

All kilns heat/hold temperature differently and every glass COE requires a different schedule for projects. The recommendations we have in this document are recommendations only and may need alteration based on your project, glass type and kiln. These recommendations are for glass with a COE of 90, for Glass with a COE of 96 you would typically minus 20°F to all top temperatures. In addition, glass manufacturers have guidelines and schedules for firing reference so don't be afraid to reach out to them for assistance.

TACK FUSE (JUST TO FUSE ATTACH)

JEWELRY CABOCHONS

SEG	RAMP (DPH)	TEMP	HOLD (MIN)
1	800°F (425°C)	1380°F (735°C)	15
2	AFAP	900°F (482°C)	30
3	500°F (260°C)	300°F (150°C)	0

SMALL PROJECTS (UP TO 8 INCHES)

1	500°F (260°C)	1000°F (535°C)	15
2	900°F (485°C)	1380°F (735°C)	15
3	AFAP	900°F (482°C)	45
4	200°F (95°C)	800°F (425°C)	10
5	500°F (260°C)	300°F (150°C)	0

MEDIUM PROJECTS (8-12 INCHES)

1	400°F (205°C)	1000°F (535°C)	20
2	900°F (485°C)	1380°F (735°C)	15
3	AFAP	900°F (482°C)	60
4	200°F (95°C)	800°F (425°C)	10
5	400°F (205°C)	300°F (150°C)	0

LARGER PROJECTS (OVER 12 INCHES)

1	400°F (205°C)	1000°F (535°C)	20
2	200°F (95°C)	1150°F (620°C)	15
3	900°F (485°C)	1380°F (735°C)	15
4	AFAP	900°F (482°C)	60
5	200°F (95°C)	800°F (425°C)	10
6	400°F (205°C)	300°F (150°C)	0

Slower ramp in segment 2 is to remove air bubbles.

TACK FUSE WITH FIRE POLISH

SEG	RAMP (DPH)	TEMP	HOLD (MIN)
1	400°F (205°C)	1000°F (535°C)	20
2	1200°F (650°C)	1345°F (720°C)	5
3	AFAP	900°F (482°C)	60
4	400°F (205°C)	300°F (150°C)	0

FULL FUSE (MELT TO SINGLE LEVEL)

JEWELRY CABOCHONS

1	800°F (425°C)	1480°F (795°C)	15
2	AFAP	900°F (482°C)	30
3	800°F (425°C)	300°F (150°C)	0

SMALL PROJECTS (UP TO 8 INCHES) - 2 LAYER

1	400°F (205°C)	1000°F (535°C)	15
2	900°F (485°C)	1480°F (795°C)	20
3	AFAP	900°F (482°C)	60
4	200°F (95°C)	800°F (425°C)	10
5	400°F (205°C)	300°F (150°C)	0

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

MEDIUM PROJECTS (8-12 INCHES) - 2 LAYER

1	400°F (205°C)	1000°F (535°C)	20
2	900°F (485°C)	1480°F (795°C)	15
3	AFAP	900°F (482°C)	60
4	200°F (95°C)	800°F (425°C)	10
5	400°F (205°C)	300°F (150°C)	0

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

FULL FUSE (MELT TO SINGLE LEVEL) - CONTINUED

LARGER PROJECTS (OVER 12 INCHES) - 2 LAYER

SEG	RAMP (DPH)	TEMP	HOLD (MIN)
1	400°F (205°C)	1000°F (535°C)	20
2	200°F (95°C)	1150°F (620°C)	15
3	900°F (485°C)	1480°F (795°C)	20
4	AFAP	900°F (482°C)	60
5	200°F (95°C)	800°F (425°C)	10
6	400°F (205°C)	300°F (150°C)	0

For 3 layer projects reduce ramps to 300°F (150°C).
Slower ramp in segment 2 is to remove air bubbles.

MELTS

SHELF MELT

1	600°F (315°C)	1480°F (795°C)	20
2	AFAP	900°F (482°C)	60
3	200°F (95°C)	800°F (425°C)	10
4	400°F (205°C)	300°F (150°C)	0

SHELF MELT (THICKER THAN 1/4 INCH - IN MOLD)

1	500°F (260°C)	1480°F (795°C)	20
2	AFAP	900°F (482°C)	90
3	200°F (95°C)	800°F (425°C)	10
4	300°F (150°C)	300°F (150°C)	0

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

SCREEN MELT

1	800°F (425°C)	1620°F (870°C)	60
2	AFAP	1460°F (795°C)	30
3	AFAP	900°F (482°C)	60
4	200°F (95°C)	800°F (425°C)	10
5	300°F (150°C)	300°F (150°C)	0

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

CASTING

SMALL OPEN FACE MOLD (1/2 INCH OR THINNER)

SEG	RAMP (DPH)	TEMP	HOLD (MIN)
1	800°F (425°C)	1480°F (795°C)	20
2	AFAP	900°F (482°C)	30
3	500°F (260°C)	300°F (150°C)	0

MEDIUM OPEN FACE MOLD (1/2 TO 3/4 INCH THICK)

1	800°F (425°C)	1480°F (795°C)	20
2	AFAP	900°F (482°C)	60
3	200°F (95°C)	800°F (425°C)	10
4	400°F (205°C)	300°F (150°C)	0

LARGE OPEN FACE MOLD (1 TO 1-1/2 INCHES THICK)

1	800°F (425°C)	1480°F (795°C)	20
2	AFAP	900°F (482°C)	90
3	200°F (95°C)	800°F (425°C)	10
4	300°F (150°C)	300°F (150°C)	0

LARGE OPEN FACE MOLD (2 TO 3 INCHES THICK)

1	800°F (425°C)	1480°F (795°C)	20
2	AFAP	900°F (482°C)	150
3	200°F (95°C)	800°F (425°C)	10
4	200°F (95°C)	300°F (150°C)	0

DROP RING

SINGLE LAYER

1	500°F (260°C)	1220°F (650°C)	*
2	AFAP	900°F (482°C)	30
3	200°F (95°C)	800°F (425°C)	10
4	500°F (260°C)	300°F (150°C)	0

*Hold time depends on depth of drop.

DROP RING - CONTINUED

DOUBLE LAYER

SEG	RAMP (DPH)	TEMP	HOLD (MIN)
1	400°F (205°C)	1270°F (675°C)	*
2	AFAP	900°F (482°C)	60
3	200°F (95°C)	800°F (425°C)	10
4	400°F (205°C)	300°F (150°C)	0

*Hold time depends on depth of drop.

DRAPE - OVER A MOLD

SMALL SINGLE LAYER (UP TO 8 INCHES)

1	500°F (260°C)	1000°F (535°C)	20
2	900°F (485°C)	1220°F (650°C)	5
3	AFAP	900°F (482°C)	30
4	200°F (95°C)	800°F (425°C)	10
5	500°F (260°C)	300°F (150°C)	0

SINGLE LAYER (12 TO 15 INCHES)

1	500°F (260°C)	1000°F (535°C)	20
2	900°F (485°C)	1170°F (620°C)	5
3	AFAP	900°F (482°C)	30
4	200°F (95°C)	800°F (425°C)	10
5	500°F (260°C)	300°F (150°C)	0

LARGER (16 INCHES AND UP)

1	500°F (260°C)	1000°F (535°C)	20
2	900°F (485°C)	1145°F (605°C)	5
3	AFAP	900°F (482°C)	45
4	200°F (95°C)	800°F (425°C)	10
5	500°F (260°C)	300°F (150°C)	0

DOUBLE LAYER (NOT FUSED)

SEG	RAMP (DPH)	TEMP	HOLD (MIN)
1	300°F (150°C)	1000°F (535°C)	20
2	900°F (485°C)	1170°F (620°C)	10
3	AFAP	900°F (482°C)	60
4	200°F (95°C)	800°F (425°C)	10
5	300°F (150°C)	300°F (150°C)	0

DOUBLE LAYER (FUSED)

1	400°F (205°C)	1000°F (535°C)	20
2	900°F (485°C)	1170°F (620°C)	10
3	AFAP	900°F (482°C)	60
4	200°F (95°C)	800°F (425°C)	10
5	400°F (205°C)	300°F (150°C)	0

SLUMP - INTO A MOLD

SINGLE LAYER (1/8 INCH (3MM) THICK)

1	500°F (260°C)	1000°F (535°C)	20
2	900°F (485°C)	1270°F (675°C)	20
3	AFAP	900°F (482°C)	30
4	500°F (260°C)	300°F (150°C)	0

DOUBLE LAYER (1/4 INCH (6MM) THICK)

1	400°F (205°C)	1000°F (535°C)	20
2	900°F (485°C)	1270°F (675°C)	20
3	AFAP	900°F (482°C)	60
4	200°F (95°C)	800°F (425°C)	10
5	400°F (205°C)	300°F (150°C)	0

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