

## Specialty Firing Schedules

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

### CASTINGS fire polish only

1	400F (260C)	1000F (535C)	20
2	1200F (650C)	1300F (705C)	5
3	AFAP	960F (515C)	60
4	400F (260C)	300F (150C)	0

For thicker castings reduce ramp speed.

### TACK FUSE CASTINGS ONTO FLAT BASE

1	400F (260C)	1000F (535C)	20
2	1200F (650C)	1325F (720C)	5
3	AFAP	960F (515C)	60
4	200F (95C)	800F (425C)	10
5	400F (260C)	300F (150C)	0

- For castings 1/4" or thicker, decrease ramp speeds to 300F (95C).
- For castings 3/8" or thicker, decrease ramp speeds to 250F (95C).
- For castings 1/2" or thicker, decrease ramp speeds to 200F (95C).
- For castings 3/4" or thicker, decrease ramp speeds to 200F (95C).
- For castings 1" or thicker, decrease ramp speeds to 1500F (95C).

### TACK FUSE TO HOLD WIRE RINGS

1	500F (260C)	1350F (730C)	20
2	AFAP	960F (515C)	60
3	500F (260C)	300F (150C)	0

### SLUMP & FIRE POLISH TOGETHER

1	400F (260C)	1000F (535C)	20
2	1200F (650C)	1200F (650C)	15
3	1200F (650C)	1300F (705C)	6
4	AFAP	960F (515C)	60
5	200F (95C)	800F (425C)	10
6	400F (260C)	300F (150C)	0

### CERAMIC MOLDS (firing greenware)

1	100F (40C)	150F (65C)	0
2	200F (95C)	600F (315C)	0
3	300F (150C)	1200F (650C)	0
4	400F (200C)	1800F (980C)	0
5	AFAP	300F (150C)	0

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

### FLOAT GLASS MOSAIC (fuse & slump together)

1	500F (260C)	1000F (535C)	20
2	1200F (650C)	1400F (760C)	20
3	AFAP	1000F (535C)	60
4	400F (200C)	300F (150C)	0

### TEMPERED GLASS CULLET TACK FUSE

1	500F (260C)	1425F (775C)	20
2	AFAP	1000F (535C)	60
3	400F (200C)	300F (150C)	0

### TEMPERED GLASS CULLET SLUMP

1	250F (120C)	1000F (535C)	20
2	150F (65C)	1150F (620C)	10
3	900F (500C)	1250F (675C)	20
4	AFAP	1000F (535C)	60
5	250F (120C)	300F (150C)	0

### WEAVE STRIP SLUMP

1	400F (260C)	1000F (535C)	20
2	1000F (515C)	1350F (730C)	30
3	AFAP	960F (515C)	60
4	400F (260C)	300F (150C)	0

### WINE BOTTLE FLATTEN

1	400F (200C)	1000F (535C)	20
2	900F (500C)	1500F (815C)	30
3	AFAP	1000F (535C)	60
4	400F (200C)	300F (150C)	0

### WINE BOTTLE SLUMP

1	400F (200C)	1000F (535C)	20
2	900F (500C)	1400F (760C)	30
3	AFAP	1000F (535C)	60
4	400F (200C)	300F (150C)	0

### PATTERN BARS (1" thick)

1	400F (200C)	1460F (795C)	30
2	AFAP	960F (515C)	120
3	200F (95C)	800F (425C)	0
4	300F (150C)	300F (150C)	0