

User Guide for B/OX™ 316

1.) Clean

Clean with E-Kleen 148-E or E-Kleen 110 at **65°-140°F** for **5-10 minutes**. Or, clean & deoxidize in one step with E-Kleen 154 at **10% by volume** in water.

For Large Architectural Panels: clean by belt sanding, glass bead, sand-blasting, or abrasive media.

2.) Rinse

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

3.) Blacken in B/Ox 311

Immerse in B/Ox 311 **solution for 30 seconds to 3 minutes** to produce a brown/dark brown finish.

See Technical Data Sheet & User Guide for B/Ox 311. A heavy coating of B/Ox 311 is desirable as it will better absorb and retain the solution.

4.) Rinse

Rinse as in step # 2. No need to dry.

5.) Immerse in B/Ox 316

While still wet from rinse, immerse in B/Ox 316 **solution for 1-3 minutes**. If dip baskets are used, the parts should be agitated when first introduced into the solution to break air bubbles and assure solution contact on the surface.

NOTE: DO NOT RINSE AFTER REMOVING FROM B/OX SOLUTION!

6.) Dry

Allow the parts to air dry. Forced warm-air drying will affect the color development: the higher the drying temperature, the greener the color produced.

7.) (Optional) Rinse

If residual chemicals are still present, you may now rinse in a bottom-fed, overflowing cold water rinse. Then dry thoroughly.

8.) Seal

Seal the finish with E-Tec 520 clear acrylic lacquer, or E-Tec 521 wax.

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 Technical Data Sheet for more detailed processing instructions.