User Guide for Insta-Blak SS-370

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 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. **Activate**
   Using a plastic container, activate the surface of the parts in one of the following solutions:
   - For 300 series alloys, immerse parts in a 50% by volume Muriatic Acid solution and 50% by volume water at room temperature for 2 to 5 minutes.
   - For 400 series alloys, immerse the parts in a solution of 2 lb of E-Pik 211 acid salts per gallon of water for 5 minutes at a temperature between 65°F to 125°F.

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

5. **Blacken**
   In a plastic container, blacken the parts at room temperature for 2-5 minutes using one of the following solutions:
   - For 300 series alloys, try a 50% by volume of Insta-Blak SS-370 and 50% by volume water solution.
   - For 400 series alloys, try a 33% by volume of Insta-Blak SS-370 and 67% by volume water solution or a 25% by volume of Insta-Blak SS-370 and 75% by volume water solution.
   - Difficult to blacken surfaces may require the use of Insta-Blak SS-370 at full strength (100% by volume).

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

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.

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.

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