



Glass Campus

Glass Casting Firing Schedules

Casting in a Ceramic Mold

SEGMENT	RAMP	TEMP	HOLD (min)	
1	800F (425C)	1460F (795C)	20	<i>ramp up & fuse</i>
2	FULL	960F (515C)	60	<i>anneal (longer for thicker)</i>
3	400F (200C)	300F (150C)	0	<i>ramp down (longer for thicker)</i>

Embossing

SEGMENT	RAMP	TEMP	HOLD (min)	
1	400F (200C)	1000F (517C)	20	<i>ramp up & hold (longer for thicker)</i>
2	850F (455C)	1460F (705C)	20	<i>ramp up to fuse/emboss</i>
3	FULL	960F (515C)	60	<i>anneal (longer for thicker)</i>
4	400F (200C)	300F (150C)	0	<i>ramp down (longer for thicker)</i>

Fire Polish

SEGMENT	RAMP	TEMP	HOLD (min)	
1	400F (200C)	1000F (517C)	20	<i>ramp up & hold (longer for thicker)</i>
2	1200F (650C)	1300F (705C)	4	<i>fire polish</i>
3	FULL	960F (515C)	60	<i>anneal (longer for thicker)</i>
4	400F (200C)	300F (150C)	0	<i>ramp down (longer for thicker)</i>

Freeze & Fuse

SEGMENT	RAMP	TEMP	HOLD (min)	
1	200F (95C)	400F (200C)	20	<i>ramp up & hold (to dry out)</i>
2	400F (200C)	1320F (715C)	35	<i>ramp up & fuse</i>
3	FULL	960F (515C)	60	<i>anneal (longer for thicker)</i>
4	200F (95C)	700F (370C)	0	<i>ramp down (longer for thicker)</i>
5	400F (200C)	300F (150C)	0	<i>ramp down</i>

*These firing schedules are for COE 96 glass.
For COE 90 glass add 20°F to all temperatures.
For clear float or architectural glass add 50°F.*