
	Work Instruction	
	VS Glow Housing Production	
Revision: 00	Procedure No.: WI-8.2.4.49	Date Effective: 6/11/2012

## General Guideline for VS Glow Housing Production


1. Pour VS Glow slip into plaster mold(s). Barrier ring(s) may be used to confine slip to certain areas of the mold. If making VSR mold,
2. Wait appropriate time for thickened slip to collect on plaster mold
3. Pour out excess slip from mold(s). Check first piece for proper thickness and adjust time in step 2 as necessary
4. Lightly brush out excess slip from mold to keep wall thickness constant
5. Assemble top mold piece(s) onto bottom mold piece. Ensure wires are in proper position and mold pieces fit completely. Apply slip as necessary to mate housing sections together
6. Temporarily fasten mold sections together
7. After appropriate amount of time, check and remove clay housing from mold
8. Lightly clean seam edges as is convenient
9. Clean mold
10. Allow housing to dry. Plastic may be used at the discretion of the supervisor or manager to keep heaters from drying too fast
11. Mounting heads
  - a. If mounting head is molded into housing, pour slip into head cavity and allow to dry completely. Repeat as necessary to achieve desired shape on housing cavity.
  - b. If mounting head is not molded into housing:
    - i. Assemble two CRB, CRC, CRM, CRL, or CRS heater top plaster molds
    - ii. Turn upside-down. Plug oval hole on bottom
    - iii. Pour slip into head, ensuring the entire head cavity is filled
    - iv. After appropriate amount of time, remove head from mold
    - v. Allow head to dry
    - vi. Clean edges, remove material at base of head until it is at the proper height and is level
    - vii. Apply slip to bottom of finished head and “glue” clay head onto clay housing at proper position(s)
12. Drill mounting/termination holes in housing
13. Fire housings per WI-8.2.4.30
14. Mark housings with kiln firing date and patent information
15. Glaze housings per WI-8.2.4.29
16. Fire housings per WI-8.2.4.30

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## Revision History

Revision Level	Date of Revision	Sections	Description of Change	Initial
00	6/11/2012	All	Initial Release	TCH

## Authorization

Position	Held By	Signature
Product Manager	Thomas Hittie	
Senior Management Representative	Abraham Joseph	