



THE ULTIMATE ONLINE RESOURCE FOR  
GLASS KILNFORMING ARTISTS IS AT

[www.FusedGlass.Org](http://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:	<b>FREEZE AND FUSE</b>
THICKNESS:	varies
SEGMENTS:	<b>5</b>

**ASSUMPTIONS FOR THIS SCHEDULE**

This schedule assumes that you are performing a freeze and fuse firing and know how to set it up. 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	<b>75</b>
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Seg	Rate (°F / HR)	Target Temp.	Soak (Hold)	Estimated Segment Time	
1	600	1250	15	2:12	In this segment the water is evaporated out of the freeze and fuse pieces and the powder is lightly tack fused together. We heat the glass right to the process temperature - in this case 1250° F where we will soak for 15 minutes.
2	9999	1350	01	0:06	In this segment we are attempting to make the pieces more "glassy" and less "chalky" without deforming them by doing a light fire polish at 1350° F where we soak the glass for just 1 minute. You may choose to skip this segment, depending on your desired results. Process temperatures are highly kiln dependant. You should adjust this temperature and hold time according to your kiln and the desired results. The surface should become glossy with little rounding of the details in the pieces. It is important to minimize hold times in the range of 1350F° to 1450F° to avoid devitrification. This is the one case where it is better to adjust the temperature upwards than hold the process longer.
3	9999	960	30	1:28	With our fusing 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	100	700	00	2:36	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	300	100	00	4:48	The goal of this segment is to cool the glass to room temperature without thermal shocking the glass.
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 11h 11m**