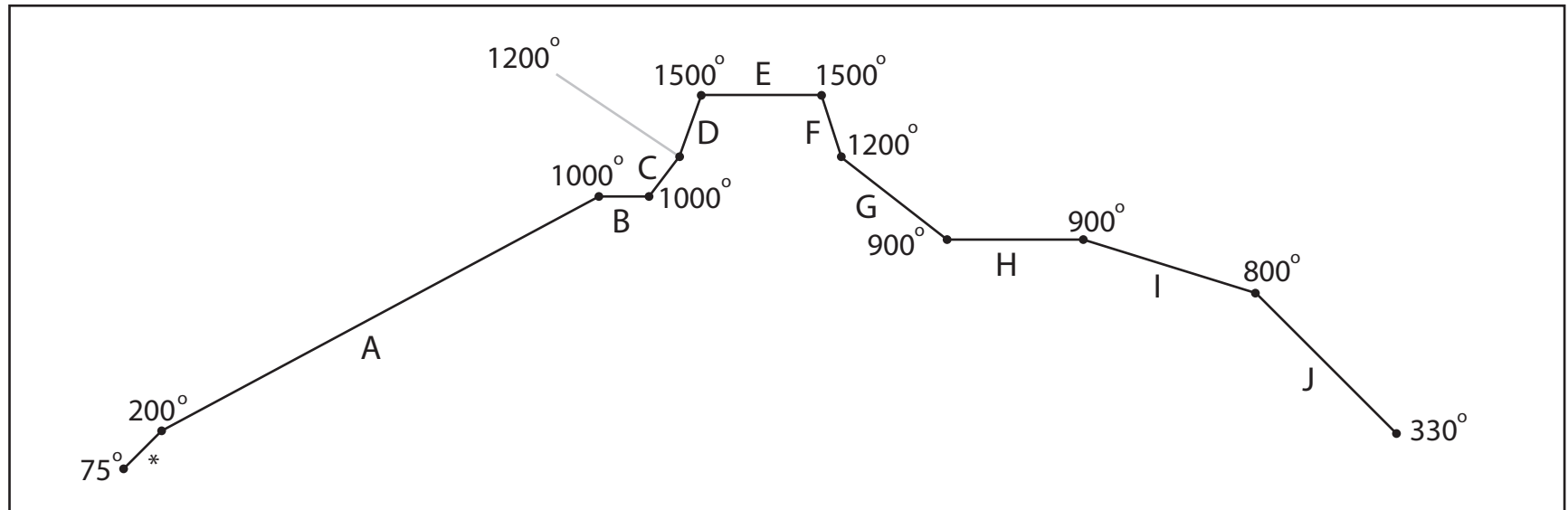


Curing, Firing & Annealing Chart



Glass Thickness	A Mold Curing	B Kiln Soak	C Quartz Inv.	E Spike	E Casting Temp	F Crash	G*** Anti-Shrink	H Soak	I Slow Cool	J Fast Cool
1"- 1.5"	100°/hr	2	2-4 hrs.	AFAP**	****	AFAP	2-4 hrs.	2-6 hrs	12°/hr	40-50°/hr
2"- 2.5"	75°/hr	2	2-4 hrs.	AFAP**	****	AFAP	3-5hrs.	6-8 hrs	5-7°/hr	18-30°/hr
3"- 4"	50°/hr	4	2-4 hrs.	AFAP**	****	AFAP	6-8 hrs.	8-12 hrs	1.5-3°/hr	7-12°/hr
4"- 6"	37.5°/hr	4	2-4 hrs.	AFAP**	****	AFAP	8-10 hrs.	12-20 hrs	.75-1.5°/hr	3.5-7°/hr
6"- 8"	25°/hr	4	2-4 hrs.	AFAP**	****	AFAP	10-12 hrs.	20-28 hrs	.4-.75°/hr	1.75-3.5°/hr

* Quartz Inversion: sudden expansion of silica around 1100° F.
Go slowly through this range to prevent uneven expansion and cracking in mould.

** As Fast As Possible (AFAP)

*** Prevents shrinkage in fully-encased castings. Not needed on many open-face molds.

**** Until desired affect is achieved (finish casting), + 30 min.