



INSTRUCTIONS FOR SilkeMat® RIGIDIZER

1. Shake thoroughly before applying, as the solution settles. Rigidizer may thicken upon storage, and may be water-diluted to desired consistency of medium to heavy cream.
2. Application: brush or dip SilkeMat® both sides. It is not necessary to completely soak through for a firm mold.
3. Position on a non-porous mold or form which has been lightly sprayed with vegetable oil or similar mold release; or hand-manipulate into shape. On porous models, clear plastic food wrap can be used instead of oil as a release agent.
4. For Slumping Molds: An optional method is to only saturate one side of the mold and leave the interior soft for a gentle texture on the glass. No separator needed.

GLOVES ARE RECOMMENDED WHEN WORKING WITH WET RIGIDIZER

Rigidizer is not harmful, but will tend to dry out your hands.

Allow to air dry (sunshine is great) or, set the wet mold into a warm kiln at 150-250F to gently dry. *** Make sure the form you are using will withstand that temperature without warping or melting.

It is helpful to press down the wet fibers with your fingers or smooth tool as it dries, which alleviates some sanding.

5. When sufficiently dry to handle easily, you MAY
 1. cure in a VENTED kiln set at (AFAP) 1450F for 20-30 minutes. **(In an empty kiln, if possible)**
 2. Or, if still damp, dry at 150F-200F slowly for 2-4 hours and then program a full cure as above.
 3. Firing too quickly when damp may warp the mold with uneven curing.
 4. Use caution firing very fast on a ceramic shelf, as the shelf may crack with a rapid temperature rise.
 5. Some odor & color change may be evident as the oil and moisture burn off, but it is not harmful.

**DO NOT CURE AT HIGH TEMP DIRECTLY ON A CERAMIC SHELF.
USE A FIBER BOARD OR FIBER PAPER ON THE FLOOR OF THE KILN!
REMOVE MODEL BEFORE CURING MOLD**

6. TO AVOID SHRINKAGE IN FINAL MOLD: It is recommended to prefire mold (even if air-dried) or raw SilkeMat®, to completely cure it. NOTE (again): REMOVE FROM MODEL BEFORE FIRING. Keep vent open for moisture to escape. SilkeMat® will now be in rigid form and ready to use.
7. A high-temp fiber paper or boron nitride coating may be applied as a separator and dried as directed by the manufacturer. However, we find transparent glass rarely sticks and opals, occasionally.
8. When dried, SilkeMat® may be sanded for some smoothness, but an N-95 or equivalent facemask is highly recommended to eliminate inhalation of dry silica particles.
9. Holes and/or slots may be drilled or cut into the dry rigid SilkeMat® form using a craft knife, electric drill, or any number of plastic or metal items. Again, a good dust mask or respirator is recommended.
10. Rigidized SilkeMat® molds tend to degrade slightly with multiple firings, and a thin layer of surface fiber may stick to the glass.

This product is non-flammable and is non-hazardous in liquid form.

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