

Kiln Casting Guidelines: 1/2" - 8" (12mm - 203mm)

Kiln Casting Guidelines: 1/2" - 8" (12mm - 203mm)														
Heating					Annealing & Cooling									
Step 1		Step 2			Step 3		Step 4		Step 5		Step 6			
Target Temps		1250° F 677° C		1465° F - 1500° F 796° C - 816° C			930° F 496° C		775° F 413° C		600° F 316° C		100° F 38° C	
Maximum Thickness	Ramp Rate (per hour)	Hold (minutes)	Ramp Rate (per hour)	Hold (minutes)	Ramp Rate (per hour)	Hold (minutes)	Ramp Rate (per hour)	Hold (minutes)	Ramp Rate (per hour)	Hold (minutes)	Ramp Rate (per hour)	Hold (minutes)		
1/2" 12 mm	225° F 122° C	75	275° F 153° C	*Variable	AFAP	120	100° F 55° C	10	200° F 111° C	10	250° F 139° C	0		
3/4" 19 mm	200° F 111° C	90	225° F 122° C	*Variable	AFAP	180	50° F 28° C	10	100° F 55° C	10	200° F 111° C	0		
1" 25 mm	175° F 97° C	100	175° F 97° C	*Variable	AFAP	240	25° F 14° C	10	45° F 25° C	10	150° F 83° C	0		
1.5" 38 mm	150° F 83° C	150	150° F 83° C	*Variable	AFAP	360	12° F 6.7° C	45	24° F 13° C	10	75° F 42° C	0		
2" 51 mm	125° F 69° C	180	125° F 69° C	*Variable	AFAP	480	7° F 3.9° C	60	14° F 7.8° C	10	42° F 23° C	0		
3" 76 mm	100° F 56° C	225	100° F 56° C	*Variable	AFAP	720	3° F 1.7° C	120	5.4° F 3.1° C	30	18° F 10° C	0		
4" 102 mm	75° F 42° C	270	75° F 42° C	*Variable	AFAP	960	1.5° F 0.8° C	300	3° F 1.7° C	45	9° F 5° C	0		
5" 127 mm	68° F 38° C	310	68° F 38° C	*Variable	AFAP	1200	1.2° F 0.7° C	375	2.4° F 1.3° C	60	7.2° F 4° C	0		
6" 152 mm	60° F 33° C	345	60° F 33° C	*Variable	AFAP	1440	0.8° F 0.4° C	450	1.3° F 0.76° C	150	4.5° F 2.5° C	0		
7" 178 mm	55° F 31° C	380	55° F 31° C	*Variable	AFAP	1680	0.6° F 0.3° C	525	1.0° F 0.58° C	225	3.4° F 1.9° C	0		
8" 203 mm	50° F 28° C	415	50° F 28° C	*Variable	AFAP	1920	0.4° F 0.2° C	600	0.76° F 0.42° C	300	2.4° F 1.3° C	0		

*Variable means hold at desired Temp and Time for desired look