

User Guide for Insta-Blak ® A-385

1.) Clean

For Extrusions and Wrought Alloys:

- ▶ If you're looking to achieve a **heavy etch** while cleaning, use E-Kleen 102 at **150-170°F** for **5-10** minutes to thoroughly clean and degrease
- ▶ If you're looking to achieve a **very mild etch** while cleaning, use E-Kleen 163 at **150-170°F** for **5-10** minutes

For Die- and Sand-Cast Aluminum, also Machine Parts, Grommets and Screws:

- ▶ Immerse in a **10-20%** solution of E-Kleen 154 at temperature of **65-100°F** for **2-5** minutes

2.) Rinse

Rinse for a minimum of **30 seconds** in a bottom-fed overflowing cold water rinse tank to remove residual blasting dust or cleaning solutions.

3.) Blacken

Step 3a. Prior to charging a production tank, some experimentation should be performed with properly prepared sample parts. Use various dilutions of A-385 concentrate at **1-5 parts** water, and different immersion times to determine the conditions and parameters required to produce the desired depth of black.

Step 3b. As a starting point, dilute **1 part** Insta-Blak A-385 with **1 part** water. Determine by test the shortest immersion time necessary to produce the desired finish—usually **30-90** seconds. Vary the amount of water to test for shortest immersion time.

4.) Rinse

Rinse for a minimum of **30 seconds** in a bottom-fed overflowing cold water rinse tank to remove residual blasting dust or cleaning solutions.

5.) Seal

Option 4a. *For a somewhat oily finish:* while parts are still wet from rinse, use E-Tec 502

Option 4b. *For a soft, dry finish:* while parts are still wet from rinse, use E-Tec 504

Option 4c. *For a hard, dry finish:* use E-Tec 520

Option 4d. *For architectural finishes:* use 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-385 Technical Data Sheet for more detailed processing instructions.