



Annealing

Annealing is the process of relieving stresses in moulded or machined plastics by heating them close to the material deflection temperature, holding this temperature for a pre-determined time and then slowly cooling them.

- Parts should be clean and dry and any films removed before placing in the oven.
- The parts should be supported to prevent distortion.
- Acrylic should be heated to 80°C in an air circulation oven.
- Holding time at temperature as shown in the table below.

Sheet Thickness (mm)	Heating Time (hours)	Cooling Time (hours)
2	2	2
3	2	2
4	2	2
5	2	2
6	2	2
8	2:40	2
10	3:20	2.5

After the heating is completed:

- The cooling rate should not exceed 15°C per hour
- Parts should not be removed until the part temperature falls below 60°C

Annealing should be carried out after all machining and polishing operations have been completed and before adhesives have been applied.



Brett Martin Ltd. pursues a policy of continuous product development and reserves the right to amend specifications without notice.

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