








Slumpy's would like to recommend a firing schedule to prolong the life of your Slumpy's Molds. Below are instructions for firing your 12" dia. or less Slumpy's mold and 12" dia. x 3/8" 96 COE glass. Please prepare to adjust the firing program as needed for your specific kiln, size of project, and type of glass.

## Slumpy's Firing Guide

Process	Description	Temp °F	Cone
<b>Full Fusing Kiln Casting</b>	With using heat and time, merging two or more layers of glass in in of any size or shape to form one solid smooth piece.	1450-1550	014
<b>Contour Fusing</b>	Using a lower temperature than a Full Fuse; to conjoin layers of glass enough so that the individual characteristics of the glass pieces remain and are smooth at the edges.	1380-1440	016
<b>Tack Fusing</b>	Using a lower temperature than a Contour Fuse; to conjoin layers of glass enough so that the individual characteristics of the glass piece remain somewhat intact.	1350-1370	017
<b>Fire Polishing</b>	Heating glass enough to heat the glass surface; creating rounded edges and providing a shiny appearance.	1300-1400	017
<b>Slumping</b>	Conforming glass to a shape by either sinking into a mold with heat, gravity, and time.	1200-1300	019
<b>Draping</b>	Conforming glass to a shape by bending it over the backside of a mold with heat, gravity, and time. In most cases the mold is stainless steel because of its coefficient of expansion with glass.	1140-1240	020

### Slumpy's Firing Schedule:

These schedules focus on a slow ramp up and ramp down. The life mold is prolonged by gradual changes in temperature. This schedule will also protect your glass from bubbles and devertification. Please refrain from opening your kiln until the temperature is below 100 °F

<b>Full Fuse</b>	Segment	1	2	3	4	5	6	7	8	
	Rate (F/HR)	400	400	600	600	9999*	90	120	400	
	Temp (F)	1000	1150	1250	1480	1000	960	750	100	
	Hold Time (Hr.Min)	00.20	00.15	00.20	00.20	00.60	00.60	00.10	00.00	
<b>Contour Fuse</b>	Segment	1	2	3	4	5	6	7	8	
	Rate (F/HR)	400	400	600	750	9999*	90	120	400	
	Temp (F)	1000	1150	1250	1440	1000	960	750	100	
	Hold Time (Hr.Min)	00.20	00.15	00.20	00.20	00.60	00.60	00.10	00.00	
<b>Tack Fuse</b>	Segment	1	2	3	4	5	6	7	8	
	Rate (F/HR)	400	400	600	850	9999*	90	120	400	
	Temp (F)	1000	1150	1250	1325	1000	960	750	100	
	Hold Time (Hr.Min)	00.20	00.15	00.20	00.20	00.60	00.60	00.10	00.00	
<b>Slump</b>	Segment	1	2	3	4	5	6	7	8	
	Rate (F/HR)	400	400	400	600	9999*	90	120	400	
	Temp (F)	750	1000	1150	1240	1000	960	750	100	
	Hold Time (Hr.Min)	00.10	00.20	00.15	00.20	00.60	00.60	00.10	00.00	
<b>Drape</b> <small>Recommended for Drape Molds &amp; Stainless Molds</small>	Segment	1	2	3	4	5	6	7	8	
	Rate (F/HR)	400	400	400	600	9999*	90	120	400	
	Temp (F)	750	1000	1150	1200	1000	960	750	100	
	Hold Time (Hr.Min)	00.10	00.20	00.15	00.10	00.60	00.60	00.10	00.00	

\*Means as fast as possible