

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) | 1360F (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.