

Installing the Bead Mandrel

Installing the Mandrel Holder

1 Open the door. You will find two screws on the bottom edge of the door. Loosen the screws with a 1/4" nut driver.

2 Slide the two slots in the bead mandrel holder under the two screws in the door. Tighten the screws.

When placing beads inside the kiln, rest the bead mandrels on the mandrel holder.



Annealing Flame-Worked Glass Beads

Glass is sensitive to breakage as it cools through the annealing range. This is approximately 950°F/510°C through 700°F/371°C. The larger the piece, the slower it must cool.

To safely cool flame-worked glass beads, anneal them in your kiln using the bead door.

Programming the Kiln

Program the controller in Ramp-Hold (the ProG display) for the following two segments. (See the separate digital controller manual.) If your bead-making session will be longer than three hours, program a longer hold time in segment 1.

Segment	Rate	Temp.	Hold
1	1799°F/999°C	1000°F/537°C	03.00
2	400/222	700/371	00.00

Fire the kiln. When it reaches 1000°F/537°C, it will maintain that temperature for three hours.

Annealing the Beads

1 At 1000°F/537°C, the kiln is ready to receive the bead mandrels loaded with hot beads. Allow a freshly finished bead to cool slightly before inserting. This is to prevent the bead from flattening on one side when it is placed inside the kiln.

Open the bead door. Insert the mandrels as you complete the beads. Leave the door ajar with the end of the bead mandrel extending outside the kiln.

2 When you have finished the batch of beads, perform a Skip Segment. This will end the temperature hold and begin segment 2. The kiln will slowly cool through the annealing range.

After the kiln shuts off, leave the beads in place. Do not remove them until the kiln has reached room temperature.