<u>Please read the Kiln Safety and General Firing Guidelines before programming your kiln.</u>

The Glass Fire Mode was designed to give beginners a starting point for their Fusing, Tack Fusing, and Slumping Projects. Using information from glass artists and manufacturers we developed preset firing programs based on the size of the piece and the type of process desired. There are many other variables that can effect the success of a firing project such as position in the kiln, accuracy of the thermocouple, strength of the elements and many others that relate to the properties of the glass. So please use the GlassMaster Firing Mode with this in mind. For more advanced projects you may want to design your own firing program using the Ramp and Hold Mode.

FAST	1/8" THICK - 18" DIAMETER OR SMALLER 1/4" THICK - 4" DIAMETER OR SMALLER 3/8" THICK - NOT RECOMMENDED
MEDIUM	1/8" THICK - 20" DIAMETER OR SMALLER 1/4" THICK - 8" DIAMETER OR SMALLER 3/8" THICK - 5" DIAMETER OR SMALLER
SLOW	1/8" THICK - 24" DIAMETER OR SMALLER 1/4" THICK - 18" DIAMETER OR SMALLER 3/8" THICK - 12" DIAMETER OR SMALLER 1/2" THICK - 8" DIAMETER OR SMALLER

The program asks for 2 pieces of data, **Speed** and **Process (process refers to whether the piece is to be (Slumped, Tack Fused or Full Fused).** Use the guidelines in the table above to determine the proper firing Speed for your project. When a speed is chosen, the controller will set the Heating and Annealing portions of the program. When the process is selected the controller adjusts the 2 process segments of the program based on the process you select. For a complete list of Glass Fire Mode programs see the following page. To modify the peak temperature and hold times of these programs see the Modify Glass Fire menu instructions on page 17.

Glass Fire Mode Programming Steps

<u>Step 1</u> From Idle (IdLE) mode, press **Glass Fire**	*(Kiln is in Idle mode when display is flashing "IdLE". If the kiln is reading "PF" press ENTER to return to Idle mode.)* Display will read **SPd**(Speed).
<u>Step 2</u> Press **CYCLE** key to toggle to one of the 3 firing speeds, either SLOW, MEd (Medium), or FAST. Press ENTER.	Display will read PROC (Process).
<u>Step 3</u> Press the CYCLE key to toggle to one of the 3 firing processes, either SLMP (Slump), TAC (Tack Fuse) or FULL (Full Fuse),. Press ENTER.	Display will revert to Idle mode If the display reads °F it is in Modify Glass Fire Mode. See instructions on page 17 regarding "Modify Glass Fire".
<u>Step 4</u> Press REVIEW to verify the correct program has been entered. Press START.	After pressing review the display will flash all the data entered. After pressing START the kiln will begin firing and display the internal temperature of the kiln. (If a Delay Start is programmed the display will begin counting down from the Delay time set).
<u>Step 5</u> When the kiln reaches the process temperature hold, visually inspect the glass and press ADD TEMP, ADD TIME, or ANNEAL NOW if needed.	The process temperature for Tack fusing is set for a minimum level of fusing. For a more aggressive level of fusing it will be necessary to Add Time or Temperature.