

## **B/Ox™ 325**

### **Room Temperature Blackening Solution for Pewter, Tin, or Lead Alloys**

#### **INSTRUCTIONS**

**B/Ox 325** liquid concentrate is diluted with water and used at room temperature as an immersion “oxidizing” solution. The depth of black developed and the reaction rate is controlled by varying the concentration and the length of immersion. Prior to charging a production tank, some experimentation should be done with properly prepared sample parts to determine the conditions required to produce the desired depth of black. As a starting point, dilute one (1) part **B/Ox 325** concentrate with three (3) parts water and immerse parts for 1 to 2 minutes. Varying the amount of water will shorten or lengthen the immersion time.

#### **EQUIPMENT REQUIRED**

Acid resistant tanks, tumbling barrels, baskets and racks must be used with the **B/Ox** and **E-Pik** solutions. Plastic, plastic lined, rubber lined, glass or stoneware is suitable. Mild steel may be used for the cleaning, rinsing and sealant tanks.

#### **BLACKENING PROCEDURES**

1. Thoroughly clean and degrease pieces to be blackened with a 5-12% by volume solution of **EPI's E-Kleen 148-E** at 100°-150°F. Time required for cleaning will depend on degree of soil.
2. Rinse with cold water.
3. Remove surface oxide if present by immersing in 16-32oz per gallon solution of **EPI's E-Pik 215** for 2-10 minutes.
4. Rinse with cold water.
5. Immerse pieces in full strength **B/Ox 325** solution for the length of time necessary to achieve the depth or black.
6. Rinse with hot or cold water and force dry.
7. A variety of attractive antiqued or “highlighted” finishes are produced by buffing, scratch brushing, barrel or vibratory burnishing.
8. A protective topcoat of **EPI's E-Tec 521** wax or **E-Tec 520** clear lacquer should be applied to enhance the color and give added corrosion resistance and abrasion resistance.

## **SOLUTION MAINTENANCE**

The solution is gradually depleted through use but may be replenished indefinitely with periodic additions of **B/Ox 325** concentrate. The strength of solution can be maintained by the time of immersion. When the time required to produce the desired depth of black increases, add sufficient concentrate to reduce the time to your established standard. The frequency of additions will depend upon the volume of work processed.

## **CAUTION**

The **B/Ox 325** solution is strongly acidic. Avoid contact with eyes, skin and clothing. Wear eye protection (glasses, goggles, or face shield), protective gloves and aprons when mixing solutions and while working with the solutions. In case of contact flush skin and eyes with generous amounts of cold water and obtain medical attention.

Avoid contact of **B/Ox 325** concentrate and solutions with alkaline materials. Do not mix **B/Ox 325** with any other chemicals or solutions.

Do not use **B/Ox 325** without first reading and understanding the **SAFETY DATA SHEET** furnished by **EPI**.

## **PACKAGING**

One (1) 5- and 55-gallon non-returnable containers.

## **IMPORTANT NOTICE! For Industrial Use Only**

The following is made in lieu of all warranties, expressed or implied, including the implied warranties of merchantability and fitness for purpose: seller's and manufacturer's only obligation shall be to replace such quantity of the product as proved to be defective. Before using, user shall determine the suitability of the product for its intended use, and user assumes all risk and liability whatsoever in connection therewith. **Neither seller nor manufacturer shall be liable either in tort or in contract for any loss or damage, direct, incidental or consequential, arising out of the use or the inability to use the product.**

**10/30/2024**