

WILCARBO

pack hardening compound

WILCARBO is a box carburizing compound that produces a rapid, dense, and high tensile strength case. This easy-to-use dark powder contains no cyanide and is of low acute toxicity. WILCARBO is also effective on stainless steel.

How To Use WILCARBO

- ❑ Place parts to be hardened in packing box where the floor of the box is covered in one inch of compound. Tamp compound around pieces with one inch of compound available to all surfaces with two or three inches of compound above pieces to allow for setting. Box should be full.
- ❑ Seal lid of box tightly or use refractory cement, leaving small gas-pressure escape vent.
- ❑ Furnace temperature should be 1450°F - 1750°F (based on manufacturer recommendations for the steel to be treated). After box contents are at full heat, leave under diffusion one to eight hours, depending upon thickness of parts and thickness of case wanted (commonly .015" to .125").
- ❑ Remove parts from box and compound, shaking compound from each piece. Allow pieces to air-cool completely and/or quickly quench in agitated brine, water, or hot oil (based on manufacturer recommendations for the steel to be treated).

After each use, hot compound should be spread out to cool rapidly. Replenish used volume of compound with fresh. For best results, keep at least 50% fresh material for each use. Keep containers tightly closed. Avoid humidity and wetting.



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Other
ThermaRose
Products:

Cherry Red
instant hardening compound

- case harden steel parts in minutes
- no special heat-treating equipment required
- fast, effective results

PBC
scale preventing compound

- prevents scale & pitting from heating
- protects surface finish
- helps eliminate buffing, cleaning, and re-machining

 **ThermaRose**
heat treating compounds

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