oceanside GLASS & TILE®

CELSIUS

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

Please note: the schedules below are guidelines only, not strict rules. Times and temperatures may be adjusted based on the nature of your project. To use these schedules for slumping thick projects, choose the appropriate thickness then set the target temperature in the "variable" step to 668 - 678 depending on your desired results.

32mm Thick			
Step	**Rate**	**Temp (ºC)**	**Hold (mins)**
1	56	150	15
2	139	570	10
3	*variable	815	desired effect
4	9999	510	90
5	56	425	10
6	167	40	0

*This rate varies based on what you want to accomplish. For instance, heat faster to fire polish, slower to minimize air bubbles.

38mm Thick			
Step	**Rate**	**Temp (ºC)**	**Hold (mins)**
1	56	150	25
2	111	315	25
3	167	570	20
4	*variable	815	desired effect
5	9999	510	180
6	7	425	15
7	13	370	10
8	67	40	0

*This rate varies based on what you want to accomplish. For instance, heat faster to fire polish, slower to minimize air bubbles.

25mm Thick			
Step	**Rate**	**Temp (ºC)**	**Hold (mins)**
1	56	150	25
2	111	315	25
3	167	570	20
4	*variable	815	desired effect
5	9999	510	180
6	17	425	15
7	28	370	10
8	139	40	0

*This rate varies based on what you want to accomplish. For instance, heat faster to fire polish, slower to minimize air bubbles.

51mm Thick			
Step	**Rate**	**Temp (ºC)**	**Hold (mins)**
1	56	150	40
2	111	315	40
3	167	570	30
4	*variable	815	desired effect
5	9999	510	240
6	4	425	30
7	9	370	30
8	36	40	0

*This rate varies based on what you want to accomplish. For instance, heat faster to fire polish, slower to minimize air bubbles.

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