

User Guide for B/OX™ 311 Gel

1.) Clean

Degrease the surface using alcohol, chlorinated solvents, vapor degreasing, a liquid detergent, or E-Kleen 163 or E-Kleen 154. Let the cleaner work for **1-3 minutes**.

NOTE: Cleaning step may be skipped if the parts have been sandblasted or mechanically prepared, as long as the parts are free from any oils, lacquers, finger prints, or other soils. In this case, proceed to step 3.

NOTE: Do not use petroleum solvents.

2.) Rinse

Rinse with running water, a damp sponge or damp cloth. If water breaks occur, return to step 1. Water breaks indicate the substrate is not clean.

3.) Blacken

Apply full strength B/OX™ 311 Gel generously with a cotton swab, sponge, or brush. Ensure a smooth and even coverage using a light rubbing action for **1-3 minutes**, making several passes over the same area. You can add fresh gel if the reaction has stopped.

NOTE: The depth of blackness is controlled by the length of time the solution is left in contact with the metal surface.

4.) Rinse

Rinse with running water, a damp cloth, or damp sponge. Wipe dry or dry with heat gun.

5.) Rub

Rub area with a soft cloth or brush to remove non-adherent layer of spent chemicals from the surface.

6.) Seal

Seal using one of the following:

- *For a slightly oily finish:* E-Tec 502
- *For a soft, non-tacky dry finish:* E-Tec 505
- *For a hard, clear finish:* E-Tec 520
- *For architectural finishes:* E-Tec 520, E-Tec 521, or 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™ 311 Gel Technical Data Sheet for more detailed processing instructions.