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property a straint solution and the second and the straint solution and a straint solution of a straint solution and a straint solution at the straint solution and a straint solution at the straint solution and a straint solution and a straint solution at the straint solution and a straint solution are straint solution as a straint solution and a straint solution and a straint solution are straint solution as a straint solution and a straint solution and

Section 15, Stress Relieving Processes Margand I2 not safety An Youndbright

NORMALIZING SCHEDULE FOR ACRYLIC CASTINGS

Table 15.1 Typical heating times for normalizing of acrylic castings prior to machining operations

(hrs)	rkness	Maximum			Approx.	U	Ω	Maximum	ш	
680 3 144 8 7 7 10 115 51 4 113 6 9 19 19 18 11 41 5 23 14 11 11 11 6 23 41 5 25 4 13 14 6 23 34 6 22 25 14 14 14 6 23 29 7 36 3 16 16 45 33 20 8 39 3 18 14 37 33 20 9 46 2.4 23 23 33 35 33 20 9 46 2.4 2.2 22 23 43 35 43 20 10 50 2.2 2.2 2.2 3.5 43 35 43 35 43 35 43 35 4	(mm	oven heating rate F/hr			oven cool rate 'F/hr	Cool oven to 230°F	230°F (110°C) hrs	oven cool rate 'F/hr	Time to cool to 80°F (hrs)	ambient temp.
51 4 18 6 9 9 9 8 19 19 41 21 24 21 3 11 7 22 41 24 26 28 4 14 14 7 22 23 6 28 4 14 14 5 13 18 23 6 28 3 16 16 4.5 13 26 8 39 35 16 16 4.5 13 26 8 43 25 22 22 4 33 4 20 9 46 24 23 23 4 33 4 20 10 53 22 27 22 23 43 43 43 20 11 57 14 39 39 15 60 15 10 11 57 14	(51)	89	3	14	88	7	7	10	15	46
51 4 21 5 11 11 7 121 122 123 121 121 121 122 123 123 122 123 124 233 123 124 233 124 233 233 124 233 233 124 233 234 134 134 134 134	(63)	51 P. C	4 CK4 1	18	9	6	6	8	19	59
41 5 25 4 13 61 6 25 130 34 6 72 35 14 14 65 130 34 6 72 35 16 16 65 130 29 7 36 3 16 16 45 130 26 8 43 39 3 16 16 45 130 26 8 43 45 3 16 16 45 130 20 9 46 23 22 22 22 43 36 20 10 50 22 22 22 35 43 43 17 12 60 18 30 20 25 35 43 43 100 110 110 110 150 110 110 110 110 110 110 110 110 110 110	(94)	51	4	12,013	2	G. Lant	11	7 00	21	89
34 6 28 4 14 14 5 30 24 6 7 36 3 16 16 45 33 25 8 7 36 3 18 18 45 133 26 8 3 3 18 18 45 33 43 26 8 44 2.4 2.2 2.2 4 38 43 20 10 50 4.6 2.4 2.2 2.2 4 38 20 10 50 2.2 2.2 2.2 4.3 4.3 20 10 50 2.2 2.2 2.2 4.3 4.3 20 10 50 2.2 2.2 2.2 3.2 4.3 4.3 10 11 12 42 2.7 2.7 3.0 1.0 11 12 42 2.7 2.2 <t< td=""><td>(88)</td><td>41</td><td>2</td><td>25</td><td>4</td><td>13</td><td>13</td><td>9</td><td>25</td><td>81</td></t<>	(88)	41	2	25	4	13	13	9	25	81
34 6 32 35 16 16 45 43 33 29 8 3 3 20 20 4 45 33 26 8 3 3 20 20 4 33 20 9 46 2.4 2.2 2.2 3 43 33 20 10 50 2.2 2.2 2.2 3 43 33 20 10 50 2.2 2.2 2.2 3.5 43 35 20 10 53 2.2 2.2 2.2 3.5 43 35 43 3.5 43 35 43 35 43 <td>(101)</td> <td>34</td> <td>9</td> <td>187 0 28</td> <td>4</td> <td>14</td> <td>14 €</td> <td>5</td> <td>30</td> <td>92</td>	(101)	34	9	187 0 28	4	14	14 €	5	30	92
29 7 36 3 18 18 45 33 26 8 8 33 3 3 3 46 33 49 46 33 44 44	(114)	34	9-0	173 0(32	3.5	16	16	4.5	21 60 33 C	103
26 8 39 3 20 20 4 31 36 43 25 22 22 4 4 38 4 25 22 22 22 22 22 22 22 22 22 22 23 23 43 43 20 10 50 2.2 2.2 25 25 43 44 43 44	(127)	- 29	7.1	36	3	18	18	4.5	-33	112
26 8 43 2.5 2.2 2.6 4 38 4.8 2.9 4.6 2.4 2.3 2.3 3.5 4.3 2.0 2.0 2.0 2.2 2.2 2.3 3.5 4.3 4.3 2.0 2.0 2.0 2.0 2.2 2.0 2.0 3.5 4.3 4.3 4.3 4.3 4.3 4.3 4.3 4.3 4.0 4.3 4.3 4.0 4.3 4.3 4.0 4.3 4.3 4.0 4.3 4.3 4.0 4.3 4.0	(140)	26	8	39	3	20	20	4	37	124
20 9 46 2.4 2.3 2.3 2.5 4.5 4.6 2.4 2.3 2.5 4.3 4.3 4.3 2.0 2.0 2.0 2.0 2.5 2.5 2.5 4.3 4.0 7.5 4.4 7.5 4.4 7.5 4.4 3.9 3.0 2.5 6.0 4.3 4.0 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5 4.0 7.5	(152)	26	8	3) 0 43	2.5	22	22	4	38	133
20 10 50 2.2 2.5 2.5 3.5 43 6.0 1.0 3.0 2.0 3.0 3.5 4.0 3.0 1.0 3.0 1.0 3.0 1.0 3.0 3.0 3.0 3.0 1.0 3.0 1.0 3.0 1.0 3.0 1.0 3.0 1.0 3.0 1.0	(165)	20	6	46	2.4	23	23	3.5	43	144
20 10 53 2 27 27 3 50 11 11 57 119 20 20 3 50 3 50 11 17 17 12 64 1.8 30 30 2.5 60 1.8 30 30 2.5 60 10 10 12 60 10 12 60 12 30 30 2.5 60 10 10 10 10 12 60 12 30 30 2.5 60 17 10 1	(178)	20	10	20	2.2	25	25	3.5	43	153
19	(190)	20	10	53	2	27	27	3	50	167
17 12 60 1.8 30 30 25 60 17 12 64 1.7 32 25 60 16 14 12 34 34 2.0 75 15 14 15 34 2.0 75 15 14 15 34 2.0 75 15 14 15 39 39 1.5 100 14 15 14 39 39 1.5 100 13 14 14 39 39 1.5 100 13 14 39 39 1.5 100 150 13 14 39 39 1.5 100 150 100 150	(203)	State 19	scientisem.	57	1.9	29	29	3	20	176
17 12 64 17 32 32 25 60 16 16 34 34 34 20 75 15 14 34 34 20 75 15 14 15 36 20 75 15 14 15 39 15 100 14 15 14 39 39 15 100 13 16 82 13 41 10 150 150 13 16 82 13 41 41 11 10 150 100 13 16 82 13 43 11 10 150 10 150 100 11 10 150 10 10 150 100 11 10 10 11 10 11 10 10 10 10 10 10 10 10 10 10 10 <td< td=""><td>(216)</td><td>17</td><td>12</td><td>21 09</td><td>0.1.8 × 9</td><td>30</td><td>30</td><td>2.5</td><td>09</td><td>192</td></td<>	(216)	17	12	21 09	0.1.8 × 9	30	30	2.5	09	192
16 13.0 68 16 34 34 2.0 75 15 15 15 16 15 15 15 1	(523)	- 17	12	64	1.7	32	32	2.5	09	200
15	(241)	16	13	89	1.6	34	34	2.0	75	224
15 14 15 14 38 38 15 100 14 15 78 14 39 39 1.5 100 13 14 15 78 14 39 39 1.5 100 13 16 185 1.3 41 41 1.0 150 13 16 185 1.2 48 48 1.0 150 11 19 18 92 1.1 48 48 0.5 300 11 19 198 1.1 60 60 60 65 300 11 19 198 1.1 60 60 60 6.5 300 10 20 103 1.0 52 52 0.5 300 10 21 110 110 52 52 0.5 300 10 21 110 1.0 52 52 0.5 300 10 21 110 0.98 62 62 62 300 10 22 112 0.98 62 62 62 300 10 22 112 0.98 62 62 62 300 10 20 135 124 0.89 62 62 62 300 10 20 135 0.83 66 66 0.5 300 10 20 149 0.75 75 75 0.5 300 10 20 149 0.75 75 75 0.5 300 10 20 149 0.75 75 75 0.5 300 10 20 149 0.75 75 75 0.5 300 10 20 110 0.75 75 75 0.5 300 10 20 110 0.68 68 69 0.5 300 10 20 149 0.75 75 75 0.5 300 10 20 110 0.68 68 69 0.5 300 10 20 110 0.67 68 84 0.5 300 10 20 110 0.68 87 85 0.5 300 10 20 110 0.68 88 84 0.5 300 10 20 110 0.68 88 89 0.5 300 10 20 110 0.68 88 88 0.5 300 10 20 110 0.68 88 88 0.5 300 10 20 110 0.68 88 0.5 300 10 20 110 0.68 88 0.5 300 10 20 110 0.68 88 0.5 300 10 20 110 0.68 88 0.5 300 10 20 110 0.68 88 0.5 300 10 20 110 0.68 88 0.5 0.5 300 10 20 110 0.68 88 0.5 0.5 300 10 20 110 0.68 88 0.5 0.5 300 10 20 110 0.68 88 0.5 0.5 300 10 20 20 20 20 20 20 10 20 20 20 20 20 20 10 20 20 20 20 20 20 10 20 20 20 20 20 20 20 20	(254)	15	14622	21,000	1.5	36	36	2.0	75	232
14 15 78 14 39 39 15 100 100 110	(267)	51.6.51	1177 Pt 35 75	75	1.4	38	38	1.5	100	265
13	(52)	September 14 mm ordered	15	78	1.4	39	39	1.5	100	172
13 16 85 1.2 45 45 1.0 150 150 121 121 121 121 122 45 45 6.5 300 121 121 122 45 45 6.5 300 121 122 122 124 46 6.5 300 121 122 122 122 123 12	(262)	13 3 5 13 5 x 0	31.0 gl6 1519.	182 115	se 1.3 cm	41	41	1.0	150	330
12 17 89 1.2 45 45 65 300 11 18 92 1.2 46 46 0.5 300 11 18 92 1.1 64 46 0.5 300 11 19 96 1.1 50 50 0.5 300 11 19 100 1.1 50 52 0.5 300 10 21 100 1.1 50 52 52 300 10 21 100 52 52 0.5 300 10 21 100 55 52 0.5 300 9 22 114 0.96 57 57 0.5 300 9 23 121 0.93 60 60 60 0.5 300 8 24 124 0.89 62 62 0.5 300 8 25 <th< td=""><td>(302)</td><td>£1</td><td>16</td><td>- 85</td><td>1.3</td><td>43</td><td>43</td><td>1.0</td><td>150</td><td>337</td></th<>	(302)	£1	16	- 85	1.3	43	43	1.0	150	337
11 18 92 1.2 46 46 0.5 300 11 19 96 1.1 68 0.5 300 11 19 96 1.1 50 50 0.5 300 11 19 100 1.1 50 50 50 300 10 20 10 1.0 52 52 0.5 300 10 21 107 1.0 55 52 0.5 300 10 21 107 1.0 55 52 0.5 300 10 21 1.0 55 57 57 57 300 9 23 114 0.96 60 60 0.5 300 8 24 124 0.89 62 62 0.5 300 8 25 132 0.8 68 69 0.5 300 8 26 <th< td=""><td>(318)</td><td>15/ 15/</td><td>14</td><td>68</td><td>1.2</td><td>45</td><td>45</td><td>0.5</td><td>300</td><td>496</td></th<>	(318)	15/ 15/	14	68	1.2	45	45	0.5	300	496
11 19 19 19 100 1.1 50 50 6.5 300 101 100 1.1 50 50 6.5 300 100 1.1 50 50 6.5 300 100 1.1 50 50 6.5 300 100 1.0 52 52 52 3.00 100 1.0 52 52 52 3.00 100 1.0 52 52 3.00 1.0 52 3.00 1.0 52 3.00 1.0 52 3.00 1.0 52 3.00 1.0 52 3.00 1.0 52 3.00 1.0 52 3.00 1.0 52 3.00 1.0 52 3.00 1.0 52 3.00 1.0 3.00 1.0 3.00 1.0 3.00 1.0 3.00 1.0 3.00 1.0 3.00 1.0 3.00 1.0 3.00 1.0 3.00 1.0 3.00 1.0 3.00 1.0 3.00	(330)	B SOTT SEC	> 186	92	1.2 m	46	46	0.5	300	205
11 19 100 1.1 50 50 0.5 300 10 20 103 1.0 52 52 0.5 300 10 21 107 1.0 52 52 0.5 300 10 21 110 1.0 55 52 0.5 300 10 21 110 1.0 55 57 0.5 300 9 22 114 0.96 57 57 0.5 300 9 23 121 0.96 57 57 0.5 300 8 24 124 0.89 62 62 0.5 300 8 25 132 0.8 68 64 0.5 300 8 25 132 0.8 68 66 0.5 300 8 27 142 0.75 73 75 0.5 300 7	(343)	11.2	19.8	96	1 43	84 00	48	0.5	300	511
10 20 103 1.0 52 52 0.5 300 10 21 107 1.0 55 53 0.5 300 10 21 110 1.0 55 53 0.5 300 9 22 114 0.96 57 59 0.5 300 9 23 117 0.93 60 60 0.5 300 8 24 124 0.93 62 62 0.5 300 8 24 124 0.89 62 62 0.5 300 8 25 132 0.8 68 66 0.5 300 8 25 132 0.8 68 66 0.5 300 8 25 132 0.8 68 68 0.5 300 8 25 135 0.8 69 69 0.5 300 8	(357)	the feet of the second	- 19	100	-1.1	50	20	0.5	300	519
10 21 107 1.0 55 53 6.5 300 10 21 110 1.0 55 55 6.5 300 9 22 114 0.96 57 57 6.5 300 9 23 117 0.93 6.5 60 60 0.5 300 8 23 121 0.93 6.0 60 6.5 300 90 8 24 124 0.89 62 62 0.5 300 90 8 25 128 0.86 64 64 0.5 300 90 80 60 60 0.5 300 90 <	(368)	10	20	103	1.0	52	52	0.5	300	527
10 21 110 15 55 55 6.5 300 9 222 114 0.96 57 57 0.5 300 9 23 117 0.93 0.59 59 0.5 300 9 23 121 0.93 60 60 0.5 300 8 24 124 0.89 62 62 0.5 300 8 25 128 0.86 64 0.5 300 300 8 25 132 0.83 66 66 0.5 300 8 25 132 0.8 68 68 0.5 300 8 26 135 0.77 0.8 68 66 0.5 300 8 146 0.77 0.8 69 69 0.5 300 7 28 149 0.77 0.75 0.75 0.75 300	(381)	n La 102 and	212.5	1078.8	1.0 (8)	00/53	53	0.5	300	534
9 222 114 0.96 57 57 0.5 300 9 23 117 0.93 0.59 59 0.5 300 8 23 121 0.93 60 60 6.5 300 8 24 124 0.89 62 62 6.5 300 8 25 128 0.86 64 6.5 300 300 8 25 132 0.83 66 66 6.5 300 8 26 135 0.8 68 68 0.5 300 8 26 135 0.77 0.8 68 6.5 0.5 300 8 27 142 0.77 0.77 0.71 7 0.5 300 7 29 149 0.77 78 75 0.5 300 7 31 160 0.68 80 60 0.5 30	(394)	10	21	110	1.0	55	55	0.5	300	541
9 & W 133 117 0.93 0.59 59 0.5 300 9 23 121 0.9 60 60 0.5 300 8 24 124 0.89 62 62 0.5 300 8 25 128 0.86 64 0.5 300 8 25 132 0.83 66 66 0.5 300 8 26 135 0.8 68 68 0.5 300 8 26 135 0.8 68 68 0.5 300 8 27 139 0.8 68 69 0.5 300 7 28 146 0.75 73 73 0.5 300 7 28 146 0.75 73 75 0.5 300 7 29 153 0.72 76 76 0.5 300 7 31	(406)	6	22	114	96'0	57	57	0.5	300	550
9 23 121 0.9 60 60 60.5 300 8 24 124 0.89 62 62 0.5 300 8 25 128 0.86 64 6.7 0.5 300 8 25 132 0.83 66 66 0.5 300 8 26 135 0.8 68 68 0.5 300 8 27 139 0.8 68 6.5 0.5 300 8 1 142 0.77 0.7 71 0.5 300 7 28 146 0.75 73 75 0.5 300 7 29 149 0.73 75 75 0.5 300 7 30 156 0.7 78 76 0.5 300 7 31 164 0.6 80 80 80 0.5 300	(419)	10 King 6/1 10W	23%	F E\$#117.60.	0.93	> 65 00 V	59	9.0	300	825
8 24 124 0.89 62 62 0.5 300 8 25 128 0.86 64 6.5 0.5 300 8 25 132 0.83 66 66 0.5 300 8 26 135 0.8 68 68 0.5 300 8 27 139 0.8 69 69 0.5 300 7 28 146 0.77 73 73 0.5 300 7 28 146 0.75 73 75 0.5 300 7 29 149 0.73 75 75 0.5 300 7 29 156 0.72 76 75 0.5 300 7 30 156 0.72 78 78 0.5 300 7 31 164 0.67 82 82 0.5 300 6	(432)	6	23	121	6.0	99	09	9.5	300	564
8 25 128 0.86 64 64 6.5 300 8 25 132 0.83 66 66 0.5 300 8 26 135 0.8 68 66 0.5 300 8 27 139 0.8 69 69 0.5 300 7 28 142 0.77 0.77 71 0.5 300 7 28 146 0.75 73 73 0.5 300 7 29 149 0.73 75 75 0.5 300 7 29 153 0.72 76 76 0.5 300 7 30 156 0.77 78 78 0.5 300 7 31 164 0.67 82 82 0.5 300 7 31 167 0.65 84 84 0.5 300 6	(445)	80	24	124	0.89	62	62	0.5	300	572
8 25 132 0.83 66 66 66 0.5 300 8 26 135 0.8 68 68 0.5 300 8 27 139 0.8 69 69 0.5 300 7 28 142 0.77 7 7 7 300 7 28 146 0.75 73 75 0.5 300 7 29 149 0.73 75 75 0.5 300 7 29 149 0.73 75 75 0.5 300 7 29 156 0.72 76 76 0.5 300 7 31 160 0.68 80 80 0.5 300 7 31 164 0.67 82 82 0.5 300 7 31 167 0.65 84 84 0.5 300	(457)	80	25	128	98.0	64	64	9.0	300	581
8 26 135 0.8 68 68 6.5 300 8 27 139° (0.8) 69 69 0.5 300 7 28 142 0.77 (0.70) 71 71 0.5 300 7 28 146 0.75 73 73 0.5 300 7 29 149 0.73 75 75 0.5 300 7 29 (1.49) 0.73 75 75 0.5 300 7 30° 153 0.72 (0.70) 76 75 0.5 300 7 31 160 0.68 80 80 0.5 300 7 31 164° 0.67 82 82 0.5 300 6 33 171 0.64 85 85 0.5 300 6 33 174 0.63 80 80 0.5 300 6 33 <td>(470)</td> <td>eo</td> <td>52</td> <td>132 8</td> <td>0.83</td> <td>99</td> <td>99</td> <td>9.5</td> <td>300</td> <td>589</td>	(470)	eo	52	132 8	0.83	99	99	9.5	300	589
8 27 139*** 0.8 69 69 0.5 300 8 h l 27 S l 142** 0.77 (E) 0.71 71 0.5 300 7 28 146 0.75 73 73 0.5 300 7 29 149 0.73 75 75 0.5 300 7 29 L 153 0.72 (E) 0.76 76 0.5 300 7 31 160 0.68 80 80 0.5 300 7 31 164 M 0.67 (E) 82 82 0.5 300 6 32 L 167 M 0.65 84 0.5 300 6 33 L 171 0.64 85 85 0.5 300 6 33 E 174 0.6 (E) 89 89 (E) 0.5 300 300	(483)	88	92	135	8.0	- 89	89	0.5	300	265
8 A 27 S 142 0.77 (E) 0.71 71 0.5 300 7	(495)	80	27	139	8.0	69	69	0.5	300	604
7 28 146 0.75 73 73 0.5 300 7 29 149 0.73 75 75 0.5 360 7 30 153 0.72 () 0.76 76 0.5 300 7 31 156 0.7 78 78 0.5 300 7 31 164 0.68 80 80 0.5 300 6 32 p 167 p 0.65 84 0.5 300 6 33 c 171 0.64 85 85 0.5 300 6 33 c 174 0.63 87 87 0.5 300 6 34 c 174 0.64 85 89 0.5 300	(208)		12.72	142	0.77	0.0271	7.1	9.5	300	611
7 29 149 0.73 75 75 0.5 380 7 29 153 0.72 0.72 76 0.5 300 7 30 156 0.7 78 78 0.5 300 7 31 160 0.68 80 80 0.5 300 6 31 167 0.67 82 82 0.5 300 6 33 171 0.64 85 85 0.5 300 6 33 174 0.63 87 87 0.5 300 6 33 174 0.63 89 89 0.5 300	(521)	7	28	146	0.75	73	73	0.5	300	620
7 29 II 153 0.72 (8.1) 0.76 76 0.5 300 7 30 II 156 0.7 II 78 0.5 300 7 31 II 160 0.68 80 0.5 300 6 II 31 II 164 II 0.67 II 82 82 0.5 300 6 II 32 II 167 II 0.65 84 84 0.5 300 6 II 33 II 171 0.64 85 85 0.5 300 6 II 33 II 174 0.63 II 87 87 0.5 300 6 II 34 ET 178 II 0.6 II 89 89 II 0.5 300	(533)	7	29	149	0.73	75	75	0.5	300	628
7 30, 1 156 0.7 g 78 78 0.5 300 7 31 160 0.68 80 0.5 300 6 31 2 2 B 164 B 0.67 B 82 82 0.5 300 6 32 B 167 B 0.65 B 84 0.5 300 300 6 33 C 171 B 0.64 B 85 85 0.5 300 6 C 33 E 174 0.63 P 0.6 S 89 89 0.5 300	(346)	7.01	29 ₽ ₽	153	0.72	0576	92	0.5	300	634
7 31 160 0.68 80 6.5 300 7 PE 31 PL 164 PL 0.67 PL 82 82 0.5 300 6 PL 32 PL 167 PL 0.65 84 84 0.5 300 6 PL 33 PL 171 0.64 85 85 0.5 300 6 PL 33 PL 174 0.63 77 87 87 0.5 300 6 PL 34 ET 178 PL 0.6 (2) 2 89 89 PL 0.5 300	(654)	7 20	30	156	0.7 rg	78	78	0.5	300	642
7 PE 31 PE 164 NA 0.67 PE 82 82 0.55 0.53 0.65 <	(2/5)	7	31	160	0.68	80	80	0.5	300	651
6 (2) 32 AB 167 (3) (3) (4) (84 (4) (5) (3) (3) (4) (4) (4) (4) (4) (4) (4) (4) (4) (4	(384)	7 * €	3118	16483	0.67	82	82	0.5	300	629
6 ° 33 ° 174 0.63 ° 87 0.5 300 6 6 8 34 EY 178 0.6 5 89 89 6.5 300 6 6 8 89 6 6.5 300 6 6 8 89 6 6.5 300 6 6 8 89 6 6.5 300 6 6 8 89 6 6.5 300 6 6 6 8 89 6 6.5 300 6 6 6 8 89 6 6.5 300 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6	(297)	9	32 µ	167 _{0.5}	0.65	2 84	84	0.5	300	299
6 C8 34 EY 178 0.6 (5) 2 89 (5, 89 0.5) (300 0.5)	(010)	9	33	manufacture 17.1 as a constant	0.64	85	85	0.5	300	674
6 58 34 ET 178: 0.6 (5) 2 89 (15,89 DE c 4,0.5) 1 1300 1 0 000	(670)	9	33 €€	174	0.63	87	87	9.0	300	681
	(650)	83 9	34 87	178 ↔	9.0	68 2 (0.30.88 nc.)	0.5	300	069

unes room temperature 80°F (27°C)
temperature of material removed from oven after completion of normalizing cycle cannot exceed the ambient room
perature by 15°F (8°C) 4 21°C
ambient temperature exceeds 80°F the time to cool down (category E) may be reduced by multiplying the temperature
intence by the approximate cool down rate for the casting thickness and subtracting these hours from category E.