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Metal Finishing Systems

[www.birchwoodcasey.com](http://www.birchwoodcasey.com)

**OXYPRIME® POWDER Surface Conditioner**  
(Patented)

**Operating Instructions**

**PRODUCT DESCRIPTION**

OXYPRIME® POWDER Surface Conditioner is used to apply a special base coat, or primer coat, on iron and steel in preparation for blackening by TRU TEMP® Low Temperature Black Oxide. Supplied as a free-flowing powder, the product dissolves in water, with good stirring, and operates at room temperature.

**OPERATING CONDITIONS**

To use as a Primer before TRU TEMP:

Mix 1 lb/gal in tap water.  
room temperature operation  
5-8 minute immersion time.

Equipment Construction  
Ventilation  
Solution Agitation

Tank: Plastic or acid-proof  
Not needed. No fumes.  
Desirable for densely loaded racks

**PROCESS SEQUENCE**

The OXYPRIME POWDER Surface Conditioner is used as part of a multi-step blackening process, as follows:

1. CLEAN the metal parts by soaking in PRESTO KLEEN® HP heavy-duty 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 solution 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, dry-to-touch finish;  
Or in SHEATH WS12 water-soluble oil for fast-drying, slightly oily finish.

### **BATH MAINTENANCE**

The OXYPRIME solution can be maintained by testing for 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 iron from the parts being processed. The bath can be replenished by additions of OXYPRIME POWDER . Eventually, the tank should be dumped and re-charged with a fresh mix. The spent bath is normally sewerable after pH adjustment.

### **PACKAGING AND STORAGE**

40 pound and 400 pound non-returnable drums. Store in closed container in a dry area.

***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](http://www.birchwoodcasey.com)**

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

**NOTE:** NO REPRESENTATIONS OR WARRANTIES, EITHER EXPRESS OR IMPLIED, OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE OR OF ANY OTHER NATURE ARE MADE HEREUNDER WITH RESPECT TO THE INFORMATION SET FORTH HEREIN OR TO THE PRODUCT TO WHICH THE INFORMATION REFERS.

OXYPRIME® POWDER Primer (Product Numbers 880950, 880960, 880975)

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