



**Bomma
cullet**

Brilliant, clear, longworking studio glass
created for glass experts by glass experts

Technical Information

Alfa:	9,6 (20 - 300 °C)	Melting temperature:	1250 – 1280 °C (2282 - 2336 °F)
Specific weight:	2.5455 g/cm ³	Working temperature	1150 - 1250 °C (2102 - 2282 °F)
Index of refraction:	1.5211	Flow point	898 °C (1648 °F)
Yield rate:	100 %	Softening point	702 °C (1297 °F)
		Annealing points:	518 °C (964 °F)
		Transformation temperature	511 °C (952 °F)
		Strain point:	488 °C (910 °F)

Compatibility:

Basic compatibility:	Glasshütte Reichenbach, Gaffer Colours, Kugler glass
Advanced compatibility:	The compatibility is generally based on Alfa with a limited tolerances (+/- 0.2 based on experience with Reichenbach and Gaffer Colors). It is always highly recommended to test your specific application before launching into full production with any design or color application or combination. Cadmium colors, Cadmium-Selenium colors, should be tested based on application.

Melting:

Before first melting Bomma Cullet, we recommend cleaning your furnace to avoid contamination from any old material. When using Bomma Cullet continuously, it is recommended to charge again when there is a minimum of 1/3 of the furnace capacity remaining.

Start melting a single layer of the Bomma Cullet at a temperature between 1250 - 1280 °C (2282 - 2336 °F) (depending on the type of furnace).

When the charge is melted, add another layer of the Cullet. Repeat until the requested amount of melted glass is ready.

To start working, adjust the temperature for the product that you are going to create.

Enjoy the longworking Glass.

Cooling down

The annealing oven should start at 525°C (977 °F)

Pieces under 10 mm of thickness

15 min 525°C (977 °F)	90 min until 410 °C (770 °F)	90 min until 200°C (392 °F)
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Pieces 10-40 mm of thickness

30 min 525°C (977 °F)	200 min until 410 °C (770 °F)	200 min until 200°C (392 °F)
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Pieces 4 - 9 cm of thickness

45 min 525°C (977 °F)	330 min until 410 °C (770 °F)	330 min until 200°C (392 °F)	110 min down to 30°C (86 °F)
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Pieces 9-15 cm of thickness

60 min 525°C (977 °F)	540 min down to 410 °C (770 °F)	540 min down to 200°C (392 °F)	180 min down to 30°C (86 °F)
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