

User Guide for Insta-Blak® A-384

1.) Clean

- ▶ **Step 1a.** *If the part is oily, or excessively dirty,* use E-Kleen 163 and let the cleaner work for **1-3 minutes**. Do not use petroleum solvents as a replacement. Rinse off cleaning residue thoroughly.
- ▶ **Step 1b.** Use a **10-50%** by volume solution of E-Kleen 154 (even if you have completed step 1a.) Use a swab or sponge saturated with the E-Kleen 154, or immerse the part for **2-5 minutes**.

2.) Rinse

Using a damp sponge, damp cloth, or running water, thoroughly remove residual cleaning solution. If water breaks occur during rinsing, return to step one—this indicates that the substrate is not clean.

3.) Blacken

- ▶ **Step 3a.** Apply the full-strength Insta-Blak A-384 solution with a swab, brush, rag, sponge, or plastic spray bottle. Cover the surface as quickly as possible, with a light rubbing action. Allow the solution to react for **30 seconds to 2 minutes**. **NOTE:** Do not rub the surface for the last 15 seconds!
- ▶ **Step 3b.** If a slower reacting solution is desired for improved adhesion or other reasons, the A-384 concentrate may be diluted to **1 part** solution to **1-3 parts** of water. Remove Residual Solution by running the part under water or using a dampened sponge. Hot water will help to accelerate the drying process.

4.) Seal

NOTE: The oxidized/blackened area may have to be buffed with a cloth or brush to remove any non-adhering smut or dusty chemicals from the surface.

NOTE: The black finish will appear as a dark gray in color until sealed, and it will have very little corrosion resistance without a sealant.

- ▶ **Option 4a.** *For a hard finish:* use E-Tec 520
- ▶ **Option 4b.** *For a semi-hard finish:* use E-Tec 521
- ▶ **Option 4c.** *If sealed with oil:* use a soft towel to remove excess oil.
- ▶ **Option 4d.** *For architectural finishes:* use either E-Tec 520, E-Tec 521, or RENWAX.

Please see relevant Technical Data Sheets for more information on how to use these products.

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 A-384 Technical Data Sheet for more detailed processing instructions.