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Metal Finishing Systems

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OXYPRIME® XP Primer/Prep
(Patented)
Operating Instructions

PRODUCT DESCRIPTION

OXYPRIME® XP Primer/Prep is used to apply a base coat, or primer coat, on ferrous metal surfaces in preparation for blackening by TRU TEMP® Low Temperature Black Oxide. This product is the Extra Strength version of OXYPRIME needed for blackening hardened tool steels or for removing rust and scale. OXYPRIME XP Primer/Prep operates at Room Temperatures in most installations, but can be heated as high as 140° F, if necessary, to increase its activity on non-reactive alloys, such as high speed steels, or parts with heavy surface rust or scale. OXYPRIME XP operates as a semi-permanent bath and can be controlled by a color-change test kit.

OPERATING CONDITIONS

Bath Make-Up Concentration	16-24 oz/gal for non-scaly parts 2 lb/gallon for descaling parts
Operating Temperature	70-140° F
Immersion Time	5-10 minutes.
Equipment Construction	Tank: Polypro or acidproof Heater: Teflon
Ventilation	Desirable if solution is heated.

PROCESS SEQUENCE

The OXYPRIME XP Primer/Prep is used as part of a multi-step blackening process, as follows:

1. CLEAN the metal parts by soaking in PRESTO KLEEN® HP alkaline cleaner, mixed at 8 oz/gallon; 150° F; 5-8 minutes. Or, use other cleaning methods appropriate to the part condition, bead blasting, shot peening, etc., to remove surface soils and oxides.
2. RINSE in clean water; 20 seconds.

3. APPLY PRIME COAT by immersing parts in OXYPRIME XP solution, at a temperature of 70-140° F, for 5-8 minutes.
4. RINSE in clean water; 20 seconds.
5. BLACKEN in TRU TEMP Black Oxide bath; 200-205°F; 10-15 minutes.
6. RINSE in clean water; 20 seconds.
7. SEAL in a rust preventive appropriate to the end-use of the parts, such as:
DRI-TOUCH® AMBER IRP2 rust preventive for a soft waxy finish;
Or in SHEATH® RB1 water-displacing oil, for a slightly oily finish;
Or in SHEATH WS12 water-soluble oil for fast-drying, slightly oily finish.

BATH MAINTENANCE

The OXYPRIME XP solution can be maintained by testing for total acid content, using the GO/NOGO Test Kit (available from BIRCHWOOD CASEY). As the bath works, the acid content will gradually diminish and the solution will pick up small amounts of dissolved iron from the parts being processed. Normal maintenance calls for periodic additions of OXYPRIME XP powder. The bath should be changed out periodically, depending on work load. Your BIRCHWOOD CASEY representative can guide you on process design and solution maintenance.

PACKAGING AND STORAGE

40 pound and 400 pound non-returnable drums. Store in closed containers.

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 is found on our website: www.birchwoodcasey.com

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

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OXYPRIME® XP Primer/Prep (Product Numbers 880560, 880575)
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October 2010