



ISO 9001:2008

Deluxe

Meproché

TECHNICAL BULLETIN

MEPROCHE N- 465 CARBO- NITRIDING SALT

Carbonitriding process is suitable for components/parts which have been finally machined and a hard case is to be imparted on them without distortions.

This is achieved by formation of hard nitrides of iron on the top surfaces. However the layer of nitrides insulate further penetrations and therefore the case depth achievable is low and the process time is long. Hence carbonitriding is adopted to have higher case depth.

MEPROCHE N-465 is a specially designed salt for Carbonitriding components by salt-bath technique, which gives much cheaper than gas-nitriding process.

Method of use of MEPROCHE N-465:-

- (1) The bath should be melted and aged for four hours before use.
- (2) Only cleaned, degreased and preheated components should be placed in the bath.
- (3) The bath should be analysed periodically and necessary salt should be added to maintain total Cyanates at 35 to 45% level and cyanides at 10% level.
- (4) Oxidation products formed from time to time should be removed.
- (5) The Carbonitriding is to take place at 675°C and the ideal temperature is 675°C.
- (6) It is advisable to keep the bath covered when not in use; it increases the life of bath.
- (7) Generally titanium crucibles or titanium plated crucibles give the best results.
- (8) The time of Carbonitriding cycle depends upon the case depth required.
- (9) Time of Carbonitriding can be curtailed if a slow current of air is passed through the molten salt. The bath temperature should not be allowed to go below 500°C, at this temperature, if reached,
heating should be accelerated to elevate the temperature.

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