

User Guide for Insta-Blak SS-370

1. Clean

In a steel container, thoroughly clean the parts in a **10% by volume** solution of **E-Kleen SR 148-E** and **90% by volume** water, at **140-150° F**. The cleaning time will depend upon the type and degree of soil present on the metal surfaces and the concentration and temperature of the **E-Kleen SR 148-E** solution.

2. Rinse

Using a plastic container, rinse the parts for **1-2 minutes** in clear running room temperature water.

3. Activate

Using a plastic container, activate the surface of the parts in one of the following solutions:

- ▶ For 300 series alloys, immerse parts in a **50% by volume** Muriatic Acid solution and **50% by volume** water at room temperature for **2 to 5 minutes**.
- ▶ For 400 series alloys, immerse the parts in a solution of 2 lb of **E-Pik 211** acid salts per gallon of water for **5 minutes** at a temperature between **65° F** to **125° F**.
- ▶ **NOTE:** Very passive surfaces may require further activation to initiate the blackening reaction by having plain steel in contact with the stainless steel parts while immersed in the **Insta-Blak SS-370** solution. This can be accomplished by using plain steel hooks or racks to suspend the stainless steel parts in the solution or by including some plain steel wire in the plastic dip baskets or rotating barrels used to contain the stainless steel parts.

4. Rinse

Using a plastic container, rinse the parts for **1-2 minutes** in clear running room temperature water.

5. Blacken

In a plastic container, blacken the parts at room temperature for **2-5 minutes** using one of the following solutions:

- ▶ For 300 series alloys, try a **50% by volume** of **Insta-Blak SS-370** and **50% by volume** water solution.
- ▶ For 400 series alloys, try a **33% by volume** of **Insta-Blak SS-370** and **67% by volume** water solution or a **25% by volume** of **Insta-Blak SS-370** and **75% by volume** water solution.
- ▶ Difficult to blacken surfaces may require the use of **Insta-Blak SS-370** at full strength (**100% by volume**).

6. Rinse

Using a plastic container, rinse the parts for **1-2 minutes** in clear running room temperature water.

7. Seal & Finish

In a steel container, seal the finish and enhance the depth of blackness.

Option 7a. *For an oily finish:* use **E-Tec 501**

Option 7b. *For a slightly oily to a semi-dry finish:* use **E-Tec 503**

Option 7c. *For a soft, non-tacky, dry-to-the-touch finish:* **E-Tec 504** or **E-Tec 505+**

- ▶ Place the blackened parts into the **E-Tec** solution of your choice, and agitate **6-12 times** up and down (about **1-2 minutes**).
- ▶ Air dry for **15-30 minutes**.

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 SS-370 Technical Data Sheet for more detailed processing instructions.