

# PROGRAMMING GLASS FIRE MODE

## FULL FUSE PROGRAMS

Full Fuse - SLOW	Segment 1	Segment 2	Segment 3	Segment 4	Segment 5	Segment 6	Segment 7	Segment 8
Rate in Rise of Temperature Per Hour (°F/HR)	300	300	300	600	600	9999	30	60
Target Temperature	250	500	750	1250	1480	1000	970	750
Hold Time (HR.Min)	0.25	0.25	0.25	0.20	0.15	2.00	2.00	0.01

Full Fuse - MEDIUM	Segment 1	Segment 2	Segment 3	Segment 4	Segment 5	Segment 6	Segment 7	Segment 8
Rate in Rise of Temperature Per Hour (°F/HR)	500	300	300	600	600	9999	90	1200
Target Temperature	250	500	750	1250	1480	1000	970	750
Hold Time (HR.Min)	0.12	0.12	0.12	0.20	0.15	1.00	1.00	0.01

Full Fuse - FAST	Segment 1	Segment 2	Segment 3	Segment 4	Segment 5	Segment 6	Segment 7	Segment 8
Rate in Rise of Temperature Per Hour (°F/HR)	800	800	800	600	600	9999	200	200
Target Temperature	250	500	750	1250	1480	1000	975	750
Hold Time (HR.Min)	0.05	0.05	0.05	0.20	0.15	0.10	0.20	0.01

## TACK FUSING PROGRAMS

Tack Fuse - SLOW	Segment 1	Segment 2	Segment 3	Segment 4	Segment 5	Segment 6	Segment 7	Segment 8
Rate in Rise of Temperature Per Hour (°F/HR)	300	300	300	600	600	9999	30	60
Target Temperature	250	500	750	1250	1350	1000	970	750
Hold Time (HR.Min)	0.25	0.25	0.25	0.20	0.10	2.00	2.00	0.01

Tack Fuse - MEDIUM	Segment 1	Segment 2	Segment 3	Segment 4	Segment 5	Segment 6	Segment 7	Segment 8
Rate in Rise of Temperature Per Hour (°F/HR)	500	300	300	600	600	9999	90	120
Target Temperature	250	500	750	1250	1350	1000	970	750
Hold Time (HR.Min)	0.12	0.12	0.12	0.20	0.10	1.00	1.00	0.01

Tack Fuse - FAST	Segment 1	Segment 2	Segment 3	Segment 4	Segment 5	Segment 6	Segment 7	Segment 8
Rate in Rise of Temperature Per Hour (°F/HR)	800	800	800	600	600	9999	200	200
Target Temperature	250	500	750	1250	1350	1000	975	750
Hold Time (HR.Min)	0.05	0.05	0.05	0.20	0.10	0.10	0.20	0.01

## SLUMPING PROGRAMS

Slump - SLOW	Segment 1	Segment 2	Segment 3	Segment 4	Segment 5	Segment 6	Segment 7	Segment 8
Rate in Rise of Temperature Per Hour (°F/HR)	300	300	300	600	600	9999	30	60
Target Temperature	250	500	750	1150	1220	1000	970	750
Hold Time (HR.Min)	0.25	0.25	0.25	0.05	0.05	2.00	2.00	0.01

Slump - MEDIUM	Segment 1	Segment 2	Segment 3	Segment 4	Segment 5	Segment 6	Segment 7	Segment 8
Rate in Rise of Temperature Per Hour (°F/HR)	500	500	500	600	600	9999	90	120
Target Temperature	250	500	750	1100	1220	1000	970	750
Hold Time (HR.Min)	0.12	0.12	0.12	0.05	0.05	1.00	1.00	0.01

Slump - FAST	Segment 1	Segment 2	Segment 3	Segment 4	Segment 5	Segment 6	Segment 7	Segment 8
Rate in Rise of Temperature Per Hour (°F/HR)	800	800	800	600	600	9999	200	200
Target Temperature	250	500	750	1100	1220	1000	975	750
Hold Time (HR.Min)	0.05	0.05	0.05	0.05	0.05	0.10	0.20	0.01