

CMI-B and CMI-C HEAT TREAT SCHEDULE

- 1. Ramp up & Hold Parts at 1550 deg F. for 1-2 Hours**
- 2. Cool to 1450 deg. F. in 1 Hour**
- 3. Cool to 1350 deg. F. in 1 Hour**
- 4. Cool to 1250 deg. F. in 1 Hour**
- 5. Cool to 1150 deg. F. in 1 Hour**
- 6. Cool to 900 deg. F in 1 Hour**
 - After steps 1 - 6**
- 7. [a] Cool at furnace rate to 300 deg. F. in Atmosphere**
[b] Cool 200 deg. F./ Hour to 300 deg. F. in Atmosphere to prevent warpage of thin complicated parts.
- 8. Air cool to ambient**
 - Heat Treat in a Protective Atmosphere**
 - For further information on atmospheres:**
[See X3. section in the ASTM-A-848-01 Specification]

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