

Every kiln measures temperature a little differently, and every project requires a slightly different firing schedule. Only experimentation will teach you exactly what schedules will produce exactly the results you want. To get you started with your experiments, here are some sample schedules. All these firing schedules are for COE 96 glass. For COE 90, add 20 degrees F (7C) to all top temperatures. For clear float glass add 50 degrees F (10C)

**SEG RAMP (dph) TEMP HOLD (min)**

**CASTING**

**Small open face mold (1/2" or thinner)**

1	800F (425C)	1460F (735C)	20
2	AFAP	960F (515C)	30
3	500F (260C)	300F (150C)	0

**Medium open face mold (1/2" to 3/4" thick)**

1	800F (425C)	1460F (735C)	20
2	AFAP	960F (515C)	60
3	200F (150C)	800F (425C)	10
4	400F (260C)	300F (150C)	0

**Large open face mold (1" to 1 1/2" thick)**

1	800F (425C)	1460F (735C)	20
2	AFAP	960F (515C)	90
3	200F (150C)	800F (425C)	10
4	300F (150C)	300F (150C)	0

**Larger open face mold (2" to 3" thick)**

1	800F (425C)	1460F (735C)	20
2	AFAP	960F (515C)	150
3	200F (150C)	800F (425C)	10
4	200F (150C)	300F (150C)	0

**DROP RING**

**Single layer**

1	500F (260C)	1200F (675C)	*
2	AFAP	960F (515C)	30
3	200F (95C)	800F (425C)	10
4	500F (260C)	300F (150C)	0

\* Hold time depends on depth of drop.

**Double layer**

1	400F (200C)	1250F (C)	*
2	AFAP	960F (515C)	60
3	200F (95C)	800F (425C)	10
4	400F (260C)	300F (150C)	0

\* Hold time depends on depth of drop.

**Basic Firing Schedules**

**SEG RAMP (dph) TEMP HOLD (min)**

**DRAPE – over a mold**

**Small single layer (up to 8")**

1	500F (260C)	1000F (535C)	20
2	900F (500C)	1200F (650C)	5
3	AFAP	960F (515C)	30
4	200F (95C)	800F (425C)	10
5	500F (260C)	300F (150C)	0

**Single layer 12" to 15"**

1	500F (260C)	1000F (535C)	20
2	900F (500C)	1150F (620C)	5
3	AFAP	960F (515C)	30
4	200F (95C)	800F (425C)	10
5	500F (260C)	300F (150C)	0

**Larger 16" and up**

1	500F (260C)	1000F (535C)	20
2	900F (500C)	1125F (605C)	5
3	AFAP	960F (515C)	45
4	200F (95C)	800F (425C)	10
5	500F (260C)	300F (150C)	0

**Double layer (not fused)**

1	300F (150C)	1000F (535C)	20
2	900F (500C)	1150F (620C)	10
3	AFAP	960F (515C)	60
4	200F (95C)	800F (425C)	10
5	300F (150C)	300F (150C)	0

**Double layer fused**

1	400F (200C)	1000F (535C)	20
2	900F (500C)	1150F (620C)	10
3	AFAP	960F (515C)	60
4	200F (95C)	800F (425C)	10
5	400F (200C)	300F (150C)	0

**SLUMP (into a mold)**

**Single layer – 1/8" (3mm) thick**

1	500F (260C)	1000F (535C)	20
2	900F (500C)	1250F (675C)	20
3	AFAP	960F (515C)	30
4	500F (250C)	300F (150C)	0

**Double layer – 1/4" (6mm) thick**

1	400F (200C)	1000F (535C)	20
2	900F (500C)	1250F (675C)	20
3	AFAP	960F (515C)	60
4	200F (95C)	800F (425C)	10
5	400F (200C)	300F (150C)	0

*For 3 layer projects reduce ramps to 300F (150C)*

## Basic Firing Schedules

**SEG RAMP (dph) TEMP HOLD (min)**

### TACK FUSE (just to fuse attach)

#### Jewelry Cabochons

1	800F (425C)	1360F (735C)	15
2	AFAP	960F (515C)	30
3	500F (260C)	300F (150C)	0

#### Small Projects (up to 8")

1	500F (260C)	1000F (535C)	15
2	900F (500C)	1360F (735C)	15
3	AFAP	960F (515C)	45
4	200F (95C)	800F (425C)	10
5	500F (260C)	300F (150C)	0

#### Medium Projects (8-12")

1	400F (200C)	1000F (535C)	20
2	900F (500C)	1360F (735C)	15
3	AFAP	960F (515C)	60
4	200F (95C)	800F (425C)	10
5	400F (200C)	300F (150C)	0

#### Larger Projects (over 12")

1	400F (200C)	1000F (535C)	20
2	200F (95C)	1150F (620C)	15
3	900F (500C)	1360F (735C)	15
4	AFAP	960F (515C)	60
5	200F (95C)	800F (425C)	10
6	400F (200C)	300F (150C)	0

*Slower ramp in segment 2 is to remove air bubbles*

#### Tack fuse with fire polish

1	400F (200C)	1000F (535C)	20
2	1200F (650C)	1325F (720C)	5
3	AFAP	960F (515C)	60
4	400F (200C)	300F (150C)	0

### FULL FUSE (to melt down to a single level)

#### Jewelry Cabochons

1	800F (425C)	1460F (795C)	15
2	AFAP	960F (515C)	30
3	800F (425C)	300F (150C)	0

#### Small Projects (up to 8") 2 layer

1	400F (200C)	1000F (535C)	15
2	900F (500C)	1460F (795C)	20
3	AFAP	960F (515C)	60
4	200F (95C)	800F (425C)	10
5	400F (200C)	300F (150C)	0

*For 3 layer projects reduce ramps to 300F (150C)*

**SEG RAMP (dph) TEMP HOLD (min)**

#### Medium Projects (8-12") 2 layer

1	400F (200C)	1000F (535C)	20
2	900F (500C)	1460F (735C)	15
3	AFAP	960F (515C)	60
4	200F (95C)	800F (425C)	10
5	400F (200C)	300F (150C)	0

*For 3 layer projects reduce ramps to 300F (150C)*

#### Larger Projects (over 12") 2 layer

1	400F (200C)	1000F (535C)	20
2	200F (95C)	1150F (620C)	15
3	900F (500C)	1460F (735C)	20
4	AFAP	960F (515C)	60
5	200F (95C)	800F (425C)	10
6	400F (200C)	300F (150C)	0

*For 3 layer projects reduce ramps to 300F (150C)*

*Slower ramp in segment 2 is to remove air bubbles*

## MELTS

#### Shelf Melt

1	600F (315C)	1460F (795C)	20
2	AFAP	960F (515C)	60
3	200F (150C)	800F (425C)	10
4	400F (200C)	300F (150C)	0

#### Shelf Melt (thicker than 1/4" – in mold)

1	500F (315C)	1460F (795C)	20
2	AFAP	960F (515C)	90
3	200F (150C)	800F (425C)	10
4	300F (150C)	300F (150C)	0

To calculate how much glass will be needed to produce a consistent 1/4" thick melt, measure out 1 lb of glass for every 32 square feet to be covered.

#### Screen Melt

1	800F (425C)	1600F (870C)	60
2	AFAP	1460F (795C)	30
3	AFAP	960F (515C)	60
4	200F (100C)	800F (425C)	10
5	300F (150C)	300F (150C)	0

- To refire a screen melt to either smooth out or attach to other glass, use the appropriate full fuse firing schedule.