

Parts molded from Styrolution's S/MMA copolymers may be annealed to improve dimensional stability or to reduce internal stresses resulting from the molding process.

Use of a forced air circulation oven is recommended for annealing.

The temperature of the oven and the time at that temperature must be varied according to the thickness, weight and shape of the molded part. The optimum temperature and time cycle should be determined experimentally for each part. To control dimensions, it may be necessary to support or clamp the parts during the annealing process.

Suggested annealing temperature and times that should be considered as starting points in the determination of optimum annealing cycles are as follows:

Thickness	Time	Temperature
Up to 1/8"	2 Hours	140°F – 160°F (60°C – 71°C)
Over 1/8" to 1/4"	4 Hours	160°F – 170°F (71°C – 77°C)
Over 1/4" to 1/2"	6 Hours	170°F – 180°F (77°C – 82°C)

After the residence time at the annealing temperature has been completed, the parts should be allowed to cool down to room temperature in the oven with the heat turned off, or they may be removed and immediately packed in the carton, if it provides sufficient insulation to assure a uniformly slow cooling rate.