



Metal Finishing Systems

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PRESTO BLACK® PBR/PBA Blackening Process

Operating Instructions

PRODUCT DESCRIPTION

The PRESTO BLACK® PBR/PBA system is a room temperature blackening process for iron and non-stainless steels. It utilizes two concentrates to make up and control the blackening bath: the PBR REPLENISHER is used to initially mix up the bath and contains all the primary blackening components. It is also used on a regular basis to replenish the bath to replace the active blackening ingredients. The PBA ACCELERATOR is used in very small quantities only to initially activate the bath, and is then added only as needed.

OPERATING CONDITIONS

Initial Bath Make-Up	PRESTO BLACK PBR, mix 10% by volume in water. Add PBA at a rate of 100 mL per 10 gallons of bath.
Equipment Construction	Tank: Polypropylene, PVC, or other acid-proof. Racks, baskets: Polypro or PVC coated steel.
Ventilation	Not necessary. No fumes.
Filtration/Recirculation	Desirable on larger tanks. Use acid-proof pump and 100 micron polypropylene filter element.

BLACKENING PROCEDURES

For best results, the steel requires thorough cleaning, then the surface should be acid-prepped, then blackened and finally, sealed with an appropriate rust preventive compound, as follows:

1. CLEAN the parts to remove oils and shop soils, using PRESTO KLEEN® HP alkaline cleaner, mixed at 8 oz/gal; 150° F; 5-8 minute soak.
2. RINSE thoroughly in clean water; 30 seconds.
3. ACTIVATE SURFACE by immersing parts for 1-2 minutes in SAFE PREP® Surface Conditioner, mixed at 10% by volume; room temp.
4. RINSE thoroughly in clean water; 30 seconds.
5. BLACKEN parts by immersing in the PRESTO BLACK solution at room temperature for 1-3 minutes, or until parts are uniformly black.

6. RINSE thoroughly in clean water; 30 seconds.
7. SEAL the black finish in DRI TOUCH® AMBER IRP2 dry-to-touch finish, or other appropriate rust preventive compound.

BATH MAINTENANCE

The PRESTO BLACK bath will gradually get weaker as parts are processed. The bath can be tested by using a simple COLOR CHANGE KIT CCK1, available from BIRCHWOOD CASEY. This test will determine how much Replenisher to add to the bath. Or, use a Bath Sample Mailer to send a sample to BIRCHWOOD CASEY for free analysis.

The bath also generates an insoluble particulate sludge that should be removed by filtering. When the filter element has plugged up, replace it with a fresh filter.

PACKAGING & STORAGE

Available in 1, 5 gallon plastic containers; 55 gallon non-returnable drums. Store indoors in a 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.

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PRESTO BLACK® PBR/PBA (Product Numbers: PBR 580050, 580051, 580058)

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May 2007