

VACUCOAT 0095

Water Washable Stop-off Paint for Low Pressure Carburising

VACUCOAT 0095 is a newly developed stop-off paint for Low Pressure carburising followed by quenching in oil or with pressurized gas.

According to the common practice in gas carburising, VACUCOAT 0095 coatings provide safe and exactly defined protection against carbon pickup, thus enabling following operations such as

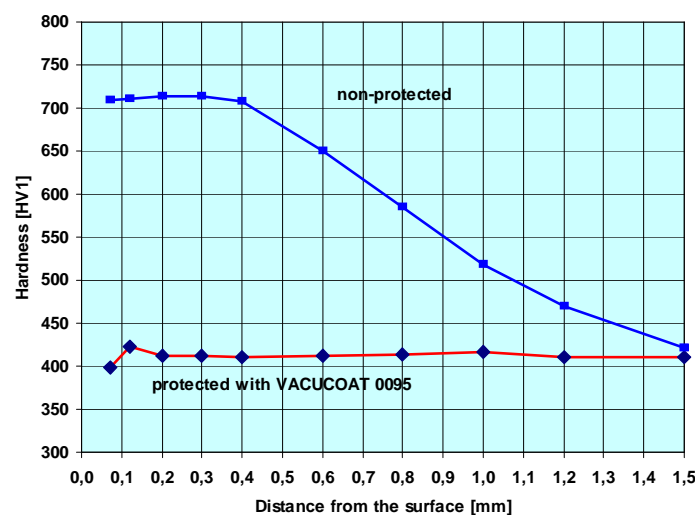
- cold forming
- drilling, turning, milling, broaching
- welding

Characteristics

As a most reliable stop-off paint for Low Pressure Carburising, VACUCOAT 0095 offers major benefits as listed below:

- Easy application by means of brushing, immersion, spraying, feeding
- Strong adherence to the steel surface
- Reliable protection up to case depths of approx. 4 mm
- Extremely low vapor pressure of the coatings ingredients
- Practically no deposits on the refractories of the furnace
- Enhanced removal of residues by washing with hot water or alkaline

Local Protection with VACUCOAT 0095
Steel grade 20MoCrS4, case depth 0,8+0,5 mm
carburising temperature 950°C, carburising time 120 min



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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Application

The surface areas to be protected have to be clean and dry. This means in detail that they must be free of oils and greases, humidity, dust, rust etc. This is normally achieved by aqueous washing, solvent degreasing or blasting.

After thoroughly stirring the content of the tin, the paint is applied to the surface areas to be protected like an oil paint by brushing, immersion, spraying or feeding. Only **one coating** of uniform thickness is necessary to provide safe protection.

Drying time

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".

On building the load, it has to be considered that coated parts should not get into contact with each other, in order to prevent unwanted protection in noncoated areas or, on the other hand, protection defects in coated areas.

After the heat treatment is completed, the residues of the paint can be easily removed from the workpieces by washing with hot water or alkaline, either after quenching in oil (respectively with pressurized gas) or after tempering.