CONDURSAL N9
Solvent base stop-off paint
for plasmanitriding / ionitriding

List for Troubleshooting

Preface

CONDURSAL N9 can be applied easily, similar to an oil paint. So it is important to clean and degrease the surfaces to be coated thoroughly prior to painting. Also it is important that the surfaces be free of oxides or passive layers whatsoever.
It is recommended to stir the paint thoroughly prior to use; **just shaking the tin will not provide satisfactory homogenisation!**

Soft brushes should be used for painting in order to provide a coating of uniform thickness. Before the parts are put into the furnace, the coating must be completely dry **which can be checked by fingernail test.**

For cases where in spite of proper usage according to the advice given in the leaflet poor insulation effect or other trouble is noted, please find listed below the possible defects, the reason why they can occur and the way how to avoid them.

TROUBLE	POSSIBLE REASONS FOR TROUBLE	HOW TO AVOID TROUBLE
Paint runs off after applying	1. Workpieces were not degreased satisfactorily prior to coating	Clean parts thoroughly by vapor degreasing or alkaline washing prior to applying the paint
	2. Paint has not been stirred or has been thinned excessively	Use paint as delivered but stir thoroughly prior to use
	3. Paint has been applied in a too thick coating	Apply paint in a thin coating of uniform thickness
Workpieces show a variety of little crater-shaped surface attacks after nitriding	Electric arcs caused by a) excessive electric energy b) excessive amount of the copper base paint per load	Reduce electric energy Reduce amount of Condursal N9 / load
After plasmanitriding the coated areas of the parts look like copperplated and the paint residues cannot be removed by wiping	same as above	same as above