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NDB Stop-Off

The One-Formulation "Do-All" Stop-Off Coating for All Heat Treating Processes

NDB Stop-Off coating is a "Do All" water-based coating for heat treating, being effective for all nitriding, carburizing, and carbonitriding atmospheres. NDB provides a hard abrasion resistant barrier layer on all metals -- proven effective for fluidized-bed processing, where abrasion resistance is mandatory. NDB has no environmental/flammability problems like solvent-based stop-off coatings.

Key Attributes

- 100% Effective for All Processes & Metals & Most All Case Thicknesses
- Abrasion-Resistant, Hard Coating
- Usable Even for Alloy Steels (8000 series, such as 8160)
- Applied Like Housepaint by Brushing, Dipping, or Spraying

Ideal Use

- Fluidized Bed Nitriding
- Vacuum, Gas, & Pack Carburizing
- Carbonitriding
- Salt Bath Treatment
- Scale & Decarburization Control

Use Notes

1. DO NOT DILUTE.
2. Resuspend the paint.
3. Clean surface of oils, dirt, scale etc.
4. Apply 2 to 3 layers by brush or spray.
5. Allow to thoroughly dry between coats and before use.
6. After use, remove residues by mechanical means, such as wire-brushing, bead-grit-blasting, dry-ice (CO₂) blasting, etc.



Specifications

Active Ingredient	Sodium-Potassium-Aluminum-Silicate
Max Use Temperature	2012 F/ 1100 C
Use Atmosphere	All
Fired Composition	Mixed Ceramic Oxides
Liquid Carrier	Water
Brookfield Viscosity (cps)	600-1600 @3/60
Specific Gravity	1.7
Color	Yellow-Orange
Shelf Life (months)	>12
Coverage (ft ² /gal)	100-400
Coating pH	9-10
H F R Ratings	1-0-0
Substrate Use	All
Other	Nearly water-insoluble after drying

Sizes and colors

NDB Stop-Off is a yellow-orange colored paint. Standard Size: wide-mouth 1 gallon pail.

Safety Information

- Consult SDS before use.
- Avoid breathing of spray/vapors.
- For Industrial Use only.

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