

## Insta-Blak 333 Trouble Shooting

Problem	Reason	Solution
<p>Spotty and non-uniform blackening</p> <p>Spotty and non-uniform blackening</p>	<p>Poor cleaning</p> <p>Poor rinsing</p>	<p>Increase temperature of <b>E-Kleen 148-E</b> to 150°F.</p> <p>Increase dwell time. Make sure solution concentration is 10-12% by volume.</p> <p>Rinses must be clean.</p> <p>Residue from cleaner must be removed. Check to see if there is any waterbreak on parts.</p>
<p>Bluish cast on parts or grayish finish</p>	<p>Insufficient activation</p>	<p>Carbon steels, 4130 and heat treated materials may require more time in <b>EPI E-Prep 258</b>. Longer time in blackening may be helpful.</p>
<p>Excessive rub-off</p>	<p>Improper blackening</p>	<p>Blackening solution too strong or excessive time in blackening solution.</p> <p>Check again if parts are clean prior to blackening.</p>
<p>Parts rusting after blackening.</p>	<p>Poor rinsing.</p> <p>Insufficient time in sealant.</p> <p>Excessive water in sealant.</p>	<p>Rinse must be clean to remove residues of blackening solution.</p> <p>Increase dwell time in sealant making sure water is displaced off parts. Do not let parts dry after rinse prior to sealant. Drain water from bottom of sealant tank.</p>