

Procedure: Coating Application

Purpose

Coating procedure for applying **FOSECO Dycote 3900**

References

Safety Data Sheet – Foseco Dycote 3900

Procedure

1. Thoroughly clean die surfaces, preferably using abrasive blasting.
2. Using the electric die heater, preheat the die to 200-250 C.
3. Dilute Dycote 3900 to 1:5 with water, this will give a Baume range of 10-12.
4. Using a spray gun with a fin nozzle (about 1mm) apply the appropriate layer thickness by doing multiply passes.
5. When the desired application is achieved, preheat the die to 400 deg C and hold for one hour or until the yellow die coating changes uniformly to pink.
6. If during service DYCOTE 3900 wears or is damaged, touch-ups can be done using a dilution of 1part DYCOTE 3900 to 8 parts water.

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Procedure: Coating Application

Purpose

Coating procedure for applying **Thermalcoat 300 Ceramic Coating**. For use on steel hand ladles, steel stirrers, skimmers and steel/cast iron dies.

References

Safety Data Sheet – Thermalcoat 300 Ceramic Coating

Procedure

1. Thoroughly clean surfaces by abrasive blast.
2. Can be applied by brushing, spraying, dipping or swabbing, can be applied undiluted or when required diluted 1:1 for spraying.
3. Thoroughly air dry prior to contact with molten metal.
4. Alternatively, items being coated can be preheated, prior to coating.

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Procedure: Coating Application

Purpose

Coating procedure for applying **Pyrotek Boron Nitride Hardcoat** (Grey). Ideal for coating of Steel ladles metal skimmers, dies and Immersion tubes.

References

Safety Data Sheet – Boron Nitride (BN) Hardcoat (Grey)

Procedure

1. Thoroughly stir the coating.
2. Do not dilute.
3. Clean surfaces by brush or preferably by abrasive blasting.
4. Apply 1 – 2 thin coats by brushing or spaying at room temperature or below 80 C.
Allow to thoroughly dry between coats.
5. Once thoroughly dried slowly immerse into molten metal.

Purpose

Coating procedure for applying **Pyrotek Boron Nitrate Lubriccoat ZV** (Blue). Ideal for coating Steel ladles, skimmers, immersion tubes and steel and cast iron dies.

References

Safety Data Sheet - Boron Nitride (BN) Lubriccoat ZV (Blue)

Procedure

1. Use full strength or dilute with water at 2 parts water to 1 part Pyrotek Boron Nitride Hardcoat.
2. Clean surfaces, preferably using abrasive blasting.
3. Apply 1-3 coats by brush, dipping or spray, dry after each coat.
4. Allow to thoroughly dry before use.

Pyrotek Boron Nitride Hardcoat can be used as a basecoat for **Pyrotek Nitrate Lubriccoat ZV** (Blue).

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