

## User Guide for **Kool-Blak 225**

### **1.) Clean**

Degrease area to be finished with a liquid detergent or E-Kleen SR 102 (floats oil) or E-Kleen SR 102-E (emulsifies oil) cleaner at **150-180°F** for **5-10 minutes**.

‣ NOTE: Silica is a contaminant to Kool-Blak. **Do not use silicate cleaners.**

### **2.) Rinse**

Rinse in bottom-fed, overflowing cold water rinse.

### **3.) Deoxidize**

Use **2lbs** of E-Pik 215 solution per gallon of water for **5-10 minutes**, or hydrochloric acid at **50% by volume**.

‣ NOTE: Do not use inhibited acid—the parts will turn brown or not blacken.

### **4.) Rinse**

Rinse in bottom-fed, overflowing cold water rinse.

### **5.) Blacken**

Immerse in **full strength** Kool-Blak 225 solution at **220-255°F** for **15-45 minutes** until a uniform black develops. Time required will depend on mass of parts, type of steel alloy, and condition of surface.

### **6.) Rinse**

Rinse in bottom-fed, overflowing cold water rinse.

### **7.) Seal**

Seal by immersing in one of the following:

- *For a water-displacing oil with an oily finish: E-Tec 501*
- *For a water-soluble oil with a soft, dry film: E-Tec 510*
- *For a hard, dry film: E-Tec 525*

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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 Kool-Blak 225 Technical Data Sheet for more detailed processing instructions.