

# CONDURON G55HK

## Stop-off Paint for Deep Carburising in Gas up to Case Depths of 4 mm

### Characteristics

CONDURON G55HK is a special modification of CONDURON G55. It was developed for applications where, because of the small size or intricate shape of the areas to be protected, the following features are important:

- easy application by painting
- exact limitation of the coating
- perfect adherence to the steel surface.

CONDURON G55HK is extremely effective as a stop-off paint for all forms of gas carburizing. It is particularly suitable for deep case carburizing up to depths of 4mm max. (.160"). Because the residues of CONDURON G55HK are not soluble in water, alkaline solution or solvents, they must be removed after heat treatment by shotblasting or steelbrushing. CONDURON G55HK is free of any solvents which is important with respect of health and safety regulations.

### Application

Before applying, stir the contents of the CONDURON G55HK tin thoroughly. As received, CONDURON G55HK is suitable for application by painting with a fine hair flat brush.

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. Depending on case depth, one or two coatings of CONDURON G55HK are recommended for optimum protection against carbon pickup. First apply one coating of CONDURON G55HK as evenly as possible. If necessary for deeper cases up to 4mm, a second coating can be applied in the same manner.

**Drying time** which strongly depends on coating thickness, ambient and workpiece temperature, atmospheric humidity etc. can range from approx. 3 to 8 hours. For effective protection it is important to have the coating thoroughly dried before heat treatment is started. This can be checked by "fingernail test".

### Special Notes

During use, with the can open, CONDURON G55HK 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 G55HK". Please note that overthinning will impair the effectiveness of the paint. CONDURON G55HK is **not recommended** for applications using ammonia based atmospheres such as carbonitriding.

### Removal of Residues after Heat Treatment

After carburizing and subsequent quenching, residues of CONDURON G55HK must be removed by shotblasting or steelbrushing. They are not soluble in water or solvents.

**Cleaning of Equipment:** As mentioned above, CONDURON G55HK cannot be dissolved after drying. So, immediately after use, CONDURON G55HK 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 on the bristles.

**Storage:** CONDURON G55HK tins shall be stored in a dry cool place. Prevent from freezing

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