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, at 140-150°F. 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.
   - **NOTE:** Very passive surfaces may require further activation to initiate the blackening reaction by having plain steel in contact with the stainless steel parts while immersed in the Insta-Blak SS-370 solution. This can be accomplished by using plain steel hooks or racks to suspend the stainless steel parts in the solution or by including some plain steel wire in the plastic dip baskets or rotating barrels used to contain the stainless steel parts.

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.

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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 SS-370 Technical Data Sheet for more detailed processing instructions.

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