

HEAT TREAT 660
 (Neutral Hardening Salt)

Heat Treat 660 is a neutral hardening salt recommended for hardening of high carbon steel, alloy steel etc. It is also recommended as a preheating salt for high carbon steel and hot work steel.

ADVANTAGES :

- It does not decarburize the surface of the steel heat treated.
- It does not pit or etch the surface
- It reduces the heat treatment time as against dry heat or muffle type furnace.
- It obtains uniform structure throughout the entire heat treated part.
- It is universal accepted heating medium for the heat treatment of high carbon alloy steel that are either ground or not ground after heat treatment.
- It does not fume or decompose at the recommended working temps.
- It does not attack container under normal conditions.
- It reduces cleaning cost due to the prevention of oxide formation on surface of steel.

Melting Point : 660`C
 Working Range : 660-900`C
 : 660-1000`C with Heat Treat Additive

Bath Preparation : Heat Treat 660 salt bath is freshly prepared by adding the salt to two third volume of the pot and pot is heated to liquifying temp of the salt then the required amount of the salt is added to bring the level of the pot to the operating level. Replenishment of the salt is carried out by adding Heat Treat 660 salt directly to the bath with the help of spatula.

Bath Rectification : To keep Heat Treat 660 in original condition, it should be kept clean. Heat Treat 660 salt absorb the air to certain extend while in operation and reacts to a limited extend with atmospheric moisture and carbon dioxide which will cause in time decarburizing action if they are not removed. The process of removing these objectionable products and cleaning the bath is simple. It is only necessary to add daily Regenerator PR in the proportion of 0.25% of the content of the bath. Immediately upon the addition of Regenerator PR the cleaning action begins. This action is distinguished by a evaluation of gas, a slight cracking sound and the formation of thin vicious slag on the surface of the bath. This slag is not required to be removed as it does not sticks to the surface of the work being treated and tends to protect surface of the bath from further contact with the atmosphere and is helpful in many ways. If for any reason thicker layer of slag is formed over the entire surface of the bath, then the excess should be skimmed off and thrown away, and only a small amount left on the surface.

Equipment : Mild Steel pot or heat resisting alloy steel pot is recommended for externally heated furnaces. Ceramic lined pots are recommended for electrode furnace.

Safety : Heat Treat 660 salts are neutral in nature. As it is operating at higher temp. use of asbestos gloves, goggles and protective clothings are recommended during the operation. Use of spatula is recommended while adding salt to the molten bath.

Disposal : Heat Treat 660 salt contains barium, sodium and potassium salts. It is therefore recommended to dispose the fused salts as per the norms of the pollution board.

NON WARRANTY

THE INFORMATION IN THIS TECHNICAL DATE SHEET IS BASED ON OUR SKILL, EXPERIENCE AND TESTS WHICH WE BELIEVE TO BE RELIABLE BUT PROTOCHEM INDUSTRIES OFFER NO GUARANTEE AND CANNOT ACCEPT RESPONSIBILITY FOR OPERATION NOT UNDER THEIR DIRECT CONTROL.