



Tools & supplies to make the beads above:

- ~ Lumiere Lusters Black Opal flakes
- ~ Lumiere Lusters stainless steel working container/funnel (optional)
- ~ Effetre transparent Black (064)
- ~ Effetre Super Clear (006)
- ~ Effetre White (204) stringer
- ~ 1/16-inch diameter mandrels
- ~ Straight-sided lentil brass press

Handy to have: a moist paper towel to clean up any flyaway flakes, your favorite working tools, stringer and/or murrini to adorn your creations.

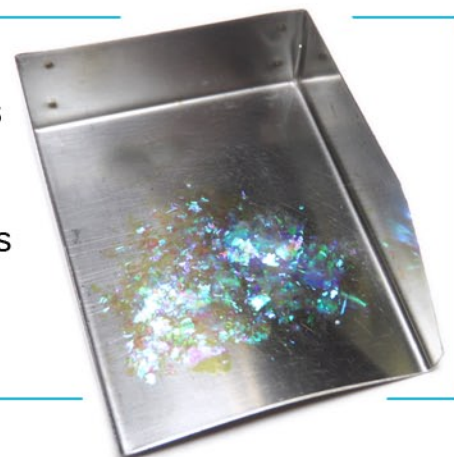
Before you begin: To start, take out a small amount of the lusters and place them in the working container, or a similar heatproof container. Spread the flakes out in a fairly even layer. Spreading them out evenly instead of leaving them in a pile gives the lusters maximum surface area in which to adhere to the molten glass when rolling.

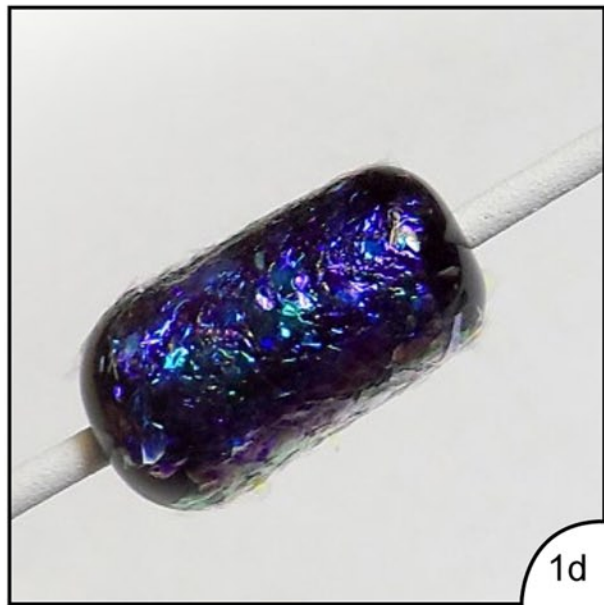
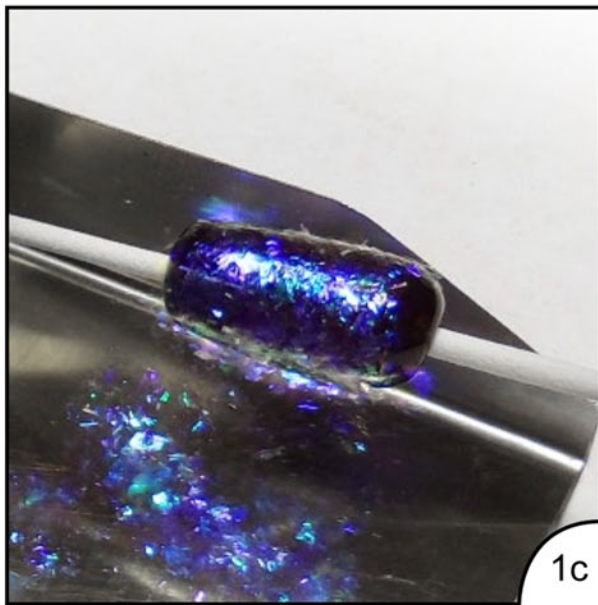
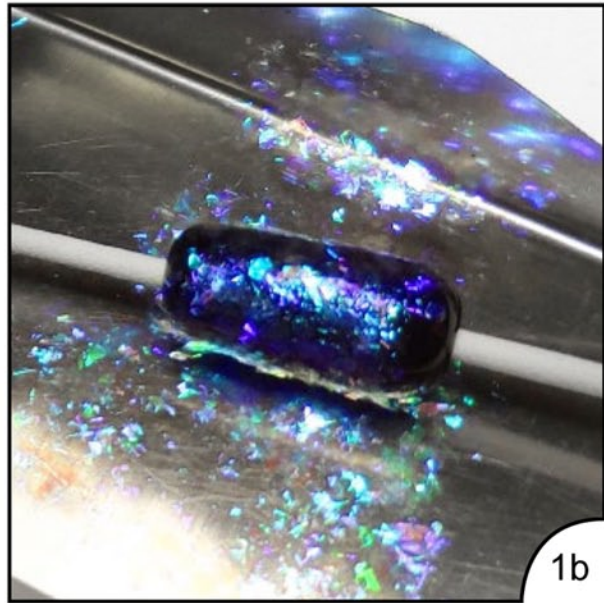
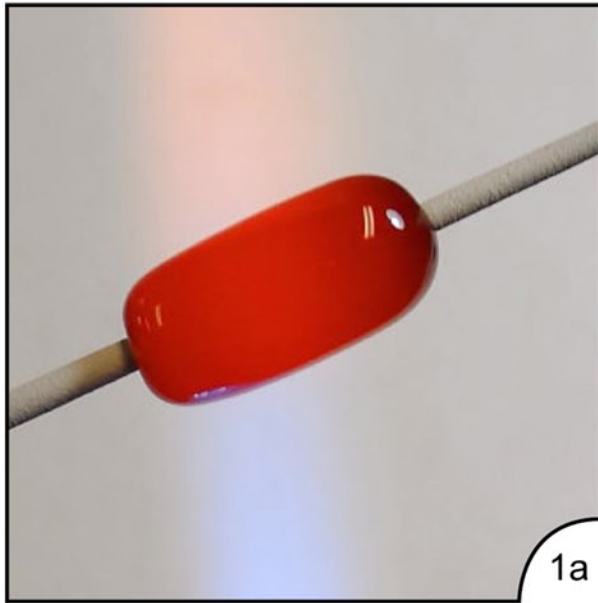


In this tutorial, I will take you through the process of successfully lamp-working JetAge Studio's Lumiere Lusters dichroic flakes in 104 coe soft glass. This method will work with our regular flakes, opal flakes, & powders.

Lumiere Lusters are a new metal oxide flake product that produces similar results to dichroic coatings and have their own design qualities unlike anything else. They can take quite a bit of heat, but like dichroic coatings, they are sensitive to overheating with direct flame, or prolonged working times. If you practice the techniques in this tutorial, you will be able to produce consistently beautiful results by discovering the best areas in your torch to work the lusters without burning them out.

Let's have some fun!

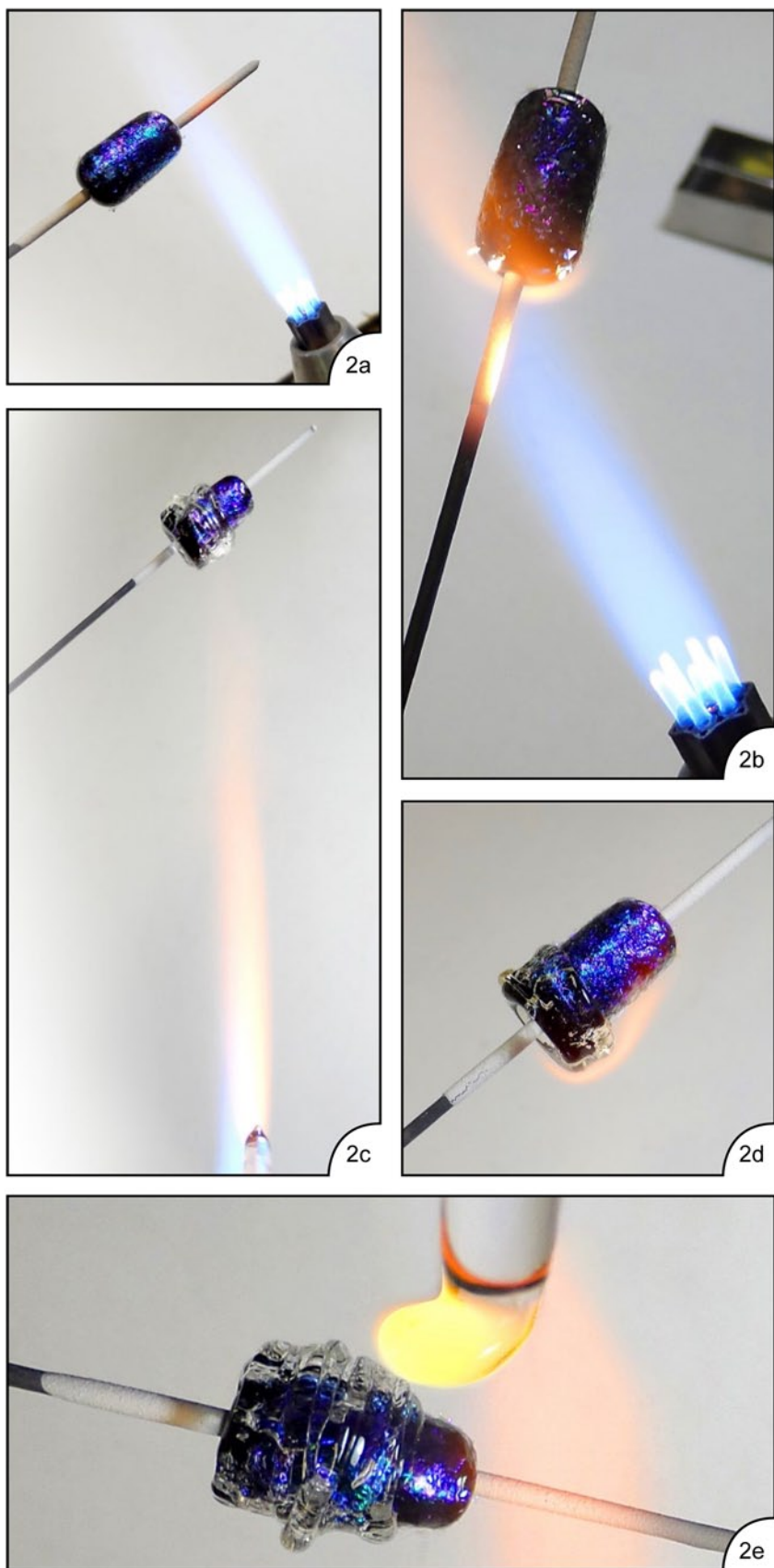




Steps 1a - 1d: Create your bead footprint to the size of the shaping tool you wish to use. For these beads I will be using a $\frac{3}{4}$ -inch straight-sided lenticular press, so I make my footprint about 2mm shy of the diameter of the cavity.

I like to use black because all the lustres look their best over dark bases, especially the opal series, such as the Black Opal Flakes I'm using here.

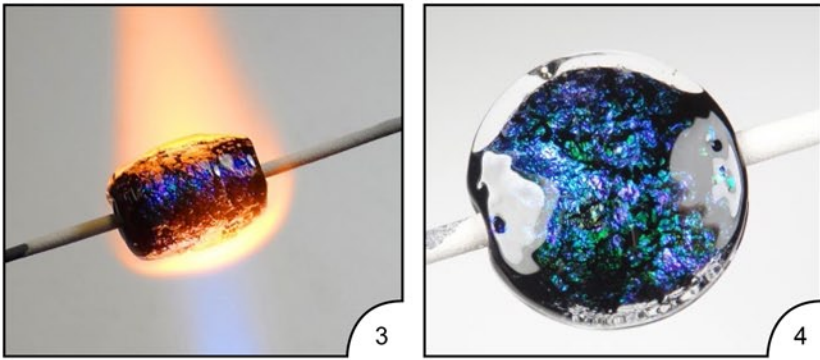
Once the footprint is evenly marvered, heat the glass to a medium to bright red, and quickly roll over the lustres back and forth to cover all of the footprint. Use the corner edge inside the luster container to marver down the flakes in a quick rolling motion. **Photo 1d** shows the footprint covered in the lustres.



Steps 2a – 2e: The next step is crucial to keeping the lusters bright & shimmery, but it does take a little practice. The trick is to work the coated bead high in the flame, & also concentrate heat at each bead hole end on the marver to keep the bead warm while preparing it for encasement. I tend to do my encasement in single revolutions around the bead & keep adding to the rounds as I go up, but if you have a favorite method of encasing, you can try it. But just be sure to keep the exposed lusters out of the flame until it is completely encased. **Photo 2c** shows where the bead should be at all stages of keeping the bead warm while heating up the clear for encasement.

While getting your encasing clear molten (closer to the face of the torch in the hottest part of the flame), keep the bead mandrel high in the flame (**photo 2c** shows relative height to the clear rod in the working heat). When the clear is molten, bring the bead down UNDERNEATH the flame (not through it), & quickly swipe the clear to begin encasement. **Photos 2c & 2d** show basically the same angle at which to keep the bead. Once you start encasing, only allow the encased area to be in the flame.

Keep working high in the flame while reheating the encasing clear rod in the hot part of the flame, & then make another revolution around the bead until it is completely covered. Again, work the bead under the flame while passing the clear rod through the flame to the bead underneath.



Step 3: The hard part is over! Once you have the bead totally encased, you can then smooth out the encasement layer by heating it just until it gets soft, & then help smooth it out by marvering. It is important to try to not let the bead get orange-hot to the core as higher temperatures may burn out the luster or fade the color.



Step 4: After your encasement is smoothed out, simply take the entire bead to no more than a medium heat & press the bead to shape it. You can then adorn your bead as you like. Also, it's important to know that the longer you work the bead, the more chance there is that the colors will fade as well, so try to keep torch time relatively short. Anneal your bead as usual. You're done! Now you can experiment with our many different colors of Lumiere Lusters!



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