



# HEAT TREATMENT PROCESS

■ All precautions regarding placement of the sheets and accurate temperature control of the oven should be strictly followed.

Sheets must be loaded with perforated metal plates to prevent warping of the ROHACELL® sheet.

■ Both drying and heat treating can cause surface deterioration and a decrease in panel volume. Final shaping must be performed after heat treatment at a temperature of >180 °C (356 °F).

■ Heat-treated ROHACELL® sheets must be processed within a certain period of time (out time) depending upon the storage climate, sheet thickness, manufacturing parameters and density. Please consult us for more detailed information and to confirm your specific ROHACELL® product’s recommended “out-time”.

■ If the established out-time is exceeded, heat treatment can be repeated for un-shaped cores. Net-shaped cores cannot be heat treated again since re-heating will change the dimensions and the surface quality.

■ Heat-treated sheets and shapes can be stored in water and vapor-proof bags (e.g. according to MIL-spec.) if necessary.

## HEAT TREATMENT PROCESS FOR ROHACELL® WF & XT

To improve the creep resistance for demanding processing conditions (temperatures up to 190 °C / 374 °F) and pressure up to 0.7 MPa / 100 psi), a heat treatment process prior to processing is required and possible with ROHACELL® WF and XT.

## HT CONDITIONS FOR ROHACELL® WF & XT

|   | Recommended Temperature   | Approximate Time                 |
|---|---|----------------------------------|
| Drying  | 125 °C ± 5 °C<br>(257 °F ± 9 °F)  | Minimum 4 hours                  |
| Heat Treatment - Should begin immediately after drying at temperatures and duration shown below |   |                                  |
| 51 - 200 WF   | 190 °C ± 5 °C<br>(374 °F ± 9 °F)  | 48 ± 2 hours                     |
| Option for 200 WF   | First, 160 °C ± 5 °C<br>(320 °F ± 9 °F)<br><br>Then, 180 °C ± 5 °C<br>(356 °F ± 9 °F) | 20 ± 2 hours<br><br>28 ± 2 hours |
| 71 - 110 XT   | 200 °C ± 5 °C<br>(392 °F ± 9 °F)  | 48 ± 2 hours                     |