

Thank You for purchasing Flatop Drop Rings!

This will be the sturdiest mold you have ever owned! Short of dropping them on the ground, or an act of God, I don't see these molds disappointing you. I have not seen these molds crack, warp or crumble in any way during regular use in our studio.

Slumping molds/dropout rings should be coated with some sort of separator to prevent the glass from sticking to the mold. Standard shelf primer works fine for smaller rings but we've learned it can be a bit too slippery from time to time, especially above 4" diameter. OnGrade Studio recommends coating dropout rings with the opposite of primer, **dōp: dropout paste**.

You may notice that the width of many of our rings is significantly less than other rings on the market. We understand their width to be necessary to support enough glass/mass that will hopefully hold the blank in place during the dropout firing. At OnGrade we use DōP, not hope, to hold our glass in place on the ring. A thin coating of dropout paste prevents the glass from sliding (or moving at all) on the ring during the dropout process. This means we can now make larger diameter vessels without the need for a larger diameter mold. Which also means you can make larger vessels without the need for a larger kiln!

Another difference is the inwards slope to the top surface of other dropout rings. We are all about keeping our glass in place. Therefore, our molds have a "flat top" that also helps keep our blanks stationary.

Using Flatop Rings:

- Upon receiving your new rings, pre-fire them to remove any residual moisture prior to dōping, priming.
- Elevate the rings on posts. It is OK to stack multiple rings on top of one another, separated by 1/2" posts.
- **To pre-fire:** 400 dFph (degrees Fahrenheit per hour) to 1500F, hold for :15. Vents open.
- Cool AFAP without opening kiln to *crash cool* until ~500F
- One side of each ring should have a smoother inside edge which indicates the side upon which glass should rest.
- Want a smoother edge? The molds are easily shaped (albeit slowly) with 100-200 grit diamond hand pads or carbide sandpaper.
- Need help? We've got your back: ongradestudio@gmail.com
- Suggested firing schedules and Dropout Paste instructions are here: <https://www.nathansandberg.com/downloads>