

THERMIC SH 615

Heat Treatment

DESCRIPTION

THERMIC SH 615 is a soluble quenching polymer, which is nitrite, DEA, formaldehyde free. It has adjustable cooling speeds, managed with dilution ratios in order to cover a wide range of applications. It can also be used for tempering stop under specific conditions.

RECOMMENDED APPLICATIONS

THERMIC SH 615 has been specially designed for superficial quenching and heating by induction or conduction. The concentration to use depends on the nature of the steel you wish to quench, and the quenching depth.

Generally, concentration of **THERMIC SH615** is between 6 and 15% (shower, dipping...). The advised temperature of bath is between 30 and 50°C maximum. **THERMIC SH 615** can also be used for tempering stop from 4% concentration.

PROPERTIES

THERMIC SH 615 has been developed to comply with the following criteria:

- New technology, formaldehyde free
- Wide range of use allowing treatment of different steels
- Very good resistance to microorganisms (bacteria and fungi)
- Good protection against corrosion (machine parts and quenched parts)
- Easy cleaning of quenched parts

ADVANTAGES

- ➔ **THERMIC SH 615** is very cost effective:
 - Low concentration
 - Reduced product consumption: loss in chips and parts is limited
- ➔ Few residues on parts
- ➔ Easy filtration of baths (no logging of filters)
- ➔ **THERMIC SH 615** gives short term corrosion protection of quenched parts which avoid the use of an additional product for temporary protection
- ➔ Very good dermatological behavior

TECHNICAL INFORMATIONS

CHARACTERISTICS	METHOD	UNIT	PURE PRODUCT
Color			colorless
Density at 20°C	ISO 12185		1.05
Viscosity at 40°C	ISO 3104	mm²/s	62
CHARACTERISTICS	METHOD	UNIT	DILUTED PRODUCT
pH at 10% and at 23°C	D15 1666		9.2
Refractometric coefficient			2.5
Cloud point at 15% TH 40	D1721		>80°C

The specifications are given for information purposes only and may need to change.

PRECAUTIONS FOR USE AND STORAGE

Periodically check the concentration of the product in use, using a refractometer and comply with the attached curve. It is recommended to store the products in temperate conditions in sealed containers.

THERMIC SH 615 concentration must be checked regularly with a refractometer and must be adjusted in accordance with the graph below, correction coefficient 2.5. In case of a long pause of the machine (end of the week for example), it is necessary to adjust the concentration at the upper limit value.

Installation must be cleaned regularly (especially the showers), do not leave saturated filtration media in contact with the fluid during production pauses. It is recommended to store products in a tempered warehouse and in closed drums. Expiration date: in storage conditions defined above in initial sealed packaging.