

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

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 1235 - 1250 depending on your desired results.

1/2-inch Thick			
Step	Rate	Temp (°F)	Hold (mins)
1	100	300	15
2	250	1050	10
3	*variable	1500	desired effect
4	9999	950	90
5	100	800	10
6	300	100	0

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

1.5-inch Thick			
Step	Rate	Temp (°F)	Hold (mins)
1	100	300	25
2	200	600	25
3	300	1050	20
4	*variable	1500	desired effect
5	9999	950	180
6	12	800	15
7	24	700	10
8	120	100	0

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

1-inch Thick			
Step	Rate	Temp (°F)	Hold (mins)
1	100	300	15
2	200	600	15
3	300	1050	15
4	*variable	1500	desired effect
5	9999	950	120
6	30	800	15
7	50	700	10
8	250	100	0

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

2-inch Thick			
Step	Rate	Temp (°F)	Hold (mins)
1	100	300	40
2	200	600	40
3	300	1050	30
4	*variable	1500	desired effect
5	9999	950	240
6	8	800	30
7	16	700	30
8	65	100	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
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.		