








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
Full Fusing Kiln Casting	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
Contour Fusing	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
Tack Fusing	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
Fire Polishing	Heating glass enough to heat the glass surface; creating rounded edges and providing a shiny appearance.	1300-1400	017
Slumping	Conforming glass to a shape by either sinking into a mold with heat, gravity, and time.	1200-1300	019
Draping	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

Full Fuse	Segment	1	2	3	4	5	6	7	8	
	Rate (F/HR)	300	300	600	600	9999*	90	120	300	
	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	
Contour Fuse	Segment	1	2	3	4	5	6	7	8	
	Rate (F/HR)	300	300	600	750	9999*	90	120	300	
	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	
Tack Fuse	Segment	1	2	3	4	5	6	7	8	
	Rate (F/HR)	300	300	600	850	9999*	90	120	300	
	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	
Slump	Segment	1	2	3	4	5	6	7	8	
	Rate (F/HR)	300	300	300	600	9999*	90	120	300	
	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	
Drape <small>Recommended for Drape Molds & Stainless Molds</small>	Segment	1	2	3	4	5	6	7	8	
	Rate (F/HR)	300	300	300	600	9999*	90	120	300	
	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