

## Oceanside Compatible™ (System 96®) Firing Schedules - Celsius

Temperatures and hold times in the following schedules should be considered starting points; you will want to adjust them as necessary to achieve your desired effects. (See Forming Stages below for additional guidance.) Please keep in mind that no one firing schedule will work for all projects. Specifics such as project size, number of layers, style of glass, desired finished shape and texture should all be considered when choosing the right firing schedule.

| Advanced 8-Segment Full Fuse Profile |      |                   |             |
|--------------------------------------|------|-------------------|-------------|
| Step                                 | Rate | <u>Temp (</u> ºC) | Hold (mins) |
| 1                                    | 139  | 121               | 30          |
| 2                                    | 139  | 566               | 30-60       |
| 3                                    | 139  | 677               | 10-30       |
| 4                                    | 139  | 732-743           | 20          |
| 5                                    | 167  | 796*              | 10*         |
| 6                                    | 999  | 510               | 60          |
| 7                                    | 111  | 427               | 10          |
| 8                                    | 167  | 38                | 0           |

2 solid layer + design projects benefit from longer holds to reduce bubbles

| Basic Full Fuse Profile |      |           |             |
|-------------------------|------|-----------|-------------|
| Step                    | Rate | Temp (ºC) | Hold (mins) |
| 1                       | 139  | 566       | 30          |
| 2                       | 139  | 677       | 20          |
| 3                       | 167  | 796*      | 10*         |
| 4                       | 999  | 510       | 60          |
| 5                       | 111  | 427       | 10          |
| 6                       | 167  | 38        | 0           |

<sup>\*</sup>Adjust schedule here to attain different forming results

| Basic Slump Fuse Profile |      |           |             |
|--------------------------|------|-----------|-------------|
| Step                     | Rate | Temp (°C) | Hold (mins) |
| 1                        | 139  | 121       | 15          |
| 2                        | 139  | 566       | 30          |
| 3                        | 83   | 663*      | 10*         |
| 4                        | 222  | 510       | 60          |
| 5                        | 111  | 427       | 10          |
| 6                        | 167  | 38        | 0           |

\*Adjust schedule here to attain different forming results

| Basic Tack Fuse Profile |      |           |             |
|-------------------------|------|-----------|-------------|
| Step                    | Rate | Temp (°C) | Hold (mins) |
| 1                       | 139  | 566       | 30          |
| 2                       | 139  | 677       | 20          |
| 3                       | 167  | 738*      | 10*         |
| 4                       | 999  | 510       | 60          |
| 5                       | 111  | 427       | 10          |
| 6                       | 167  | 38        | 0           |

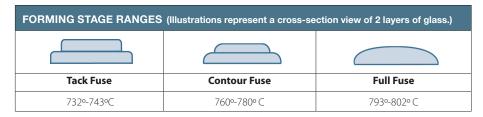
<sup>\*</sup>Adjust schedule here to attain different forming results

## Oceanside Compatible Forming Stages

Forming Stages information is provided to help users understand the melting characteristics of Oceanside Compatible products. The temperatures provided are estimates for common kilns firing a project about 12-inches (30 cm) diameter or square, consisting of two full glass layers and a third design layer (fired thickness about 1/4-inch (6mm)).

Use these guidelines as a starting place, then make adjustments to obtain the desired results for your specific project using your unique equipment. Temperatures are given in degrees Celsius.

| DESCRIPTION  | BEHAVIOR  |           |
|--------------|---|-----------|
| Slump        | Previously fused project softens and slumps to take the shape of a selected form or mold.   |           |
| Tack Fuse    | Separate glass layers are fused together with little deformation beyond softening or rounding of edges.   | 732°-743° |
| Contour Fuse | Separate glass layers are fused together, edges are soft and rounded, project surface retains a degree of dimension desired by the artist. (Any degree beyond Tack but not yet Full fused.) | 760°-780° |
| Full Fuse    | Separate glass layers are completely conjoined into a single uniform layer, top surface is smooth and void of dimension or relief.  | 793°-802° |
| Combing      | Recommended temperature for a 3/8-inch thick combing.   | 904°-927° |



| STRAIN POINT* | ANNEAL POINT* | SOFTENING POINT |
|---------------|---------------|-----------------|
| 476 (+/- 6)   | 513 (+/- 6)   | 680 (+/- 6)     |

<sup>\*</sup> At the Anneal Point of a glass, internal stresses are largely relieved in a matter of minutes. At the Strain Point, internal stresses are substantially relieved in a matter of hours.

<sup>\*</sup>Adjust schedule here to attain different forming results