

User Guide for Insta-Blak ® Z-360

1.) Clean

Clean the surface using E-Kleen 154 at **5-50%** by volume in water at **65°F to 140°F**. 5% by volume is recommended for surface activation; 50% by volume is recommended required for heavily-oxidized surfaces. Elevated temperature will reduce processing time. Required concentration, immersion time, and temperature will depend on condition of the metal surface.

2.) Rinse

Rinse using a bottom-fed, overflowing cold water rinse.

3.) Deoxidize

Deoxidation/activation can be achieved by using either a **10%** by volume room-temperature solution of E-Kleen 154, or a **10%** by volume Acetic Acid, or a **10%** by volume Sulfuric Acid.

Prior to charging a production tank, some experimentation should be performed with sample parts to determine if activation is required, and which method produces the most uniform and adherent black finish.

4.) Rinse

Rinse using a bottom-fed, overflowing cold water rinse.

5.) Blacken

Blacken the parts by immersing them at **10%** by volume solution of Insta-Blak Z-360 until a uniform black finish develops (**2-5 minutes**.)

6.) Rinse

Rinse using a bottom-fed, overflowing cold water rinse.

7.) Seal

Immerse the parts in one of the following E-Tec solutions:

- For a dry finish: either E-Tec 504, or E-Tec 510 diluted at **5%** by volume, in water
- For a somewhat oily finish: E-Tec 510 diluted at **10-20%** in water
- For an oily finish: E-Tec 501
- For a waxy finish: E-Tec 522
- For a hard, clear, acrylic finish: E-Tec 520
- For architectural finishes, use E-Tec 520, E-Tec 521, or RENWAX. Please see relevant Technical Data Sheets for more information on how to use these products.

Please note that the ultimate depth of black will not develop until a sealant is completely absorbed into the Insta-Blak Z-360 surface (this may take several hours.)

Be sure to read and understand the Technical Data Sheets and Safety Data Sheets for each of these products before using them. Please see the Insta-Blak Z-360 Technical Data Sheet for more detailed processing instructions.