

## Automatic Ramp/Hold Programs for Fusing Images on Glass

When firing multiple times, add the decal image in the last firing and use a slump or tack temp. When firing and fusing glass all at the same in just one firing, you can use a Full Fuse.

If image fades... fire cooler, if it wipes off... fire hotter

### Full Fuse

Segment	Heating rate per hour	Temperature	Hold Time
1	150°F (66°C) /hour	960°F (516°C)	20 min
2	210°F (105°C) /hour	1250°F (677°C)	20 min
3	*9999° /hour (max heat rate)	1450°F (788°C)	10 min
4	*9999° /hour (max cool rate)	960°F (516°C)	2 hours
5	90°F (32°C) /hour	650°F (343°C)	10 min
	Natural cooling rate /hour	250°F (121°C) safe to open kiln	

### Slump or Tack Fire

Segment	Heating rate per hour	Temperature	Hold time
1	150°F (66°C) / hour	1000°F (538°C)	20 min
2	210°F (105°C) / hour	1250°F (677°C) slump 1300°F (704°C) tack	20 min
3	*9999° /hour (max cool rate)	960°F (516°C)	2 hours
4	90°F (32°C) / hour	650°F (343°C)	10 min
	Natural cooling rate/ hour	250°F(121°C) safe to open kiln	

\*In an automatic kiln 9999 ° is the default temperature for rapid heating or cooling