

User Guide for B/OX™ 314

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 **20% by volume** B/OX™ 314 solution for the length of time necessary to produce the desired color. Using **5-10% by volume** solutions will produce very light brown tones.

- 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.

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™ 314 Technical Data Sheet for more detailed processing instructions.