

## User Guide for B/OX™ 311

### 1.) Clean & Rinse

*For plated surfaces:* Rinse thoroughly with cold water, followed by a short rinse in **5%** Sulfuric Acid solution or E-Pik 215 acid salts at **¼ oz to 2 oz/gal** water to neutralize residual alkaline plating solutions. Then, rinse again with water.

*For Wrought alloys and sheet stock:* Clean mechanically, or chemically with E-Kleen 153 followed by E-Pik 215. A cold-water rinse is used following the cleaning and deoxidizing steps to remove residual solutions or blasting dust.

### 2.) Blacken

Immerse while still wet from preceding rinse into a water-diluted B/OX™ 311 solution for the length of time necessary to produce the desired color.

- Rotating perforated plastic barrels are recommended for processing small parts.
- When using dip baskets, the parts should be agitated when immersed in the solution to break air bubbles and to assure solution contact with all surfaces.

### 3.) Rinse

Rinse in bottom-fed overflowing cold water rinse. Stagnant hot water rinse can be used to speed drying, but it should be preceded by a short cold-water rinse to minimize staining. Hot rinses should be maintained at **160-180°F** and dumped periodically or overflowed very slowly. A rinse aid may be helpful in eliminating water spots.

### 4.) Dry

Force drying in heated spin dryers, ovens, or cob meal will minimize streaking and staining.

- Large architectural panels should be wiped dry or blown dry.
- Small parts do not require drying if they will be barrel or vibratory burnished immediately after rinsing.

### 5.) Seal

You can achieve a “highlighted” or relieved antique finish by buffing, scratch brushing, barrel or vibratory burnishing.

Otherwise, seal by immersing while still wet from previous rinse in one of the following:

- *For a hard, dry US 10L finish:* E-Tec 520
- *For an oily US 10B finish:* E-Tec 501
- *For hand-applied wax topcoat:* RENWAX.

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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 B/OX™ 311 Technical Data Sheet for more detailed processing instructions.