section 15. Stress Relieving Processes sudizingmout not which to doodbash

ANNEALING SCHEDULE FOR ACRYLIC CASTINGS Table 15.2 Shrinking heat treatment for plastic sheets and plates prior to machining

Thickness Range (in)	Maximum oven heating rate	Holding time in hours at temperature (maximum)	Maximum oven cooling rate to	in hours at temperature (minimum)	Maximum oven cooling rate to	Holding time in hours at temperature (minimum)	Maximum cooling rate at 15°F above ambient
62 14 1	F/hr (°C)	266 F (130 C)	176°F (80°C)	176 F (80°C)	266'F (130'C) 176'F (80'C) 176'F (80'C) 95'F (35'C) 95'F (35'C)	95°F (35°C)	°F/hr (C)
0.500	100 (56)	4	100 (56)	Towns I way 2 we had seen	50 (28)		25 (14)
0.625-1.00	100 (56)	Total — Joseph State Management and	100 (56)	,2	36 (20)	8	18 (10)
1.125-2.00	100 (56)	6	50 (28)	2	20 (11)	0 1	10 (5.5)
2.125-3.00	50 (28)	7	50 (28)	8 23 mm	₉₈ 14 (8)	100	7 (4)
3.25-4.25	50 (28)	00	50 (28)	E, 2	10 (6)	0.5	5 (3)

Notes:

1. The shrinking heat treatment is to be used primarily on cell cast monomer castings in the form of sheets

and plates.

Windows machined from shrunk plates and sheets must be annealed after machining and polishing. The oven is to be maintained at the set temperature within ±5°F (2.8°C).

ANNEALING SCHEDULE FOR ACRYLIC WINDOWS Table 15.3 Part A Minimum heating times for elevated temperature annealing of acrylic windows

6.7	mainta	maintained at the set temperature within \pm 5°F (2.8°C)	emperature w	maintained at the set temperature within ± 5 F (2.8 C)	0
Thickness, irr (mm)	Maximum oven heating rate	230°F (max) (110°C)	212 F (min) (100 C)	195°F (min) (90°C)	185' (max) (85'C)
0.250 to 0.375, incl. (6 to 10, incl.)	100 (56)	2.5	3.5	5.5	10
0.500 to 0.750, incl. (13 to 19, incl.)	100 (56)	3 807	4	6	11
0.875 to 1.125, incl. (22 to 28, incl.)	100 (56)	3.5	4.5	6.5	11.5
1.250 to 1.500, incl. (32 to 38, incl.)	100 (56)	4.00	5	7 0	12
≥ 1.750 (44)	100 (56)	5 (1)	5.5	7.5	12.5
≥ 2.000 (50)	100 (56)	6.44	- 6	8	13
≥ 2.250 (57) bbs	50 (28)	7.83	N. 4. 4	9 6	14
≥ 2.500 (64)	50 (28)	8 : 8	9	11 8	15
≥ 3.000 (75)	50 (28)	10	-11	-12	17
≥ 3.250 (82)	50 (28)	12	12 \	148	18
≥ 3.500 (89)	50 (28)	13 04	13	15	19
≥ 3.750 (92) ○ ○ €	50 (28)	14.3	148	16 °	20
4.000 (100)	50 (28)	16	17 "E	18	22
> 4.000 to 6.000, incl. (> 100 to 152, incl.)	25 (14)	28	31	34	40
> 6.000 to 8.000, incl. (> 152 to 203, incl.)	15 (8)	40 07	45	50	58
> 8.000 to 10.000, incl. (> 203 to 254, incl.)	10 (6)	52 M	- 59	66 8	76
> 10.000 to 12.000, incl. (> 254 to 305, incl.)	.) 8 5 (3)	6.4	73	82	94
> 12.000 to 14.000, incl. (> 305 to 356, incl.)	.) 2(1)	76	15175 <mark>87</mark> 108 s	98	112
> 14.000 to 16.000, incl. (> 356 to 406, incl.)	.) 1 (0.5)	88	101	114 vd	130

Does not include the period of time required to raise the oven temperature from ambient room temperature to the set annealing temperature.

ANNEALING SCHEDULE FOR ACRYLIC WINDOWS Table 15.3 Part B Typical heating times for elevated temperature annealing of acrylic windows	NEALING Spical heating	CH	ANNEALING SCHEDULE FOR ACRYLIC WINDOWS B Typical heating times for elevated temperature annealing of ac	ACRYLI	C WINDO	OWS of acrylic v	vindov
Thickness	of Fee statement in	Design of the second	Hold times*,	Hold times*, hr, for acrylic placed in a forced-circulation air oven maintained at the set temperature within \pm 5°F (2.8°C)	placed in a force	ed-circulation a ithin ± 5°F (2.8°	ir oven
in (mm) Jen (J. 02)	D'01))	100	Maximum oven heating rate 'F/hr (C'/hr)	230°F (max) (110°C)	212 F (min) (100 C)	195°F (min) (90°C)	185 (min) (85°C)
0.250 to 0.375, incl. (6 to	o 10, incl.)	B	100 (56)	2.5	80	8 B 11 8 2	12
0.500 to 0.750, incl. (13 to 19, incl.)	to 19, incl.)		100 (56)	ū	9	SI) 12 10 C	14
0.875 to 1.125, incl. (22 to 28, incl.)	to 28, incl.)		100 (56)	7.5	10	13	15
1.250 to 1.500, incl. (32 to	to 38, incl.)	27.5	100 (56)	10	11 00 4	14	16
≥ 1.750 (44)	12	Pr	100 (56)	12	13	16	18
≥ 2.000 (50)	2 July 1	12	100 (56)	13	15	18	20
≥ 2.250 (57)		200	50 (28)	-15	17	20	22
≥ 2.500 (64)	30	(M)	50 (28) _] _]	16.5	18	21	23
≥ 3.000 (75)	and the second and th	25	50 (28)	20	21	24	26
≥ 3.250 (82)	1 50		50 (29)	21.5	23	26	28
≥ 3.500 (89)	3.05	20	50 (28)	23	25	28	30
≥ 3.750 (92)	2.05	43	50 (28) ∈ €	25 (Jbr	,Eds 27, 021	30 ((0))	ं 32
4.000 (100)	2.00		50 (28)	26	29	32	35
> 4.000 to 6.000, incl. (>	100 to 152, incl.)	949	25 (14)	37	44	49	53
> 6.000 to 8.000, inic. (> 152 to 203, incl.)	152 to 203, incl.)	580	15 (8)	53 DOL 5	3265 0 40	65	71
> 8.000 to 10.000, incl. (> 203 to 254, incl.)	203 to 254, incl	٥	10 (6)	. b.66.,236	74 cm	qor 81 ,740 d 8	88
> 10.000 to 12.000, incl. (> 254 to 305, incl.)	(> 254 to 305, in	C.D	5 (3)	79	88	97	107
12,000 to 14 000 incl.	12.000 to 14.000, incl. (> 305 to 356, incl.)	d.)	A 32 (1) 51.11	90	103	W 114	124
The same of the sa		> 14 000 to 16 000 in 1 / > >		STATE OF THE PERSON			