

CONDURON G55

Stop-off Paint for Deep Carburising in Gas and Vacuum Carburising up to Case Depths of 5 mm

Characteristics

CONDURON G55 is extremely effective as a stop-off paint for all kinds of gas carburizing. It is particularly suitable for deep case carburising up to depths of 5mm max. (.20") and for vacuum carburising, as well.

CONDURON G55 provides:

- easy application by painting or automatic feeding systems
- exact limitation of the coated area
- perfect adherence to the steel surface

Since the residues of CONDURON G55 are not soluble in water, alkaline solution or solvents, they must be removed after heat treatment by shotblasting or steelbrushing. CONDURON G55 is free of any solvents which is an important benefit in respect of health and safety regulations as well as protection of Environment.

Application

Prior to painting, the surfaces of the components to be protected must be cleaned thoroughly by either a vapor degreaser or a detergent washer, so that the parts are free of oil and grease. They must be free of rust and oxide layers, as well. Before applying, stir the contents of the CONDURON G55 tin thoroughly.

As received, CONDURON G55 is suitable for application by painting with a fine hair flat brush.

Two coatings of CONDURON G55 are required for optimum protection.

Apply a first coating of CONDURON G55 thin and as evenly as possible. The coating should be allowed to air dry for about 3 hours. After that, a second coating is applied in the same manner which must again have thoroughly dried before the parts are put into the furnace.

Thorough drying of the coating prior to heating is essential because otherwise spalling of the coating may occur when the workpieces are put into the furnace.

During use, with the can open, CONDURON G55 has a tendency to thicken due to evaporation of the liquid vehicle in the paint. Normal consistency can be restored by adding small amounts of "Special Thinner for Conduron G55". Please note that overthinning would impair the effectiveness of the paint.

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Removal of Residues after Heat Treatment

After carburising and subsequent quenching, residues of CONDURON G55 must be removed by shotblasting or steelbrushing. They are not soluble in water or solvents.

Cleaning of Equipment

As mentioned above, CONDURON G55 cannot be resolved after drying. So, immediately after use, CONDURON G55 cans should be tightly resealed and the brushes cleaned with water. If painting is interrupted for any length of time, the brushes should be set in water to prevent drying of the bristles.

Storage

CONDURON G55 tins should be stored in a dry cool place. **Prevent from freezing.**