

Oceanside Compatible™ Studio Nuggets® Annealing Guidelines: 1/2"-8" (12mm - 203mm)

Annealing & Cooling

	Step 1		Step 2		Step 3		Step 4	
Target Temps	966 ° F 519 ° C		775 ° F 413 ° C		600 ° F 316 ° C		100 ° F 38 ° C	
Maximum Thickness	Ramp Rate (per hour)	Hold (minutes)	Ramp Rate (per hour)	Hold (minutes)	Ramp Rate (per hour)	Hold (minutes)	Ramp Rate (per hour)	Hold (minutes)
1/2" 12 mm	None	120	100 ° F 55 ° C	10	200 ° F 111 ° C	10	250 ° F 139 ° C	0
3/4" 19 mm	None	180	50 ° F 28 ° C	10	100 ° F 55 ° C	10	200 ° F 111 ° C	0
1" 25 mm	None	240	25 ° F 14 ° C	10	45 ° F 25 ° C	10	150 ° F 83 ° C	0
1.5" 38 mm	None	360	12 ° F 6.7 ° C	45	24 ° F 13 ° C	10	75 ° F 42 ° C	0
2" 51 mm	None	480	7 ° F 3.9 ° C	60	14 ° F 7.8 ° C	10	42 ° F 23 ° C	0
3" 76 mm	None	720	3 ° F 1.7 ° C	120	5.4 ° F 3.1 ° C	30	18 ° F 10 ° C	0
4" 102 mm	None	960	1.5 ° F 0.8 ° C	300	3 ° F 1.7 ° C	45	9 ° F 5 ° C	0
5" 127 mm	None	1200	1.2 ° F 0.7 ° C	375	2.4 ° F 1.3 ° C	60	7.2 ° F 4 ° C	0
6" 152 mm	None	1440	0.8 ° F 0.4 ° C	450	1.3 ° F 0.76 ° C	150	4.5 ° F 2.5 ° C	0
7" 178 mm	None	1680	0.6 ° F 0.3 ° C	525	1.0 ° F 0.58 ° C	225	3.4 ° F 1.9 ° C	0
8" 203 mm	None	1920	0.4 ° F 0.2 ° C	600	0.76 ° F 0.42 ° C	300	2.4 ° F 1.3 ° C	0

Technical Data	
Strain Point	898 °F
	481 °C
Anneal Point	966 °F
	519 °C
Softening Point	1270 °F
	688 °C

