Basic Firing Schedules

Bullseye Glass 2021

Programme your kiln with confidence using our tried and tested firing schedules, developed to make the process as simple as possible. Each kiln fires differently so use these schedules as a helpful guide.

Basic Full Fuse

For up to 50cm squares with an even thickness of 6mm

Runtime: 12 hr	Rate	Temp	Hold
Segment 1	222°C/hr (400°F)	→ 677°C (1250°F)	30 min
Segment 2	333°C/hr (600°F)	→ **804°C** (1480°F)	10 min
Segment 3	999°C/hr (999°F)	→ 482°C (900°F)	1 hr
Segment 4	83°C/hr (150°F)	→ 371°C (700°F)	End

Basic Slump*

For non-complex moulds.
**See our website for individual mould schedules*

Runtime: 12 hr	Rate	Temp	Hold
Segment 1	167°C/hr (300°F)	→ **640°C** (1184°F)	10 min (variable)
Segment 2	999°C/hr (999°F)	→ 482°C (900°F)	1 hr
Segment 3	56°C/hr (100°F)	→ 371°C (700°F)	End

Basic Tack/Contour

*Use a Process Temp of **780°C** for a Contour Fuse*

Runtime: 12 hr	Rate	Temp	Hold
Segment 1	222°C/hr (400°F)	→ 677°C (1250°F)	30 min
Segment 2	333°C/hr (600°F)	→ **760°C** (1400°F)	10 min
Segment 3	999°C/hr (999°F)	→ 482°C (900°F)	2 hr
Segment 4	83°C/hr (150°F)	→ 371°C (700°F)	End

Super Bubble Squeeze

Use this firing to avoid unwanted bubbles

Runtime: 12 hr	Rate	Temp	Hold
Segment 1	222°C/hr (400°F)	→ 600°C (1112°F)	30 min
Segment 2	111°C/hr (200°F)	→ 677°C (1250°F)	1 hr
Segment 3	333°C/hr (600°F)	→ **804°C** (1480°F)	10 min
Segment 4	999°C/hr (999°F)	→ 482°C (900°F)	1 hr
Segment 5	83°C/hr (150°F)	→ 371°C (700°F)	End

Ideal Process Temperature for Full Fuse

Kiln	Ideal Process Temperature
Skutt Firebox 8	→ **804°C** (1480°F)
Skutt Hotstart Pro	→ **795°C** (1463°F)
Skutt Firebox 14	→ **790°C** (1454°F)
Paragon SC2	→ **804°C** (1480°F)
Kilncare Hobbyfuser	→ **795°C** (1463°F)
Kilncare Cubfuser	→ **804°C** (1463°F)
Kilncare Profuser	→ **800°C** (1472°F)
Kilncare Profuser D	→ **800°C** (1472°F)
Nabertherm GF240	→ **810°C** (1490°F)

Based on our own test results. If your kiln is not shown, we recommend using our Kiln Test Kit to calibrate your kiln.

What is a segment?

A segment is made of three parts:

1. **RATE/RAMP:**
   Temperature rise/fall in degrees per hr
2. **TEMP:**
   The heat you want to reach
3. **HOLD:**
   How long you want to stay there

A programme is made of several segments in a row. Segments can be identified in the following order:

- Heat to Bubble Squeeze
- Heat to Process Temperature
- Cool to Annealing Hold
- Cool to Room Temperature

Recommended Adjustments

A slower heat to bubble squeeze is required for thick projects or when using inclusions that may need burning out or slower heating, such as metals, paints or decals.

Adjusting the process temperature or hold time will achieve different surface and edge finishes, especially in the Tack/Contour fuse.

Adjust annealing time according to the project's thickness and complexity. If you get cracks or bubbles, fire slower, lower, longer.

Working on Thicker Projects?

For pieces that are thicker than 6mm or uneven in thickness, a longer annealing phase is required. See our Annealing Charts PDF for more information and firing schedules.

Looking for more free tips & advice?

Visit our Knowledge Base on our website for a wealth of information: **www.warm-glass.co.uk**