

User Guide for Insta-Blak ® A-380

1.) Clean

For Extrusions and Wrought Alloys:

- ▶ If you're looking to achieve a **heavy etch** while cleaning, use E-Kleen 102 at **150-170°F** for **5-10** minutes to thoroughly clean and degrease
- ▶ If you're looking to achieve a **very mild etch** while cleaning, use E-Kleen 163 at **150-170°F** for **5-10** minutes

For Die- and Sand-Cast Aluminum, also Machine Parts, Grommets and Screws:

- ▶ Immerse in a **10-20%** solution of E-Kleen 154 at temperature of **65-100°F** for **2-5** minutes

2.) Rinse

Rinse the part using a bottom-fed, overflowing cold rinse tank for **30 seconds** to **1 minute**

3.) Deoxidize (*Die-/Sand-Cast Aluminum, Machine Parts, Grommets & Screws can skip this step*)

For Extrusions and Wrought Alloys; Deoxidize the parts by immersing them in either

- ▶ E-Pik 210 at **65-80 °F** for **5 minutes**, or
- ▶ A **40%** by volume solution of Nitric Acid for **1-5 minutes**

4.) Rinse

Rinse the part using a bottom-fed, overflowing cold rinse tank for **30 seconds** to **1 minute**

(Optional: For Die- and Sand-Cast Aluminum, also Machine Parts, Grommets and Screws: You may choose to utilize E-Prep 280 NCZ for additional surface conditioning. See E-Prep 280 NCZ Technical Data Sheet for more detailed processing instructions)

5.) Blacken

Immerse the parts in a **25%** by volume room-temperature solution of Insta-Blak A-380 for the length of time necessary to produce a uniform black finish (**30 seconds** to **2 minutes** depending on the alloy.)

- ▶ Rotating perforated barrels are recommended for processing small parts.
- ▶ If dip-baskets are used, the parts should be agitated when first introduced into the solution to break air bubbles and to assure solution contact with all surfaces.

NOTE: Prolonged immersion times in the Insta-Blak A-380 solution will result in a rough, non-adherent finish and may also cause excessive etching of the part.

6.) Rinse

Rinse the part using a bottom-fed, overflowing cold rinse tank for **30 seconds** to **1 minute**.

7.) Seal Immerse the parts with one of the following:

- ▶ For a somewhat oily finish: while parts are still wet from rinse, use E-Tec 502

- For a soft, dry finish: while parts are still wet from rinse, use E-Tec 504
- For a hard, dry finish: E-Tec 520
- For architectural finishes: either E-Tec 520, E-Tec 521, or RENWAX. Please see relevant Technical Data Sheets for more information on how to use these products.

Please note that the temperature of the Insta-Blak A-380 solution must be kept *below 85°F*. A solution chiller may be required.

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 A-380 Technical Data Sheet for more detailed processing instructions.

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