

Type of Firing _____

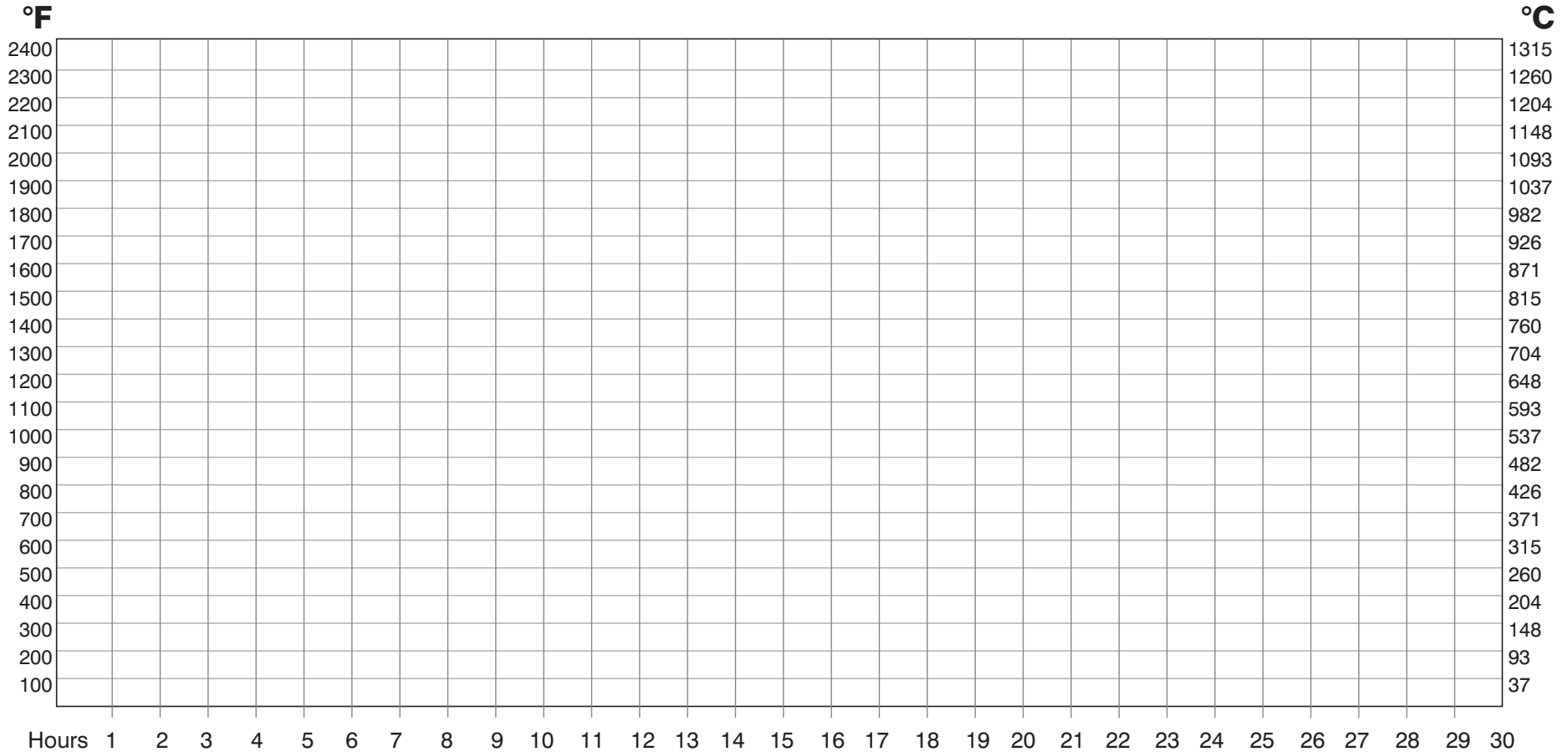
Paragon Ramp-Hold Firing Profile

1. Pencil in a dot for room temperature at the left edge of chart.
2. The next dot will show segment #1 temperature and time needed to reach it.
3. Add dots for all segments. Then connect the dots with straight lines. (Hold times are

represented by horizontal lines.) The firing profile will help you design firings.
Figuring the rate of a segment:
 A. Subtract temperature at beginning of segment from the segment's target temperature. (Cool-down segments: subtract

target temperature from beginning temperature.)
 B. Divide that temperature by number of hours it takes to reach the target temperature.
 C. Rate is the answer to B above: °F or °C

temperature change per hour.
 Example: It takes 3 hours to reach a target temperature of 1250°F from 750°.
 $1250 - 750 = 500$
 $500 \div 3 = 166.666$
 Rate = 166°F



Date	
Profile #	
User #	

Segment	Rate	Temp.	Hold
1			.
2			.
3			.
4			.

Segment	Rate	Temp.	Hold
5			.
6			.
7			.
8			.

 Kilns and furnaces you can depend on.

Paragon Industries, Inc.

2011 South Town East Blvd.
 Mesquite, Texas 75149-1122
 800-876-4328 / 972-288-7557
 Toll Free Fax 888-222-6450
 Fax 972-222-0646
 www.paragonweb.com
 paragonind@worldnet.att.net

Paragon Ramp-Hold Firing Record

Page _____

This record sheet will help you learn from each firing. It is a valuable aid in solving firing problems.

Kiln: If you have more than one kiln or furnace, write in the model number.

User #: The program # that you enter at the USER prompt.

Profile #: The firing profile from your Ramp-Hold Firing Profile sheet (IM-187).

Firing Started: The time that the kiln began firing after delay time, if any, elapsed.

Total Firing Time: This will help you determine when to monitor the kiln during the next firing and when to change elements. When firing time gradually becomes excessive, it may be time to change elements.

Vented Lid: In ceramics, the lid is vented to release moisture at the beginning of the firing. Write in total hours the kiln was vented.

Shelf Cones: Pyrometric cones, used in ceramics, measure heat work. Record the bending as a clock number.

 *Kilns and furnaces you can depend on.*
Paragon Industries, Inc.
 2011 South Town East Blvd.
 Mesquite, Texas 75149-1122
 800-876-4328 / 972-288-7557
 Toll Free Fax 888-222-6450
 Fax 972-222-0646
 www.paragonweb.com
 paragonind@worldnet.att.net

Date _____ Kiln _____ User # _____ Profile # _____ Firing Started _____: _____ Total Firing Time _____: _____

Type & Size of Load _____ Comments & results _____

Segment	Rate	Temp.	Hold	Segment	Rate	Temp.	Hold
1			.	5			.
2			.	6			.
3			.	7			.
4			.	8			.

CERAMICS:

Lid vented: _____ hours

Shelf cone # _____

Cone bending: _____ o'clock

Date _____ Kiln _____ User # _____ Profile # _____ Firing Started _____: _____ Total Firing Time _____: _____

Type & Size of Load _____ Comments & results _____

Segment	Rate	Temp.	Hold	Segment	Rate	Temp.	Hold
1			.	5			.
2			.	6			.
3			.	7			.
4			.	8			.

CERAMICS:

Lid vented: _____ hours

Shelf cone # _____

Cone bending: _____ o'clock

Date _____ Kiln _____ User # _____ Profile # _____ Firing Started _____: _____ Total Firing Time _____: _____

Type & Size of Load _____ Comments & results _____

Segment	Rate	Temp.	Hold	Segment	Rate	Temp.	Hold
1			.	5			.
2			.	6			.
3			.	7			.
4			.	8			.

CERAMICS:

Lid vented: _____ hours

Shelf cone # _____

Cone bending: _____ o'clock

Date _____ Kiln _____ User # _____ Profile # _____ Firing Started _____: _____ Total Firing Time _____: _____

Type & Size of Load _____ Comments & results _____

Segment	Rate	Temp.	Hold	Segment	Rate	Temp.	Hold
1			.	5			.
2			.	6			.
3			.	7			.
4			.	8			.

CERAMICS:

Lid vented: _____ hours

Shelf cone # _____

Cone bending: _____ o'clock

Paragon Cone-Fire Firing Record

Page _____

This record sheet will help you learn from each firing. It is a valuable aid in solving firing problems.

Kiln: If you have more than one kiln, write in the model number.

Total Firing Time: This will help you determine when to monitor the kiln during the next firing and when to change elements. As elements wear, the firing time will gradually increase. Low voltage and moisture in the greenware also lengthen firing time.

Pre-Heat: Leave blank if you are using the DTC 100, 600 or 800. If possible, avoid using Pre-Heat to dry greenware. The ware should be dry before loading it in the kiln.

Vented Lid: Vent the kiln at the beginning of firing to release moisture. Write in total hours the kiln was vented.

Shelf Cones: Though your kiln is automatic, use witness cones on the shelf. Record the bending as a clock number (from one to six o'clock).



Kilns and furnaces you can depend on.
Paragon Industries, Inc.
2011 South Town East Blvd.
Mesquite, Texas 75149-1122
800-876-4328 / 972-288-7557
Toll Free Fax 888-222-6450
Fax 972-222-0646
www.paragonweb.com
paragonind@worldnet.att.net

Date _____ Kiln _____ Total Firing Time __:___ Cone _____ Fast Medium Slow Hold ____.

Type & Size of Load _____ Pre-Heat: _____ hours Lid vented: _____ hours

Comments & results _____ Shelf firing cone # _____ Cone bending _____

Date _____ Kiln _____ Total Firing Time __:___ Cone _____ Fast Medium Slow Hold ____.

Type & Size of Load _____ Pre-Heat: _____ hours Lid vented: _____ hours

Comments & results _____ Shelf firing cone # _____ Cone bending _____

Date _____ Kiln _____ Total Firing Time __:___ Cone _____ Fast Medium Slow Hold ____.

Type & Size of Load _____ Pre-Heat: _____ hours Lid vented: _____ hours

Comments & results _____ Shelf firing cone # _____ Cone bending _____

Date _____ Kiln _____ Total Firing Time __:___ Cone _____ Fast Medium Slow Hold ____.

Type & Size of Load _____ Pre-Heat: _____ hours Lid vented: _____ hours

Comments & results _____ Shelf firing cone # _____ Cone bending _____

Date _____ Kiln _____ Total Firing Time __:___ Cone _____ Fast Medium Slow Hold ____.

Type & Size of Load _____ Pre-Heat: _____ hours Lid vented: _____ hours

Comments & results _____ Shelf firing cone # _____ Cone bending _____

Date _____ Kiln _____ Total Firing Time __:___ Cone _____ Fast Medium Slow Hold ____.

Type & Size of Load _____ Pre-Heat: _____ hours Lid vented: _____ hours

Comments & results _____ Shelf firing cone # _____ Cone bending _____

Date _____ Kiln _____ Total Firing Time __:___ Cone _____ Fast Medium Slow Hold ____.

Type & Size of Load _____ Pre-Heat: _____ hours Lid vented: _____ hours

Comments & results _____ Shelf firing cone # _____ Cone bending _____