

# MO-RE<sup>®</sup>

SPRAY N' FUSE MOLD RELEASE



Equipped with  
Anti-Clog Nozzle



The premier boron nitride mold release made especially for the fusing glass enthusiast and professional. Each masterpiece can be easily removed from any mold cleanly with no post-fire work needed.

To experience top-of-the-line results, use alongside the superior

**PAPYROS** KILN SHELF PAPER!



## TECHNIGLASS



MADE IN THE USA

# MO-RE® Application and Best Practices

## Application Instructions for All Types of Molds

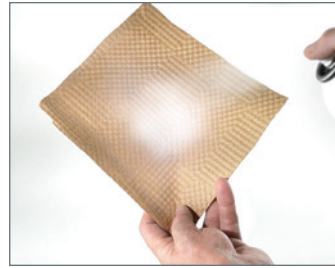
This basic method of application works for ceramic (slumping or frit casting) molds, as well as all types of stainless steel molds.



1. Set the mold on a protected, flat surface in a well ventilated area to shield from over spray.



2. Shake the can of **MO-RE** vigorously for at least 1 minute.



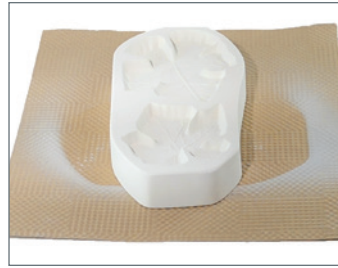
3. Spray a quick test on a scrap of paper. If the spray releases clear, additional shaking is required. If the spray releases white, apply **MO-RE** to the mold.



4. Hold the can of **MO-RE** at a 45° angle, 10-14 inches (25-35 cm) from the mold.



5. Spray in swift, sweeping motions from outside edge to outside edge.



6. Rotate the mold 90° and spray again in swift sweeping motions from side to side.



7. Keep rotating and spraying until you have applied **MO-RE** from all four directions. When finished, allow the mold to dry for 10-15 minutes.



8. Repeat the entire process until you have coated the mold *twice from all four directions*. The mold is ready to use when it is thoroughly dry.

## Frit Casting Molds: Cleaning and Reapplication of MO-RE Between Uses

You should always remove any loose powder residue between uses of a casting mold since this can potentially mix with the frit of the next project. After cleaning, re-coat with a single application of **MO-RE** in all four directions.



1. Using a nylon brush, gently sweep any loose powder from the cavity of the mold.



2. Vacuum the dust with your studio Shop Vac. **(NOTE: A HEPA filter is always recommended when vacuuming fine particles.)**



3. Apply **ONLY ONE** application of **MO-RE** in all four directions.



4. When finished, allow the mold to dry for 10-15 minutes.

# MO-RE<sup>®</sup> of an Advantage

## Using MO-RE After Using Other Primers

MO-RE can be effectively applied to a mold\* that has previously been coated with kiln wash. *\*(NOTE: Many different brands and formulations of kiln wash are available in the market. Each has not been tested and your results may vary.)*

## Removing Kiln Wash From a Mold

Use a stiff nylon brush to gently sweep loose all of the previous primer. Vacuum away the dust with your studio Shop Vac. (A HEPA filter is always recommended when suctioning fine particles.) On flatter mold surfaces, a dry sponge can also be effective in removing the kiln wash. Remove all visible signs of kiln wash before coating with MO-RE.

## Using Kiln Wash After MO-RE

A mold that has had MO-RE applied to it will no longer be porous enough to accept kiln wash.

## Using MO-RE After Other Boron Nitride

MO-RE can be successfully used on a mold previously coated with another Boron Nitride. Be sure to brush the mold, thoroughly loosening and vacuuming away any residual powder before applying MO-RE.

## Slumping Notes

### Ceramic Molds

You do not need to reapply MO-RE between each use of a ceramic slumping mold. If the mold is fired frequently, remove any loose powder and reapply a light coating after several uses.

### Stainless Steel Molds

MO-RE is a perfect choice as a primer on Stainless Steel molds and so easy to apply. Because steel is non-porous, any primer can scratch off fairly easily. Inspect the coverage on your steel molds before using them and touch up any areas where necessary.

## Frit Casting Information

Smaller Frit particle grades of Powder, Fine, and Medium are recommended for Frit Casting. Larger particle sizes and nipped sheet glass can scratch the MO-RE coating and lead to sticking or embedding of the boron nitride into the casting.

Opal frit has a tendency to appear matte or cloudy on the mold-side surface after firing. It is recommended to layer in clear or complementing transparent colors with opal frit to reduce this effect.

Adjust the length of spray time in accordance with the size of the mold. The tiny cavities in jewelry molds need much less coverage than larger and more detailed molds.

## Cleaning Castings

The non-flammable solvent used in MO-RE releases somewhat from the boron nitride when fired, leaving some residual powder on the mold-side of the castings. If the conservative firing schedule below was used, you should only need to rinse the casting to clean it. More aggressive firing schedules can result in additional residue adherence. If you intend to use the casting in a larger project, be sure to remove all residue so that it will tack fuse properly in the next step.

## Cleaning Methods

- The scrubbing side of a kitchen sponge is often enough to remove light residue.
- Soak/wash the piece in hot water with a little dish washing liquid. A mild, abrasive cleansing powder can be used to scrub the affected surface.
- For stubborn residue, a fine sandpaper can be used to gently scrub it away.
- A wire brush can be effective in reaching recessed areas of a detailed casting. Be as gentle as possible to avoid scarring the glass surface.

## Firing Frit Castings

It is strongly recommend to follow a conservative firing schedule when frit casting. Going slowly once the glass begins to soften and then holding at lower forming temperatures can keep the glass from moving too quickly inside a frit casting mold — a primary cause of glass picking up the boron nitride particles as a residue. Additionally, castings don't shrink and round as much using a lower firing schedule.

Remember that all firing schedules are considered starting points. Kilns vary widely, glasses differ, and each project is unique. Adjust the firing schedule accordingly.

## Recommended Frit Casting Firing Schedule

*This schedule is designed for COE 96 glass. For COE 90, add 15-20°F.*

Segment	Ramp <sup>1</sup>	Temp	Hold
1	500°F/278°C	700°F/371°C	20
2	300°F/167°C	1350-1400°F/732°-760°C	20-60**
3	AFAP***	950°F/510°C	60
4	200°F/111°C	800°F/427°C	0

\*\* Adjust the hold time in Segment 2 depending on the size and thickness of the casting as well as your desired effect.

\*\*\* AFAP: Go as fast as possible.

1: Ramp rates not direct Fahrenheit to Celsius conversion. C=F/1.8

# MO-RE<sup>®</sup> Boron Nitride

## Congratulations — You're Using a Safer Product in Your Studio!

**MO-RE is different.** The non-flammable solvent used in **MO-RE** is a safer alternative, emitting lower odor. Although you may have used a boron nitride product before, please follow our instructions carefully.

**NOTE:** Aerosol products expel fine particles into the air upon spraying. Apply **MO-RE** outdoors or in a well ventilated area. Wear eye protection / face protection.

### Non-stick Formulation with Exceptional Release

- Wet application allows self-leveling of particles
- Works on stainless steel, ceramic, and frit casting molds
- Glass releases clean with no spiked edges or film left behind
- Minimal application enhances effectiveness

### Radically Different

Glass is the most difficult application to release, that's why Techniglass has formulated **MO-RE** specifically for the art glass industry. With a non-flammable solvent base, **MO-RE** produces an effortless release for a wide array of molds. Application and cleanup are simple compared to brush-on primers.

### Safe Solvent Based Formula

- Non-Flammable
- Can withstand firing schedules from 500°F/260°C to 1600°F/872°C.

### Efficient & Self-Leveling

**MO-RE** Spray n' Fuse Mold Release consists of microscopic solvent particulates that are expelled onto a surface by a liquid propellant. The unique formulation is completely different and appears wet upon application, undergoing a self-leveling process to create an ideal barrier between glass and mold.

### Types and Sizes:

Item No.	Description	Qty	Volume	Dimensions		Weight	
				English (in)	Metric (cm)	English (lbs)	Metric (g)
MO-120	12 oz. Can	1	276 ml	9x3	23x8	0.78	340
	12 oz. Case	12	3.3 L	12x9x9	31x23x23	10.0	4536
MO-80	8 oz. Can	1	184 ml	7x2	18x5	0.5	227
	8 oz. Case	12	2.3 L	12x9x9	31x23x23	7	3175

**Please NOTE:** Visual indication of application is delayed by 45-60 sec.

#### CAUTION: DO NOT OVER SPRAY.

Heavy application of mold release will cause imperfections in glass.

# TECHNIGLASS

**Techniglass Corporation**  
80 Thompson Street  
N. Tonawanda, NY 14120 USA  
[www.techniglass.com](http://www.techniglass.com)

Toll Free: 800.564.9353  
Phone: 716.564.8888  
Fax: 716.564.8889