

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 96, for Glass with a COE of 90 you would typically add 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)	1360°F (735°C)	15
2	AFAP	950°F (510°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)	1360°F (735°C)	15
3	AFAP	950°F (510°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)	1360°F (735°C)	15
3	AFAP	950°F (510°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)	1360°F (735°C)	15
4	AFAP	950°F (510°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)	1325°F (720°C)	5
3	AFAP	950°F (510°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)	1460°F (795°C)	15
2	AFAP	950°F (510°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)	1460°F (795°C)	20
3	AFAP	950°F (510°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)	1460°F (795°C)	15
3	AFAP	950°F (510°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)	1460°F (795°C)	20
4	AFAP	950°F (510°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)	1460°F (795°C)	20
2	AFAP	950°F (510°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)	1460°F (795°C)	20
2	AFAP	950°F (510°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)	1600°F (870°C)	60
2	AFAP	1460°F (795°C)	30
3	AFAP	950°F (510°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)	1460°F (795°C)	20
2	AFAP	950°F (510°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)	1460°F (795°C)	20
2	AFAP	950°F (510°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)	1460°F (795°C)	20
2	AFAP	950°F (510°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)	1460°F (795°C)	20
2	AFAP	950°F (510°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)	1200°F (650°C)	*
2	AFAP	950°F (510°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)	1250°F (675°C)	*
2	AFAP	950°F (510°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)	1200°F (650°C)	5
3	AFAP	950°F (510°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)	1150°F (620°C)	5
3	AFAP	950°F (510°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)	1125°F (605°C)	5
3	AFAP	950°F (510°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)	1150°F (620°C)	10
3	AFAP	950°F (510°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)	1150°F (620°C)	10
3	AFAP	950°F (510°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)	1250°F (675°C)	20
3	AFAP	950°F (510°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)	1250°F (675°C)	20
3	AFAP	950°F (510°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).