VACUCOAT 0095

Water Washable Stop-off Paint for Low Pressure Carburising

List for Troubleshooting

Preface

VACUCOAT 0095 can be applied as easy as a viscous oil paint. As with painting it is important to clean and degrease the surfaces to be coated thoroughly, to use soft brushes, to apply a coating of uniform thickness and to allow the coating to dry thoroughly before the workpieces are put into the furnace.

For cases where in spite of proper use poor insulation effect or other trouble is noted, we have 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
Paints runs off after applying by painting/ spraying/ immersion	1. Paint has been stored at too high temperature	Store at ambient temperature
	2. Workpieces have not been degreased satisfactorily prior to coating	Clean parts thoroughly by vapour degreasing or alkaline washing
	3. Workpieces have been too warm at the time when paste was applied (for instance after vapour degreasing)	Let workpieces cool down to ambient temperature (20 to 25°C) prior to coating
	4. Paint has been thinned excessively	Use paint as delievered; add small amounts of „Special Thinner“ only if thickening has occurred due to evaporation of solvent
.	5. Paint has been applied in a too thick coating	Apply paint in a thin coating of uniform thickness; if necessary because of deep case, apply twice
Paint pops off after drying	1. Surfaces of workpieces have been 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
	2. Coated parts have been stored fao a too long period of time at high atmospheric humidity	Store coated parts at a dry place and for not more ehan some days prior to carburising

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TROUBLE	POSSIBLE REASONS FOR TROUBLE	HOW TO AVOID TROUBLE
Paints runs off in the carburising furnace	1. Paint has been applied in a too thick layer / coating has not been allowed to dry thoroughly	Apply paint in a thin coating of uniform thickness and let it dry thoroughly
	2. Coated parts have been stored for a too long period of time at high atmospheric humidity	Avoid storing of the coated parts at high atmospheric humidity
	3. Parts have been preheated at temperatures of more than 200°C with oxygen present	Limit preheating temperature to 180°C
Residues of the paint are hard to remove after carburising / surface attack is noted	Coating has come into contact with humidity	See RUNNING-OFF PROBLEMS
	Coated parts have been cooled down after carburising and then reheated for quenching	Remove residues of the paste after carburising
Protection against carbon pickup has been found to be nonuniform or nonsatisfaction	Paint has been applied in a too thin or nonuniform layer	Stir paint thoroughly prior to use; apply paste in a layer of even thickness; if necessary for deeper cases apply twice but keep in mind that first coating must be dry prior to application of second one

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