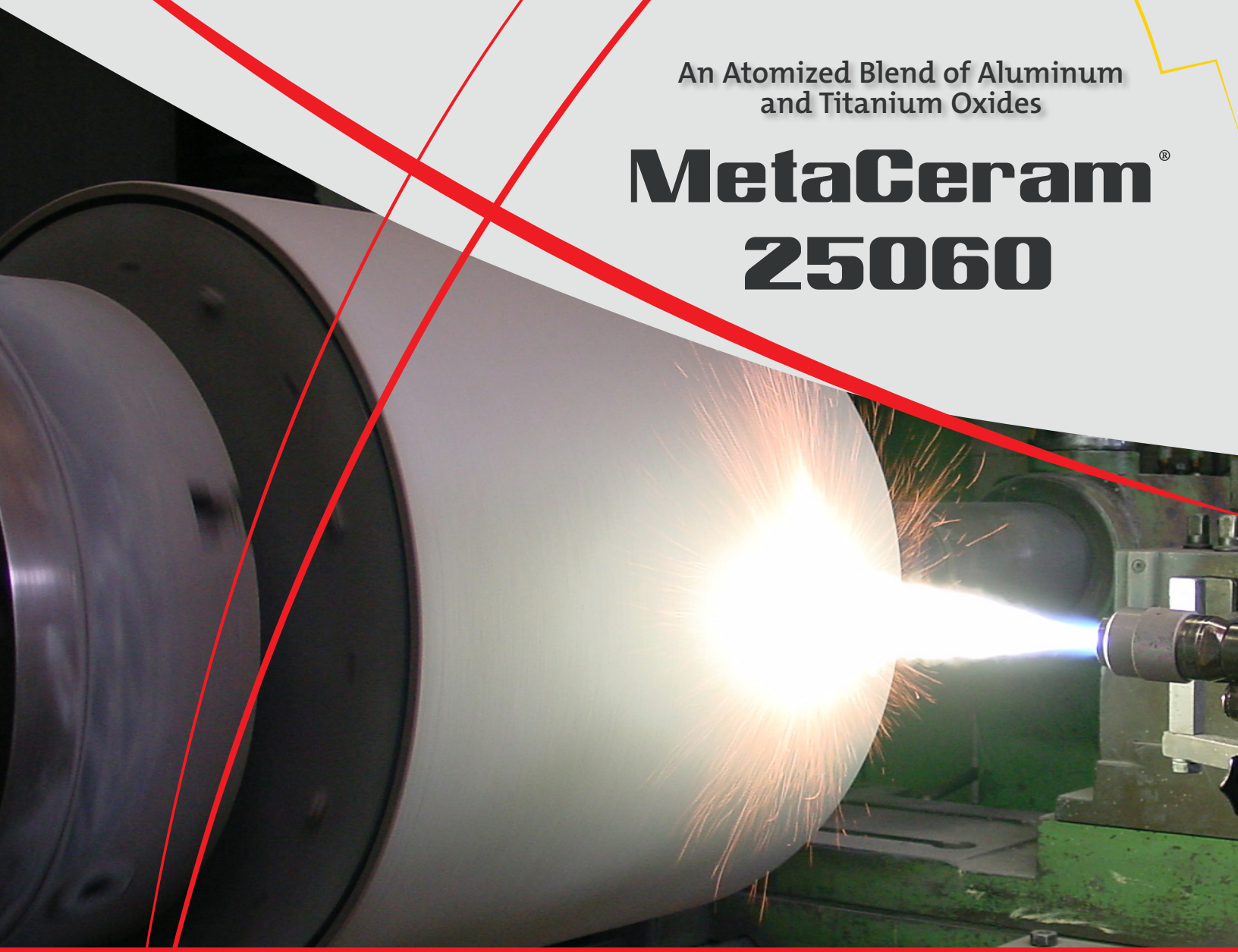
Castolin Eutectic®
Eutectic Castolin

An Atomized Blend of Aluminum and Titanium Oxides

MetaCeram® 25060



- Two-step “Cold Process” powder
- Excellent resistance to abrasion, cavitation and corrosion
- Offers a low coefficient of friction with most mating surfaces
- Precise particle sizing ensures coating consistancy

MetaCeram® 25060

Eutectic 25060 is a blend of aluminum oxide (Al_2O_3) and titanium dioxide (TiO_2) powders and is designed for use with high energy combustion thermal spray equipment like the TeroDyn® Syetems 2000, 3000, CDS 8000 or conventional plasma spray processes. The coatings produced exhibit excellent resistance to abrasion, cavitation, corrosion and offer a low coefficient of friction with most mating surfaces.

Metaceram 25040 will require a bond coating in n early all applications. Use Proxon 50000 or 21031.

TECHNICAL DATA

Typical Coating Properties	
Macrohardness:	Rockwell 15N Scale, 85
Density:	3.7 g/cc
Max. Service Temperature:	1000°F (538°C)
Micro-hardness:	DPH_{300g} 800
Typical Powder Properties	
Flow Rate:	12 seconds
Bulk Density:	1.8 g/cc
Powder Coverage:	0.021 lb/ ft^2 @ 0.001"
Melting Point:	3340°F (1806°C)

PROCEDURE FOR USE

Finishing Procedure: Coatings of MetaCeram 25060 should be rough ground with 120 grit silicon carbide or 150 grit diamond wheels. Finish grind using a 400 grit diamond wheel.

Recommended Parameters

TD 2000*

Nozzle:	RL 210 or RL 210-W
RotoJet:	RPA 3@40psi air
Module Adaptor:	Aqua
Oxygen:	50 psi / 35 flow (FM-1 flowmeter)
Acetylene:	12 psi / 75 flow (FM-1 flowmeter)
T-Valve Setting:	6 clicks
Coating Rate:	3 lb/hr
Deposit Efficiency:	65%

TD 3000*

Nozzle:	RL 210 or RL 210 W
Terometer:	50
Oxygen:	50 psi / 38 flow
Acetylene:	12 psi / 62 flow
Carrier Gas:	Ni or Ar @ 55 psi
Coating Rate:	2.5 lb/hr
Deposit Efficiency:	85%
Spray Distance:	3 to 4 inches

CDS 8000*

Nozzle:	SSm 30
Powder Module:	1 - 2
Compressed Air:	40 - 45 psi
Rotational Speed:	200 sfpm
Advance:	0.125 in/rev
Spray Distance:	3 - 3.5 inches

**Pre-heat of 300°F (150°C) minimum must be maintained at all times until final build-up is reached. A maximum temperature of 500°F (260°C) should not be exceeded during the build-up.*

TYPICAL APPLICATIONS

- Thread Guides and Spindles
- Computer and Recording System Heads
- Sealing Rings for Bearings
- Shaft Seal Areas
- Sliding Surfaces
- Pump Shafts

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