

Beta Superior No 1 Case Hardening Compound (0065)

These processes will create toxic fumes, you must consult the SDS and perform your own risk assessment.

1. 	<u>For mild steel</u> Heat the component uniformly from mid to bright cherry red in colour (720 - 750C). <u>For deeper cases</u> Cover the component in the compound in an open shallow receptacle and heat to 720 - 750C for 15 - 60 minutes depending on the depth of hardness required	2. 	<u>For mild steel</u> Dip/roll the component in the compound and leave for 1 - 2 minutes. <u>For deeper cases</u> Use dry tongs to remove from molten compound and quench only in clean water. <u>For tool steel</u> Heat the component as above and dip/roll in the compound until the right tempering heat is reached. Re-heat and repeat the process until the desired depth of hardening is achieved then quench in clean cold water or oil. This will produce the ultimate in hardness and prevent cracking.
3. 	<u>For mild steel</u> Remove from the compound and gently brush away the excess build-up of the compound.	4. 	<u>For mild steel</u> Leaving 1 - 2 mil thickness of residue on the surface re-heat the component until the compound on the surface starts to darken and liquefy.
Steps 1, 2, 3 and 4 can be repeated 2 - 3 times until the desired depth of hardening has been achieved. Following the final heat process the component should be quenched in clean cold water using a scrubbing action to maximize cooling.			
We would always recommend running through the process with an initial test piece prior to use.			
Disclaimer: No conditions or warranty is to be implied by the supplied information.			