



THE ULTIMATE ONLINE RESOURCE FOR
GLASS KILNFORMING ARTISTS IS AT

www.FusedGlass.Org

AN IMPORTANT MESSAGE ABOUT FUSING SCHEDULES:

Any "generic" schedule is meant as a starting point. Your project, your kiln, and your desired results are all variables that will likely be reasons to adjust this schedule. Remember to fuse and anneal for the thickest part of the glass. By using this schedule you agree that the final responsibility is yours and yours alone and under no circumstances will FusedGlass.Org, it's partners or owners be held responsible for the results of using this schedule.

| | |
|--------------|--------------------------|
| FIRING TYPE: | SLUMP |
| THICKNESS: | 1/8 inch / 3MM / 1 LAYER |
| SEGMENTS: | 5 |

ASSUMPTIONS FOR THIS SCHEDULE

This schedule assumes that you are slumping 1 layer of single thickness (1/8 inch) Bullseye glass. System 96 fusers should change the anneal hold temperature in segment 5 from 960 to 950.

This schedule makes assumptions regarding maximum heating and cooling rates of a glass kiln. All times are an approximation. **Kilns should NOT be fired unattended.**

| | |
|------------|----|
| START TEMP | 75 |
|------------|----|

| Seg | Rate (°F / HR) | Target Temp. | Soak (Hold) | Estimated Segment Time | |
|-----|-------------------|-----------------|----------------|------------------------------|---|
| 1 | 300 | 900 | 15 | 3:00 | The only goal for this segment (besides heating the glass) is to not thermal shock the pieces. If your glass is positioned especially close to your kiln's elements, if there are metal inclusions or iridized surfaces, or other characteristics that may interfere with even heating then you should consider slowing down this segment. The 15 minute hold at the end of the segment allows us to more completely burn off any glue, fiber paper binder or other organic material. |
| 2 | 100 | 1175 | 00 | 2:45 | Our final heating brings us to the process temperature - slumping at 1175° F where we do not soak the glass. Process temperatures are highly kiln dependant. You should adjust this temperature and hold time according to your kiln and the desired results. When slumping a single layer of glass, you may find that your hold time needs to be longer than thicker pieces because thinner pieces weigh less and sag more slowly. Also, it is easier to slump into larger areas than small, detailed areas. |
| 3 | 9999 | 960 | 30 | 1:13 | With our slumping complete, we now cool as rapidly as possible to our anneal hold at 960 degrees. The 30 minute soak at this stage allows the temperature to equalize throughout the glass. |
| 4 | 200 | 700 | 00 | 1:18 | We now begin our controlled anneal cooling. The goal of this segment is to allow our work to both contract and harden evenly throughout the glass while the glass returns to a completely solid state. |
| 5 | 400 | 100 | 00 | 4:48 | The goal of this segment is to cool the glass to room temperature without thermal shocking the glass. As with segment 1, if your glass is positioned closely to the heating elements, if it there are metal inclusions or iridized surfaces, or other characteristics that may interfere with even cooling then you should consider slowing down this segment. |
| 6 | 0 | 0 | 00 | -- | This segment is not used for this schedule. |
| 7 | 0 | 0 | 00 | -- | This segment is not used for this schedule. |
| 8 | 0 | 0 | 00 | -- | This segment is not used for this schedule. |

Total Elapsed 0d 13h 4m