LUISO W36

for gas carburizing

DAM Härtetechnik

www.stopoffpaints.com

- without solvents
- environment friendly and copper-free
- viscosity and course may be adjusted by water
- drying time appr. 30 minutes only
- good protection properties
- residues can be removed by sandblasting

Application

LUISO W36 is a copper-free and solvent-free stop off paint for gas carburizing. It provides good protection properties against carbon depths up to **max. 6 mm**. The stop off paint is delivered ready for painting.

Before using, **LUISO W36** should be stired up shortly and then applied with a paint brush. The work pieces to be treated must be free of grease and dirt! One layer is sufficiant. To avoid evaporation the cans should be sealed hermetically after use. To restore normal viscositiy the stop off paint can be diluted by adding up to 2 % water. No special thinners are necessary.

The dry off time for **LUISO W36** is 30 minutes. Unwanted paste residues may be removed easily with water. The heat treatment with **LUISO W36** should not exceed temperatures above 970 °C.

After heat treatment **LUISO W36** residues may be removed only by sandblasting, because of the excellent adhesion quality on the parts.

Packing

LUISO W36 to be delivered in PP-cans of 1, 5 or 10 kg.

Storage

LUISO W36 is sensitive to frost. Storage at room temperature is recommended. Opened cans should be closed after use. Storage time should not exceed 12 months.

Contact For further information please call us under telephone +49 (0)621 / 454 9 666

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Trouble Shooting

TROUBLE	POSSIBLE REASONS	HOW TO AVOID
Paint runs off after applying by painting, spraying or immersion.	1. Paint has been stored at too high temperatures.	Store paint at ambient temperature.
	2. Work pieces have not been de-greased thoroughly prior to coating.	Clean parts thoroughly by vapor degreasing or alkaline washing.
	3. Paint has been thinned excessively.	Use paint as delivered after homogenizing the content of the bottle/bucket; add small amounts of water only if thickening has occurred.
	4. Paint has been applied in too thick a coating.	Apply paint in a thin coating of uniform thickness; if necessary for deep cases, apply twice.
Paint pops off after drying.	1. Surfaces of work pieces were wet or greasy when paint was applied.	Clean parts thoroughly by vapor degreasing or alkaline washing and make sure that they are dry prior to coating.
Paint runs off in the carburizing furnace.	1. Paint has been applied in too thick layer/coating has not been allowed to dry thoroughly.	Apply paste in a thin coating of uniform thickness and let dry thoroughly.
	2. The organic binder of the paint has burnt because parts have been preheated at temperatures of more than 150 degrees C. with oxygen present.	Limit preheating temperatures to 150 degrees C. max.
	3. Coating has come into contact with oxygen in the carburizing furnace due to incorrect atmosphere regulation or cracking/leaking of the retort of the furnace.	Make sure by purging with nitrogen that even in the beginning of the carburizing process, furnace atmosphere does not contain oxygen/repair retort.
Residues of the paint are hard to remove after carburizing/ surface attack is noted.	1. Coated parts have been cooled down after carburizing and then reheated for quenching.	Remove residues of the paste after carburizing.
	2. Paint has not been stirred thoroughly prior to use.	Stir paste thoroughly prior to use.

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Am Bubenpfad 2, 67065 Ludwigshafen, Deutschland

Tel: +49 (0)621 - 4549666 / Fax: +49 (0)621 - 4549667

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