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ANTIQUÉ BLACK® M80 Immersion Blackener

Operating Instructions

ANTIQUÉ BLACK® M80 oxidizer is a room temperature blackening solution for brass, bronze and copper. Supplied as a liquid concentrate, it produces tightly adherent finishes with no excess ruboff. For this reason, coverage per gallon is extremely high – 400-500 ft²/gallon for black finishes; 600-800 ft²/gallon for brown finishes. ANTIQUÉ BLACK M80 oxidizer offers finishers high quality antique finishes at a low operating cost in both rack and barrel process lines.

OPERATING CONDITIONS

Bath Makeup	10-20% by volume in tap water.
Operating Temperature/Time	Room Temp/1-3 minute immersion
Tank Construction	Plastic or acid proof material

PROCESSING PARTS

For brass plated surfaces, blackening works best when carried out immediately after plating:

1. BRASS PLATE, as normal (minimum thickness: .2 mil or 20 minutes plating time).
2. RINSE well in clean water.
3. NEUTRALIZE CYANIDE by immersing parts in "sour" rinse (2-5% sulfuric acid or 1 oz./gallon acid salts) to neutralize residual cyanide; 10 second immersion.
4. RINSE well in clean water.
5. BLACKEN by immersion in M80 bath for 1½-2 minutes for black tones or 30-90 seconds for brown tones.
6. RINSE well in clean water.
7. DRY, HIGHLIGHT if desired, & SEAL with lacquer or oil topcoat. Note: accelerated warm drying minimizes water staining.

For solid brass parts, the surface must be cleaned so they are free of oil and oxide, as follows:

1. CLEAN parts in alkaline soak cleaner, electrocleaner or ultrasonic cleaner; 70-150°F; 3-5 minutes.
2. RINSE well in clean water.
3. REMOVE TARNISH in mild acid solution -- 10% sulfuric acid or 4 oz./gallon acid salts.
4. RINSE well in clean water.
5. Continue with steps 5 through 8 above.

BATH MAINTENANCE

It is recommended that the bath be periodically tested with the BIRCHWOOD CASEY CCK-1 Test Kit, and maintained at 80% of its original strength or greater. A 50-100 micron particle filter works well to keep the production bath clean.

PACKAGING: 5 gallon and 55 gallon non-returnable drums. Store in closed container.

Before Using This Product – Please Read, Understand and Follow all the Precautions shown on the Product Label and on the Material Safety Data Sheet.

The Material Safety Data Sheet can be found on our website: www.birchwoodcasey.com.

Always Apply Appropriate Labels to any Container used to Store or Apply this Product.

NOTE: The information contained herein is provided in good faith and is believed to be correct as of the date hereof. However, Birchwood Laboratories, Inc. makes no representation as to the comprehensiveness or accuracy of the information. It is expected that individuals receiving the information will exercise their independent judgment in determining its appropriateness for a particular purpose. Accordingly, Birchwood Laboratories, Inc. will not be responsible for damages of any kind resulting from the use of or reliance upon such information.

ANTIQUÉ BLACK® M80 (Product Number 750251, 750258)

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