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**Product Name:** Coating for Protecting Materials Against Nitriding

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**Product Number:** PL37 (ANL)

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**Product Description:**

- A 2-part air dry tin rich lacquer used as a stopping off medium during the nitriding process.
- Originally developed by Rolls Royce in their own labs and made under licence by Acheson Colloids, (where it was known as ANL – Anti Nitriding Lacquer).
- This material is now made by Indestructible as one of our specialist product ranges. Competitive to Degussa WSN 100 and Acheson's Nitrostop N4 which contains xylene.
- Should not be used near copper parts, as tin melts into it which creates bronze.

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**Approvals/Specifications:**

- CSS 60 apply in accordance with RPS 135 (was RR 138204)
- OMat 7/181A

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**Performance:** Mixed product air dries in 2 hours. Please also refer to Product Description

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**Components:**

Part "A": Lacquer  
Part "B": Powder for mixing in to Part "A"

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**Application:**

**Surface Preparation:** Surface must be clean and free from grease, dirt and oil.

**Paint Preparation:** Add component "B" to Component "A". Ensure well stirred in and homogeneous before use.

**Application Method:** Degrease to RPS 313 (Genklene)

- Mask using suitable tape or jigs

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- Prepare PL37 by mixing the two components and stirring thoroughly
- Brush or spray one coat of PL37 on the surface where nitriding is not required to a film thickness of 0.050 to 0.075mm
- Air Dry
- Remove masking
- Nitride the component with minimum delay

#### Stop off Test

- Mix the two parts together thoroughly
- A suitable diameter Hykro Izod test bar shall be degreased and half its area coated by brushing or spraying with one coat of the mixed lacquer and tin powder
- After a minimum of 2 hours drying time, the test bar shall be nitride in accordance with RPS 135 using the 60 hour treatment.
- *Note:* a fusing treatment is necessary before nitriding as detailed in RPS 135
- After nitriding, the test bar shall be dry abrasive blasted all over using 120-220 mesh alumina, any suspect areas as evidenced by bright hard spots, shall be micro sectioned and examined to ensure that complete stopping off has been effected on the areas treated.

#### Drying Curing:

Air dries in 2 hours.

#### Technical Properties:

<b>Supply Viscosity:</b>	Not Applicable
<b>Flash Point:</b>	Part "A": Below 4°C Part "B": N/A
<b>VOC Content:</b>	Part "A": Part "B": N/A
<b>Colour:</b>	Part "A": Yellow/ Grey Part "B": Grey/ Silver Powder
<b>Pack Size:</b>	Part "A" both in 125ml. Plastic bottles
<b>Density:</b>	Part "A": 0.885 -0.915 kg/l Part "B": N/A.

# Technical Data Sheet



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<b>Gloss:</b>	Semi-matt
<b>Thinner:</b>	N/A
<b>Solvent/Clean Up:</b>	40005 Gunwash
<b>Catalyst:</b>	N/A
<b>Theoretical Coverage:</b>	-

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## Storage:

Highly flammable liquid: store and use in accordance with the flammable liquid regulations

**Shelf Life:** 12 months temperate; 6 months tropical

**Before use, refer to Product Safety Data Sheet**

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## Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

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