

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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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	960°F (515°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).