



many castings.



### COE 96 Firing Schedule

- Seg 1 300°F/hour to 1350°F,  
Hold 10 minutes
- Seg 2 AFAP (As Fast As Possible) to 960°F no venting
- Seg 3 60°F/hour to 700°F
- Seg 4 Off, cool kiln, no venting

Next, place the partially-filled mold on the digital scale. (Here is where we use that filled mold weight.) Evenly add water clear frit until the mold reaches the filled mold weight. Place mold on elevated kiln shelf. Avoid thermal shock – breaking the mold – by heating mold no faster than 300°F per hour until fusing temperature is reached.

Below are two firing schedules. One is for COE 90 glass. The other; COE 96 glass. Please recognize, however, that every kiln is different and firing schedules can be affected by glass thickness, number of pieces in the firing, number of kiln shelves, whether the kiln has top and/or side elements, and even glass color. Firing schedules may have to be adjusted for

your kiln.

Wait until the mold is completely cool and remove it from the kiln. The castings should fall out. If they are stubborn, turn mold face-down and tap it against a hard



surface cushioned with several layers of newsprint.

Mix a small batch of epoxy following package instructions. Adhere the findings to to each glass piece. Let the epoxy cure according to the package instructions.

Thoroughly clean the mold with a stiff brush between every firing to remove all the old primer. Avoid breathing any dust by wearing a proper dust mask. If correctly primed and fired, a Colour de Verre Honey Bee mold will yield

### COE 90 Firing Schedule

- Seg 1 300°F/hour to 1375°F,  
Hold 10 minutes
- Seg 2 AFAP (As Fast As Possible) to 960°F no venting
- Seg 3 60°F/hour to 700°F
- Seg 4 Off, cool kiln, no venting