

Annealing programm casting glass

Farbglashütte Reichenbach GmbH



1. phase 0 irregular annealing until above the upper annealing point
2. phase 1 bring the glass on a uniform temperature of 480 °C
3. phase 2 / 3 regular linear annealing of the glass
4. phase 4 annealing up to room-temperature

material thickness (mm)	phase 1 dwell on 480 °C (min)	phase 2			phase 3			phase 4			whole annealing time (min)	
		temp.-range (°C)	rate °C/h	total (min)	temp.-range (°C)	rate °C/h	total (min)	temp.-range (°C)	rate °C/h	total (min)		
10	60	480 - 400	67	72	400 - 320	135	36	320 - 20	650	28	195	3h 16min
20	90	480 - 400	29	166	400 - 320	57	84	320 - 20	290	62	402	6h 42min
30	150	480 - 400	15	320	400 - 320	21	229	320 - 20	125	144	843	14h 03min
40	190	480 - 400	7,4	649	400 - 320	15,5	310	320 - 20	70	257	1405	23h 25min
50	240	480 - 400	4,3	1116	400 - 320	9	533	320 - 20	44	409	2299	1d 14h 19min
60	300	480 - 400	2,9	1655	400 - 320	6	800	320 - 20	30	600	3355	2d 07h 55min
70	350	480 - 400	2,3	2087	400 - 270	4,8	1625	270 - 20	22	682	4744	3d 07h 04min
80	380	480 - 400	1,65	2909	400 - 270	3,6	2167	270 - 20	17	882	6338	4d 09h 38min
90	420	480 - 400	1,4	3429	400 - 270	2,7	2889	270 - 20	13	1154	7891	5d 11h 31min
100	480	480 - 400	1	4800	400 - 270	2,1	3714	270 - 20	10	1500	10494	7d 06h 54min
125	600	480 - 400	0,7	6857	400 - 270	1,5	5200	270 - 20	8	1875	14532	10d 02h 12min
150	720	480 - 400	0,5	9600	400 - 270	1,1	7091	270 - 20	5	3000	20411	14d 04h 11min
200	960	480 - 400	0,26	18462	400 - 270	0,53	14717	270 - 20	3	5000	39139	27d 04h 19min

The specified annealing times and temperatures are theoretical values only.

The actual annealing times and temperatures have to be adapted to the respective used hardware and glass mold.