

CONDURSAL Z0095

Solvent base water washable protective paint against oxidation / scaling

List for Troubleshooting

Preface

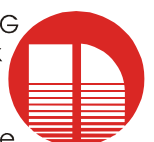
CONDURON Z0095 can be applied to the parts to be protected as a viscous oil paint.

It is recommended to stir CONDURSAL Z0095 thoroughly prior to use; **just shaking the tin will not provide satisfactory homogenisation!**

To provide proper adherence of the paint to the steel surface it is important to clean and degrease the parts to be coated thoroughly, to use soft brushes, to apply a coating of uniform thickness and **to allow the coating to thoroughly dry (which can be easily checked by fingernail test)** before the workpieces are put into the furnace.

For cases where in spite of proper use according to the CONDURSAL Z0095 leaflet poor protection 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
Paste runs off after being applied by painting/ spraying/ immersion	1. Paint has been stored at too high temperatures	Store paint at ambient temperature
	2. Workpieces have not been degreased thoroughly prior to coating	Clean parts thoroughly by vapor degreasing or alkaline washing
	3. Paste has been thinned excessively	Use paint as delivered after homogenizing the content of the tin; add small amounts of "Special Thinner for CONDURSAL Z0095) only if thickening has occurred
	4. Paint has been applied in a too thick layer	Apply paint in a thin coating of uniform thickness; if necessary apply twice.
Paste pops off after drying	Surfaces of workpieces were wet or greasy when paste was applied	Clean parts thoroughly by vapor degreasing or alkaline washing and make sure that they are dry prior to coating



TROUBLE	POSSIBLE REASONS FOR TROUBLE	HOW TO AVOID TROUBLE
Residues of the paint are glassy and hard to remove after annealing and surface attack has occurred	<ol style="list-style-type: none"> 1. Annealing temperature was more than 850 °C 2. There was a reaction of the coating with humidity either during intermediate storage of the coated parts or in the furnace 	<p>Restrict annealing temperature to 850 °C max.</p> <p>Prevent the coated parts from getting into contact with elevated humidity</p>
Residues of the paint form a dense black coating which is not water washable	Annealing temperature was less than 650 °C	Use CONDURSAL Z0095 for temperatures in the 650 to 850 °C range only (see leaflet)
Protection against oxidation / scaling has been found to be non-uniform or non-satisfactory	<ol style="list-style-type: none"> 1. Foreign substances left behind on the steel surface after drawing, cutting, stamping, forging etc. 2. Paint has not been stirred thoroughly prior to use 3. Paint has been applied in a too thin or streaky layer 	<p>Remove any contaminants / layers from the parts' surfaces by washing, solvent degreasing or shotblasting before paint is applied</p> <p>Stir paint thoroughly prior to use for homogeneous consistency</p> <p>Apply paint in a layer of even thickness; if necessary, apply twice but keep in mind that the first coating must be completely dry before the second one is applied</p>

Exclusion of liability

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.

