

The Blackening Process

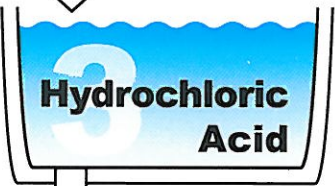
Pieces to be blackened may be processed in mild steel baskets, tumbling barrels, hung on racks or hooks, depending upon the shape, weight and production requirements.



Thoroughly clean and degrease pieces with E-Kleen 101, 102, 102-E or 111 hot (180°F) soak cleaners. Typical cleaning time is only 5-10 minutes.



Rinse pieces in bottom-fed, overflowing cold water rinse.



50% by volume or E-Pik 215, 2#/gallon for 5-10 minutes.



Rinse in bottom-fed, overflowing cold water rinse.



Immerse in KOOL-BLAK 225 solution (220-240°F) until a uniform, deep black color is developed. Immersion time: 15-45 minutes, depending upon the mass of parts, type of steel alloy and condition of surface.



Rinse in bottom-fed, overflowing cold water rinse



Immerse for 1 minute in one of the following EPI products for your desired finish:

- | | |
|-----------------|------------------|
| Oily Finish: | E-Tec 501 |
| Soft Dry Film: | E-Tec 510 |
| Hard, Dry Film: | E-LAQ 525 |

