



## Durferrit Salts and Auxiliary Products



**Product Catalogue**



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## Nitrocarburizing

Ionic liquids offer a significant improvement in wear protection, sliding properties and fatigue strength on all kind of ferrous materials. A subsequent oxidizing quenching produces a major increase in corrosion resistance. Due to the main process characteristics like

- ⇒ **excellent reproducibility on high quality level**
- ⇒ **shortest treatment times**
- ⇒ **most negligible distortion**
- ⇒ **highest flexibility**

This technology often gives superior results to that of galvanic layers and other nitrocarburizing processes.



## Salts for nitrocarburizing

With TUFFTRIDE® and ARCOR® we offer two different environment-friendly processes for nitrocarburizing. Which of both processes is the most appropriate one

depends on the requirements and the geometry of the parts. Our Technical Sales Department will be pleased to giving you advice to make the right choice.

### TUFFTRIDE®-Process

| Product            | Application   | Working temp. in °C |
|--------------------|---|---------------------|
| TF 1               | Cyanide-free replenishment salt.<br>For use only with REG 1 regenerator.                                      | 480 – 630           |
| REG 1              | Non-toxic regenerator for TF 1 baths.   |                     |
| AB 1<br>AB 1.8     | Oxidizing salts for enhancing the corrosion resistance of TUFFTRIDE® treated components and for QPQ®-process. | 370 – 420           |
| AB 1 A<br>AB 1.8 A | Starter salts for the initial filling.  |                     |

## ARCOR®-Process

| Product | Application  | Working temp. in °C |
|---------|--|---------------------|
| CR 2    | Non-toxic regenerator for CR 4 baths.  |                     |
| CR 4    | Cyanide-free replenishment salt for the ARCOR® C-process;<br>for use only with CR 2 regenerator.                           | 540 – 590           |
| CR 8    | Cyanide-free replenishment salt for the ARCOR® V/N-process;<br>for use only with CR 9 regenerator.                         | 480 – 630           |
| CR 9    | Non-toxic regenerator for CR 8 baths.  |                     |
| OX R    | Oxidizing salt for cooling parts treated with CR 4 or CR 8;<br>leads to an important increase of the corrosion resistance. | 420 – 440           |
| OX 1.2  | Starter salt for the initial melting of OXINIT baths.  |                     |

## NSK

| Product | Application   |
|---------|---|
| NSK     | In special cases for the artificial activation of TF 1 baths. |



## Solid nitrocarburizing products

Powder nitriding (Pulnieren) is done analogical to pack carburizing and does not require complex

equipment. It is a very economical process for the treatment of small series or tools.

| Product                    | Application  | Working temp. in °C |
|----------------------------|--|---------------------|
| Pulnierpulver<br>Aktivator | Cyanide-free base powder.<br>Non toxic activation product. The required amount depends on the treated parts. | 450 - 600           |

# Carburizing and Carbonitriding

Carburizing salt melts feature following advantages:

- ⇒ **the best temperature uniformity**
- ⇒ **high reproducibility of the carburizing effect**
- ⇒ **easy to control**
- ⇒ **very flexible in use**

DUROFER® is an environmental friendly process as the products don't contain any cyanide and the carbon activity is controlled by adding the regenerator CECONTROL®. Hence amount of waste salts are considerably reduced. This technology can also be used for hardening being free of decarburization as long as the melt is set for low activity.



## DUROFER®-Process

| Product                             | Application  | Working temp. in °C |
|-------------------------------------|--|---------------------|
| CECONTROL®                          | Non toxic regenerator. For use only with the base salts CECONTROL® 50 H, 80 B and 110 B.   |                     |
| CECONTROL® 50 H                     | Cyanide free start-up and replenishment salt to achieve a surface carbon level of approx. 0.5 % C. For use only with CECONTROL® regenerator.   | 780 – 950           |
| CECONTROL® 80 B<br>CECONTROL® 110 B | Cyanide free start-up and replenishment salt to achieve surface carbon level of 0.8 % resp. 1.1 % C. For use only with CECONTROL® regenerator. | 820 – 950           |



## Other salts for carburizing and carbonitriding

| Product                               | Application   | Working temp. in °C |
|---------------------------------------|---|---------------------|
| CECONSTANT® 80<br>CECONSTANT® 110     | One-salt system to achieve a surface carbon level of approx. 0.8 resp. 1.1 % C. | 850 – 950           |
| CECONSTANT® 80 A<br>CECONSTANT® 110 A | Starter salts for the initial filling.  |                     |
| GS 540 / C 3                          | This two-salt system is also suitable for carbonitriding below A <sub>1</sub> . | 700 – 950           |

## Solid carburizing products

Pack carburizing is a technology which can be operated in simple chamber furnaces. Our products are granules which are characterized by their

- ⇒ **consistent carburizing activity**
- ⇒ **low sulfur content**
- ⇒ **high stability**
- ⇒ **low tendency of forming dust during usage**
- ⇒ **capability of being used several times**

| Product             | Application   | Working temp. in °C |
|---------------------|---|---------------------|
| KG 6.2              | Mild carburizing granules for carburizing alloyed steels to depths over 0.6 mm.   | 900 approx.         |
| KG 30.2             | Strong carburizing granules for carburizing non-alloyed and alloyed steels with depths up to approx. 0.6 mm.                                | 900 approx.         |
| AUFSTREUHÄRTEPULVER | For surface hardening of tools. The powder is sprinkled onto the tool after bringing it to red heat with the welding torch or in a furnace. |                     |

## Annealing and Hardening

Annealing salts are usually used as part of a 2-salt system in combination with an additive, otherwise decarburization and oxidation will take place with increasing treatment temperature. We are offering two different classes of additives.

The cyanide-free products bind successfully oxygen containing compounds and ensure the inert character of the liquid. They can be used up to a temperature of 1100 °C.

The second class of additives gives the melt a certain carbon activity which depends on its concentration and the nature of the base salt. However, due to the short treatment times the carbon activity is allowed to vary considerably from the carbon content of the steel and has not to be adjusted within closer limits. The DUROFER®-Process is also suitable for hardening being free of decarburization (see carburization and carbonitriding) as long as the melt is set for low activity.



## Base salts

| Product          | Application  | Working temp. in °C      |
|------------------|--|--------------------------|
| GS 230           | For quenching and tempering above 300 °C.  | 270 – 600                |
| GS 430           | For tempering, cooling or quenching of steel for which AS bathes are not suitable. | 500 – 700                |
| GS 520           | Replenishment salt for GS 430 baths.   |                          |
| GS 540           | For heating and annealing.   | 600 – 950                |
| GS 560           | Barium free salt for annealing silver, gold and brass.                             | 600 – 850                |
| GS 660           | Nontoxic salt for annealing steel and non-ferrous metals.                          | 700 – 900                |
| GS 670<br>GS 750 | For heating and annealing.   | 750 – 1000<br>850 – 1100 |
| GS 960           | For heating and annealing.   | 1050 – 1250              |

## Additive salts for inert annealing; cyanide-free

| Product | Application   |
|---------|---|
| R 2     | For the prevention of decarburization and oxidation in combination with GS 540, GS 670, GS 750.   |
| R 3     | Nontoxic additive for the prevention of decarburization and oxidation in combination with GS 660. |



## Additive salts for preventing decarburization

| Product | Application   |
|---------|---|
| C 1     | For the prevention of decarburization and oxidation in combination with GS 540, GS 560, GS 660 and GS 670, if the carbon content of C 3 is undesirable. |
| C 3     | For the prevention of decarburization and oxidation in combination with GS 540, GS 560, GS 660 and GS 670. Contains active carbon to form a bath cover. |

## Supplements

| Product         | Application   |
|-----------------|---|
| SCHUPPENGRAPHIT | For covering baths to reduce temperature losses. This product is only scattered in small amounts and can also be used for cyanide-free annealing baths. |
| AKTIVAT         | Covering agent to reduce temperature losses. Suitable for baths having a certain carburization activity.  |
| DRS 3           | A dip emulsion that prevents rusting.   |



## Heat Treatment of High-Speed Steel

Tools treated in our salts are well known for their superior quality. Due to the highest temperature uniformity and quickest heat transfer a fine grain structure with the corresponding proportion of solute carbides is achieved. Pre eutectoid carbide precipitation at the grain boundaries or local formation of intermediate structure are avoided. Our technology provides benefits like:

- ⇒ **Highest hardness combined with excellent toughness.**
- ⇒ **Partial hardening easy realizable.**
- ⇒ **Ideal quenching conditions regardless of part diameter.**
- ⇒ **Lowest distortion compared to other hardening processes.**



| Product             | Application   | Working temp. in °C |
|---------------------|---|---------------------|
| GS 540              | Salt for the 2 <sup>nd</sup> preheating stage.  | 800 – 950           |
| GS 750 / R 2        | 2-salt systems for the 3 <sup>rd</sup> preheating stage.  | 1050 – 1100         |
| CARBONEUTRAL®       | For austenitizing of high alloyed tool and high-speed steels. Additives are reducing decarburization.                               | 1000 – 1300         |
| SEMPERNEUTRAL® 950  | For austenitizing of high alloyed tools and high-speed steels. Additives prevent from decarburization.                              | 1100 – 1300         |
| SEMPERNEUTRAL® 1100 | For austenitizing of high-speed steels. Additives prevent from decarburization. Less sensitive to moisture than SEMPERNEUTRAL® 950. | 1200 – 1300         |
| GS 430              | Quenching salt for high alloyed tool and high-speed steels.   | 500 – 580           |

## Supplements

| Product  | Application   |
|----------|---|
| DUOPERL® | For covering the CARBONEUTRAL® or SEMPERNEUTRAL® baths. |
| GS 960   | For saturating a new lining of the furnace.             |
| DRS 3    | A dip emulsion that prevents rusting.                   |

# Quenching and Tempering

The great benefits of martempering are the lowest grade of size alteration and distortion. The austenitized components are quenched to a temperature close above the martensite starting point to ensure temperature equalization between surface and core. This allows a martensitic formation being as uniform as possible during further cooling.

Moreover, for austempering the AS salts are the first choice as these assure the best attainable toughness.



## Salts for quenching and tempering

| Product | Application   | Working temp. in °C |
|---------|---|---------------------|
| AS 140  | For austempering, martempering, tempering and blueing.<br>Not suitable for components which are heated above 950 °C or treated in a bath containing more than 13 % KCN.             | 160 – 550           |
| AS 220  | For austempering, martempering, tempering and blueing.<br>Not suitable for components which are heated above 950 °C or treated in a bath containing more than 13 % KCN.             | 250 – 550           |
| AS 235  | Non toxic salt for austempering, martempering, tempering and blueing. Not suitable for components which are heated above 950 °C or treated in a bath containing more than 13 % KCN. | 280 – 550           |
| AS 300  | Non toxic salt for austempering, tempering and blueing.<br>Not suitable for components which are heated above 950 °C or treated in a bath containing more than 13 % KCN.            | 340 – 550           |
| GS 430  | For quenching and tempering parts which are austenitized at temperatures above 950 °C.  | 500 – 560           |

## Specials

### Additives for water quench

Some materials like mild or low alloyed steel need such rapid cooling rates which can only be realized in water. However, plain tap water will evaporate on the hot surface during quenching (Leidenfrost phenomenon) resulting in reducing quenching speed with high risk of local pearlite formation. The HYDRODUR®-additives restrain successfully this phenomenon and give very clean parts.



| Product      | Application  |
|--------------|--|
| HYDRODUR®    | Additive for improved water quenching performance, gives components silver grey appearance. At 70 °C the maximum cooling rate is approx. 50 % higher than water.   |
| HYDRODUR® GF | Non toxic additive for improved water quenching performance. At 70 °C the maximum cooling rate is approx. 25 % higher than water.                                  |
| HYDRODUR® 20 | Additive for improved water quenching performance, gives components slightly dark appearance. At 70 °C the maximum cooling rate is approx. 50 % higher than water. |

### Corrosion protection

After cleaning, the work piece must be treated to prevent the very sensitive metal surface against corrosion.

| Product | Application                           |
|---------|---------------------------------------|
| DRS 3   | A dip emulsion that prevents rusting. |

### Covering products for waste salts

| Product  | Application   |
|----------|---|
| DUROSORB | For sprinkling waste salts. Prevents the release of odours. |

## Aluminium Heat Treatment

The quality of solution annealed and age hardened aluminium resp. aluminium alloys increases strongly with temperature uniformity as well as with the speed of heat transfer. For that reasons liquid salts are the first choice.

They are well known for their excellent temperature constancy and provide

- ⇒ **quickest heat transfer by contact which successfully oppressed grain growth for gaining a very fine core structure**
- ⇒ **avoidance of deleterious precipitation of alloying elements on grain boundaries since the remaining salt film on the parts prevents from critical cooling effects during transfer into quenching station**
- ⇒ **shortest treatment times.**



## Salts for the annealing of aluminium and aluminium alloys

| Product | Application  | Working temp. in °C |
|---------|--|---------------------|
| AVS 220 | For solution annealing and age hardening of aluminium and aluminium alloys containing maximal 10 % of magnesium. | 270 – 550           |
| AVS 250 | For solution annealing and age hardening of aluminium and aluminium alloys containing maximal 10 % of magnesium. | 340 – 550           |

## Boriding

Boriding is a thermochemical process which gives components

- ⇒ **very high hardness up to 2000 Vickers**
- ⇒ **outstanding abrasive wear resistance**
- ⇒ **high temperature strength up to 800 °C**
- ⇒ **strongly reduced sticking properties**

We supply the boriding product alternatively as fine granules or as paste. Both give excellent layer qualities and oppress successfully the unwanted very brittle FeB-phase.



## Boriding products

| Product         | Application  | Working temp. in °C |
|-----------------|--|---------------------|
| DURBORID® G     | Granules that create perfectly formed boride layers for maximum performance. After treatment the work piece can be easily removed.   | 850 –1000           |
| DURBORID® PASTE | Water-based boriding paste, submersible and sprayable, hardly drips for high quality layers. Also suitable for partial boriding. Must be used with an inert gas (Ar, N <sub>2</sub> ). | 850 –1000           |

# Blackening

Blackening produces an uniform deep black layer on components made from ferrous materials which gives them a decorative appearance. It is performed by immersion in a boiling alkaline oxidizing salt solution.



## Salts for blackening Pre- and post-treatment products

| Product                  | Application  | Working temp. in °C |
|--------------------------|--|---------------------|
| G 19 / G 22              | Alkaline cleaner for hot degreasing prior to blackening.   | 60 – 80             |
| BEIZENTFETTER            | For descaling prior to blackening. Has some degreasing properties.   | RT                  |
| FERROBLACK® MH           | Blackening salts containing special additives for a wide range of application.                                     | 140 approx.         |
| FERROBLACK® SPEZIAL      | Ideal for blackening silicon containing steel and cast iron.   | 140 approx.         |
| FERROBLACK® HL           | Particularly suitable for parts with copper coatings and brazed joints.  | 140 approx.         |
| FERROBLACK® NIF          | Non-toxic blackening salt; more suitable for 2-bath processes.   | 140 approx.         |
| FERROSOL HL              | A booster for all blackening bathes either for short-term regeneration or for treatment of complicated workpieces. |                     |
| STREICH-<br>BRÜNIERBEIZE | A fluid product for brushing on or immersion at room temperature. Ideal for repairs and hobby use.                 | RT                  |
| DRS 3                    | A dip emulsion that prevents rusting.  |                     |

## Salts for Heat Transfer

Very often chemical processes take place in a closely defined and frequently very narrow temperature range. In industrial plants, salts are used as heat transfer media for heating and cooling as well as for holding at constant temperature. Our heat transfer salts offer following benefits:

- ⇒ **excellent heat transfer properties**
- ⇒ **low meeting point approx. 142° C**
- ⇒ **best possible chemical consistency**
- ⇒ **regenerable within certain limits**
- ⇒ **pressure-less operation despite high working temperatures**



| Product | Application  | Working temp. in °C |
|---------|--|---------------------|
| ASD     | Heat transfer salt for the chemical industry.                                | 180 – 450           |
| ASD REG | For regenerating ASD salts.  |                     |
| HT 400  | Heat transfer salt for the chemical industry for use at higher temperatures. | > 400               |

## Salts for Vulcanizing

RUBBERCURE products are special designed heat transfer salts used with great success for the vulcanization of rubber profiles which are for example continuously extruded. Some of their advantages are

- ⇒ **high vulcanization speed**
- ⇒ **compact profile surface without any porosity**
- ⇒ **high long-term thermal stability of the salt melt**
- ⇒ **excellent protection against corrosive attack**
- ⇒ **rubber profiles are easy to clean**



| Product        | Application                             | Working temp. in °C |
|----------------|---|---------------------|
| RUBBERCURE     | For vulcanizing in LCM and PLCV plants. | > 180               |
| RUBBERCURE LAS | Non toxic classified vulcanizing salt.  | > 160               |

# Thermochemical Cleaning of Metallic Surfaces

Cleaning salts are used for the quick and gentle removal of coatings which are difficult to dissolve, even in narrow crevices and small bore holes.

The formulation of each product is optimized regarding their special application.



## Cleaning salts

| Product        | Application  | Working temp. in °C |
|----------------|--|---------------------|
| ALKO® N        | For descaling titanium.  | 200 – 220           |
| KOLENE® No. 4  | Removes moulding sand, graphite, oil coke, casting crust and scale.<br>For cast iron, steel and cast aluminium.  | 400 – 500           |
| KOLENE® No. 5  | Removes organic materials: semi and fully synthetic plastics, paint, lacquer, grease, oil, resin, carbon, graphite, rubber etc.<br>Ideal for cleaning steel and cast iron.                         | 400 – 500           |
| KOLENE® No. 6  | Removes paint, oil carbon and plastics from aluminium and steel work pieces, also grey cast iron.  | 300 – 400           |
| KOLENE® No. 10 | Removes organic materials: semi and fully synthetic plastics, paint, lacquer, grease, oil, resin, carbon, graphite, rubber etc.<br>Ideal for cleaning chrome-alloyed tools.                        | 380 – 480           |
| DGS®           | Removes scale and rolling skin, metal oxides, glass residue (drawing agent), sand residue, oil coke, oil, grease and other organic traces from stainless steels and other Cr / Ni materials.       | 370 – 540           |
| RS 700         | Removes ceramic moulding material based on silicon and aluminium oxides, also zirconium oxide, from precision castings. Devitrifies Pt-Rh-spinning nozzles and similar components, removes enamel. | 600 – 700           |

KOLENE® is a registered trademark of Kolene Corporation.



## Stop-off Compounds

Based on our long lasting experience the stop-off compounds are continuously optimized especially regarding environment and safety at work. The products are offering benefits like

- ⇒ **best protection**
- ⇒ **easy in use**
- ⇒ **short trying times**



## Aqueous lacquer based masking compound

| Product              | Application  |
|----------------------|--|
| CONTRADUR WSC 200    | Silicate free product for gas carburizing up to 1.3 mm case depth; applicable by painting; easy removable with hot water or alkaline cleaner |
| CONTRADUR® WSC 201   | Silicate free product for gas carburizing up to 1 mm case depth; applicable by dipping; easy removable with hot water or alkaline cleaner.   |
| WAGA                 | For gas carburizing for more than 1.3 mm case depth; applicable by painting or dipping.  |
| WAGA Plus            | For gas carburizing for more than 1.3 mm case depth; favorable at higher humidity; applicable by painting.                                   |
| ANTIDUR              | For gas carburizing for more than 1.3 mm case depth; applicable by dipping.  |
| CONTRADUR WSN 100    | For gas nitriding and nitrocarburizing; applicable by painting.  |
| CONTRADUR Spezial PN | For plasma nitriding and nitrocarburizing; applicable by painting.   |



## Solvent based stop-off compounds

| Product        | Application   |
|----------------|---|
| CONRADUR GAKO  | For gas carburizing up to 1.3 mm case depth; applicable by painting or dipping.                     |
| CONRADUR UDK-N | For low pressure and vacuum carburizing up to 1.7 mm case depth; applicable by painting or dipping. |
| S 100          | For gas and plasma nitriding; applicable by painting.   |
| THINNER I      | Thinner for CONTRADUR GAKO and S100.  |
| THINNER II     | Thinner for BLACK 15 N and CONTRADUR UDK-N.   |

## Kneadable stop-off compounds

| Product | Application  |
|---------|--|
| ATOMIN  | For pack carburizing and sealing hardening boxes; easy kneadable and removable; esp. for small holes, threads, etc.          |
| REKORD  | For pack carburizing and sealing hardening boxes; only little shrinking properties; favorable for larger areas or pin holes. |

## Product list

|                                   |      |                             |              |
|-----------------------------------|------|-----------------------------|--------------|
| AB 1 / AB 1.8 / AB 1 A / AB 1.8 A | 2    | CONTRADUR GAKO              | 17           |
| AKTIVAT                           | 7    | CONTRADUR UDK-N             | 17           |
| AKTIVATOR                         | 3    | CONTRADUR WSC 200 / WSC 201 | 16           |
| ANTIDUR                           | 16   | CONTRADUR WSN 100           | 16           |
| AS 140                            | 9    | CONTRADUR Spezial PN        | 16           |
| AS 220                            | 9    | CR 2                        | 3            |
| AS 235                            | 9    | CR 4                        | 3            |
| AS 300                            | 9    | CR 8                        | 3            |
| ASD                               | 14   | CR 9                        | 3            |
| ASD REG                           | 14   | DRS 3                       | 7; 8; 10; 13 |
| ATOMIN                            | 17   | DURBORID® G                 | 12           |
| AUFSTREUHÄRTEPULVER               | 5    | DURBORID® PASTE             | 12           |
| AVS 220                           | 11   | DUOPERL®                    | 8            |
| AVS 250                           | 11   | DUROSORB                    | 10           |
| BEIZENTFETTER                     | 13   | FERROBLACK® HL              | 13           |
| C 1                               | 7    | FERROBLACK® MH              | 13           |
| C 3                               | 5; 7 | FERROBLACK® NIF             | 13           |
| CARBONEUTRAL®                     | 8    | FERROBLACK® SPEZIAL         | 13           |
| CECONTROL®                        | 4    | FERROSOL HL                 | 13           |
| CECONTROL® 50 H                   | 4    | G 19 / G 22                 | 13           |
| CECONTROL® 80 B                   | 4    | GS 230                      | 6            |
| CECONTROL® 110 B                  | 4    | GS 430                      | 6; 8; 9      |
| CECONSTANT® 80                    | 5    | GS 520                      | 6            |
| CECONSTANT® 80 A                  | 5    | GS 540                      | 5; 6; 8      |
| CECONSTANT® 110                   | 5    | GS 560                      | 6            |
| CECONSTANT® 110 A                 | 5    | GS 660                      | 6            |

## Product list

|                  |      |                     |    |
|------------------|------|---------------------|----|
| GS 670           | 6    | SCHUPPENGRAPHIT     | 7  |
| GS 750           | 6; 8 | SEMPERNEUTRAL® 950  | 8  |
| GS 960           | 6; 8 | SEMPERNEUTRAL® 1100 | 8  |
| HT 400           | 14   | STREICHBRÜNIERBEIZE | 13 |
| HYDRODUR®        | 10   | TF 1                | 2  |
| HYDRODUR® GF     | 10   | VERDÜNNER I         | 17 |
| HYDRODUR® 20     | 10   | VERDÜNNER II        | 17 |
| KG 6.2 / KG 30.2 | 5    | WAGA                | 16 |
| KOLENE® ALKO® N  | 15   | WAGA Plus           | 16 |
| KOLENE® No. 4    | 15   |                     |    |
| KOLENE® No. 5    | 15   |                     |    |
| KOLENE® No. 6    | 15   |                     |    |
| KOLENE® No. 10   | 15   |                     |    |
| KOLENE® DGS®     | 15   |                     |    |
| KOLENE® RS 700   | 15   |                     |    |
| NSK              | 3    |                     |    |
| OX R             | 3    |                     |    |
| OX 1.2           | 3    |                     |    |
| PULNIERPULVER    | 3    |                     |    |
| R 2              | 7; 8 |                     |    |
| R 3              | 7    |                     |    |
| REG 1            | 2    |                     |    |
| REKORD           | 17   |                     |    |
| RUBBERCURE       | 14   |                     |    |
| RUBBERCURE LAS   | 14   |                     |    |
| S 100            | 17   |                     |    |

Details we provide on our products and appliances as well as our plants and process methods are based on comprehensive research work and operational experience. We provide such data either verbally or in writing to the best of our knowledge and belief on the understanding that they do not present any warranty concerning the existence of specific characteristics in our products, but reserve the right to make technical modifications in the course of product development.

This does not, however, relieve the user of his responsibility to check our data and recommendations for his own application before using them. This also applies - particularly for shipment abroad - with regard to the maintenance of protection rights of third parties and to applications and process methods not expressly declared by ourselves in writing. In the case of loss our liability is limited to replace goods and services on the same scale as is stipulated for quality defects in our General Conditions of Sale and Delivery.



## Notes



[www.hef-durferrit.com](http://www.hef-durferrit.com)

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