

## Metal Blackening Solutions Room Temperature

### Insta-Blak 333 Iron & Steel

A room temperature blackening solution for cold and hot rolled carbon steels, alloy steels, tool steels as well as cast iron, forged steels and powdered metal. The mildly acidic liquid concentrate is diluted with 9 parts of water for a 10% by volume working solution. Immersion times of 2 to 5 minutes. It will not blacken stainless steels.

### Insta-Blak 333 GEL

A room temperature blackening solution for cold and hot rolled carbon steels, alloy steels, tool steels as well as cast iron, forged steels and powdered metal. It is an instant-acting black chemical conversion finish for all ferrous metals except stainless steel. It is recommended for architectural steel surfaces (such as steel steps and steel framing), blackening re-machined black oxide surfaces, quick touch-up of scratched or damaged black oxide finishes. It is also used for swab-on finishing of prototype parts. It produces no dimensional or structural change in the metal. The finish is resistant to solvents, oils, cutting fluids, etc. Apply at full strength.

### Insta-Blak 333 M/E Iron & Steel

This two component room temperature system was developed to enable the metal finisher to fine-tune his blackening process to fulfill his unique requirements. It is also recommended for very high volume blackening. The **Insta-Blak 333M** make-up component is used at 10% by volume in water. The **Insta-Blak 333E** enhancer governs the speed of the blackening reaction and depth of blackness. It is used at 1 to 6 fluid ounces per gallon of **333M** concentrate.

### Insta-Blak 335 Iron, Steel, Powdered Metals

A room temperature blackening solution for cold and hot rolled carbon steels, alloy steels, tool steels, cast iron, forged steels and powdered metal. It produces a black finish equal in depth of blackness and in corrosion resistance to that of conventional hot black oxide processes. Works well for interior architectural steel finishes. The mildly acidic liquid concentrate is diluted with 9 parts of water for a 10% by volume working solution. Immersion times of 2 to 5 minutes. It will not blacken stainless steels.

**Insta-Blak S-334  
Iron & Steel**

This swab-on finish is recommended for quick touch-up of scratched or damaged black oxide surfaces. It is also used for swab-on finishing of prototype parts. The mildly acidic liquid concentrate is used at full strength.

**Insta-Blak Z-360  
Zinc & Cadmium**

Room temperature blackening solution for die cast zinc and plated zinc surfaces. The very mild acidic liquid concentrate is diluted with 9 parts water for a 10% by volume working solution. Immersion times of 2 to 5 minutes. Equally effective on cadmium surfaces.

**Insta-Blak SS-370  
Stainless Steel**

Acidic liquid concentrate is used full strength or diluted with up to 3 parts water for blackening stainless steels at room temperature.

**Insta-Blak SS-370  
GEL Stainless Steel**

Acidic liquid concentrate is used full strength for blackening stainless steels at room temperature . It is an instant-acting black chemical conversion finish for stainless steel. It is recommended for architectural stainless steel surfaces (such as railings and stainless steel panels), blackening re-machined black oxide surfaces, and quick touch-up of scratched or damaged black oxide finishes. It is also used for swab-on finishing of prototype parts. It produces no dimensional or structural change in the metal. The finish is resistant to solvents, oils, cutting fluids, etc.

**Insta-Blak A-380  
Aluminum**

Room temperature immersion finish for aluminum surfaces. Alkaline liquid concentrate used at 25% to 40% by volume with water. Immersion times of 30 seconds to 2 minutes.

**Insta-Blak A-384  
Aluminum**

The acidic liquid concentrate is used full strength and is applied by swab-on techniques for blackening engravings, etching, prototype parts or for the quick touch-up of scratched or re-machined black anodized surfaces.

**Insta-Blak A-385  
Aluminum**

Immersion, swab-on or touch-up room temperature finish for aluminum surfaces. Mild acidic liquid concentrate used full strength for swab-on finishing and touch-up finishing or diluted with 4 parts water for immersion finishing.

**Equipment**

Acid resistant tanks, tumbling barrels, baskets, hooks and racks must be used with the **Insta-Blak** acidic solutions. Polypropylene, polyethylene or PVC dipping baskets, polypropylene rotating barrels, plastic lined or

rubber lined steel tanks and plastic coated hooks and racks are suitable.  
The alkaline **A-380** solution requires the same materials.

Note: **Insta-Blak<sup>®</sup>** is a registered trademark of **EPI, Electrochemical Products Inc.**

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