



Glass composition	Step 1 time (min)	Step 2 heating (min)	Step 3 temperature (C°)	Step 3 Time (min)	Step 4 heating (min)	Step 5 temperature (C°)	Step 5 Time (min)
33,1	5 min	20 min	70 C°	25 min	18 min	120 C°	45 min
44,2	10 min	22 min	70 C°	25 min	18 min	120 C°	45 min
55,2	10 min	25 min	75 C°	30 min	20 min	120 C°	50 min
66,2	10 min	25 min	75 C°	32 min	20 min	120 C°	55 min
88,2	15 min	32 min	80 C°	35 min	22 min	120 C°	65 min
10,10,2	15 min	35 min	80 C°	45 min	25 min	120 C°	85 min
12,12,2	15 min	38 min	80 C°	65 min	28 min	120 C°	105 min

All circles are recommended and must be tested on every kiln to achieve best results.

For every additional EVA layer of 0.38 mm second hold temperature (step 5) must be increased by 2 to 5 min.

Vacuum has to be hold between 0.9-0.95 bar depending on the glass and number of layers.

Thermally toughened glass is supposed to have pre-vacuuming by at least 5 min. longer.

In case of use more EVA layers (2x0.38 instead of 1x0.76) pre-vacuuming to be increased by at least 5 min.

For quicker cooling, the kiln can be open after second hold, but kiln producer must be consulted.

Glass could be taken from the kiln when cooling reaches 60°C , but we recommend 40 °C for workers safety.