

## User Guide for Insta-Blak 333

### **1. Clean**

In a steel container, thoroughly clean the parts in a **10% by volume** solution of E-Kleen SR 148-E and **90% by volume** of water. The cleaning time will depend upon the type and degree of soil present on the metal surfaces and the concentration and temperature of the E-Kleen SR-148-E solution.

### **2. Rinse**

Using a plastic container, rinse the parts for **1-2 minutes** in clear running room temperature water.

### **3. (Optional) Activate**

Using a plastic container, activate the surface of the parts in a **20% by volume** E-Prep 258 solution and **80% by volume** water for **2 minutes** for optimal activation at room temperature.

### **4. (If Activated) Rinse**

Rinse the parts as in #2 above.

### **5. Blacken**

In a plastic container, blacken the parts in a **10% by volume** solution of Insta-Blak 333 and **90% by volume** of water at room temperature for **2-5 minutes**.

### **6. Rinse**

Rinse the parts as in #2 above.

### **7. Seal & Finish**

In a steel container, seal the finish and enhance the depth of blackness.

**Option 7a.** *For an oily finish:* use E-Tec 501

**Option 7b.** *For a slightly oily to a semi-dry finish:* use E-Tec 503

**Option 7c.** *For a soft, non-tacky, dry-to-the-touch finish:* E-Tec 504 or E-Tec 505+

- Place the blackened parts into the E-Tec solution of your choice, and agitate **6-12 times** up and down (about **1-2 minutes**).
- Air dry for **15-30 minutes**.

Typically, 24 hours later, the part will be blacker as the oil absorbs into the blacken finish.

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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 Insta-Blak 333 Technical Data Sheet for more detailed processing instructions.