



System 96® Forming Stages (Fahrenheit)


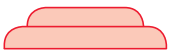

Forming Stages information is provided to help users understand the melting characteristics of System 96 products. The temperatures provided are estimates for common kilns firing a project about 12-inches (30 cm) diameter or square, consisting of two full glass layers and a third design layer (fired thickness about 1/4-inch (6mm)).

Use these guidelines as a starting place, then make adjustments to obtain the desired results for your specific project using your unique equipment.

Temperatures are given in degrees Fahrenheit.

DESCRIPTION	BEHAVIOR	TEMP
Slump	Previously fused project softens and slumps to take the shape of a selected form or mold.	1225°-1250°
Tack Fuse	Separate glass layers are fused together with little deformation beyond softening or rounding of edges.	1350°-1370°
Contour Fuse	Separate glass layers are fused together, edges are soft and rounded, project surface retains a degree of dimension desired by the artist. (Any degree beyond Tack but not yet Full fused.)	1400°-1440°
Full Fuse	Separate glass layers are completely conjoined into a single uniform layer, top surface is smooth and void of dimension or relief.	1460°-1475°
Combing	Recommended temperature for a 3/8-inch thick combing.	1660°-1700°

Forming Stage Ranges (Illustrations represent a cross-section view of 2 layers of glass.)

		
Tack Fuse	Contour Fuse	Full Fuse
1350-1370° F	1400-1450° F	1460°-1470° F

Technical Data	Strain Point*	Anneal Point*	Softening Point
Fahrenheit:	890 (+/- 10)	955 (+/- 10)	1255(+/- 10)
Celsius:	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.