

## User Guide for B/OX™ 315

### 1.) Clean

*For plated surfaces:* First, rinse thoroughly with cold water. Then, rinse again in a 5% sulfuric acid solution or E-Pik 215 at ¼oz-2oz per gallon water to neutralize residual alkaline plating solutions.

*For Wrought alloys & sheet stock:* Mechanically clean and deoxidize by glass bead or sand blasting. Or, chemically clean and deoxidize with E-Kleen 153 followed by **8oz per gallon** of E-Kleen 215.

### 2.) Rinse

Rinse with cold water—**do not dry after rinsing.**

### 3.) Blacken

While still wet from rinse, immerse parts in **10-20% by volume** B/Ox 315 solution until they have reached the desired color.

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

### 4.) Rinse

Rinse thoroughly in bottom-fed overflowing cold water rinse.

After the cold water rinse, a second stagnant hot water rinse maintained at **160°F-180°F** can be used to speed up drying. Be sure to dump periodically, or overflow very slowly.

### 5.) Dry

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

### 6.) 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™ 315 Technical Data Sheet for more detailed processing instructions.