



Oceanside Compatible® (System 96®) Firing Schedules - Fahrenheit

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	Temp (°F)	Hold (mins)
1	250	250	30
2	250	1050	30-60
3	250	1250	10-30
4	250	1350-1370	20
5	300	1465*	10*
6	9999	950	60
7	200	800	10
8	300	100	0

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

*Adjust schedule here to attain different forming results

Basic Slump Fuse Profile			
Step	Rate	Temp (°F)	Hold (mins)
1	250	250	15
2	250	1050	30
3	150	1225*	10*
4	400	950	60
5	200	800	10
6	300	100	0

*Adjust schedule here to attain different forming results

Basic Full Fuse Profile			
Step	Rate	Temp (°F)	Hold (mins)
1	250	1050	30
2	250	1250	20
3	300	1465*	10*
4	9999	950	60
5	200	800	10
6	300	100	0

*Adjust schedule here to attain different forming results

Basic Tack Fuse Profile			
Step	Rate	Temp (°F)	Hold (mins)
1	250	1050	30
2	250	1250	20
3	300	1360*	10*
4	9999	950	60
5	200	800	10
6	300	100	0

*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 Fahrenheit.

DESCRIPTION	BEHAVIOR	TEMP
Slump	Previously fused project softens and slumps to take the shape of a selected form or mold.	1225°-1250°
Tack Fuse	Separate glass layers are fused together with little deformation beyond softening or rounding of edges.	1350°-1370°
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.)	1400°-1440°
Full Fuse	Separate glass layers are completely conjoined into a single uniform layer, top surface is smooth and void of dimension or relief.	1460°-1475°
Combing	Recommended temperature for a 3/8-inch thick combing.	1660°-1700°

FORMING STAGE RANGES (Illustrations represent a cross-section view of 2 layers of glass.)		
Tack Fuse	Contour Fuse	Full Fuse
1350-1370° F	1400-1450° F	1460°-1470° F

STRAIN POINT*	ANNEAL POINT*	SOFTENING POINT
890 (+/- 10)	955 (+/- 10)	1255(+/- 10)

* 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.