

CONDURSAL 710

Stop-off Paint for Deep Carburising up to Case Depths of 3mm

Properties

CONDURSAL 710 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 3mm max. Only one coating of CONDURSAL 710 is necessary for effective protection against carbon pickup. Therefore it is very economical. Because the residues of CONDURSAL 710 are not soluble in water, alkaline solution or solvents, they must be removed after heat treatment by shotblasting or steel wire brushing. CONDURSAL 710 is free of any solvents which is important in respect of health and safety regulations.

Application

Before applying, stir the contents of the CONDURSAL 710 tin thoroughly. As received, CONDURSAL 710 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 these areas are free of oil and grease.

Apply CONDURSAL 710 as evenly as possible to a thickness of approx. 0.2 to 0.3 mm (.006" to .010"). Only one coating is necessary for effective protection. During use with the can open, CONDURSAL 710 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 CONDURSAL 0118/710". Avoid overthinning; it would impair the effectiveness of the paint.

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

1. 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.
2. CONDURSAL 710 is not recommended for applications using ammonia based atmospheres such as carbonitriding.

Removal of Residues after Heat Treatment

After carburizing and quenching, residues of CONDURSAL 710 must be removed by shotblasting. They are not soluble in water or solvents.

Cleaning of Equipment

Immediately after use, CONDURSAL 710 cans should be tightly resealed and the brushes etc. cleaned with water. Deposits as well as contents of the can cannot be rejuvenated if the liquid vehicle becomes dry. Therefore, whenever painting has to be interrupted for some period of time, brushes should be set into water to prevent the bristles from drying and getting hard.

Storage

Cans of CONDURSAL 710 should be stored in a dry cool place; prevent from freezing.

The content of this leaflet is based on our actual knowledge. It provides a description of the product regarding properties and application without giving any guarantee or other legal binding assurance. It does not relieve the user from the responsibility of carrying out his own tests and experiments to check its suitability for his application. Also it is the user's responsibility to make sure that any proprietary rights and existing legislation are observed.

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