glue will do the trick.

Q: The glass pieces for thin beads are all the same size, does it matter what order they go in the mold?

A: No, since the width is the same, they can go in any order.