

## Blakodize SS1/SS2

### Black Oxide Coating for Stainless Steel

<b>Description</b>	A two pack powdered product designed to produce lustrous deep black finishes to stainless steel alloys and cast iron.
<b>Features</b>	<ul style="list-style-type: none"><li>• Produces a black oxide coating on ferrous metals.</li><li>• Coating provides mild corrosion resistance.</li><li>• Aesthetic lustrous finish which minimises light reflection.</li><li>• No dimensional changes to the component.</li></ul>
<b>Product Code</b>	<b>TT/BLAKO/SS1</b> and <b>TT/BLAKO/SS2</b> .
<b>Equipment</b>	Mild or stainless steel tank heated by an external source.
<b>Initial Fill</b>	<ol style="list-style-type: none"><li>1. Fill the tank to approximately <math>\frac{3}{4}</math> full with cold water.</li><li>2. <b>Slowly and carefully, with stirring (to prevent violent boiling)</b>, add the required amount of Blakodizing Salt SS-1. When the salts become slow to dissolve, heating should be applied, with stirring, until all are dissolved.</li><li>3. Add water up to the working level (which should be 10 – 13 cm from the top of the tank).</li><li>4. Bring the tank to a rolling-boil.</li><li>5. The rolling-boil temperature should be checked and adjusted to 121° - 127°C.</li><li>6. At this stage, add 31 g of Blakodize SS-2 for each 1 kg of Blakodize SS-1 in the initial make-up. <b>Do this carefully, by sprinkling on the surface, and stirring in.</b></li></ol> <p>Small additions of the SS1 or SS2 salts, or water, will give the final temperature adjustment. This will enable the thermometer reading to be taken under rolling-boil conditions.</p> <p><b>The temperature reading must be taken under rolling-boil conditions - not while the tank is either boiling furiously, or not boiling properly.</b></p> <p>To make a 10 litre solution, use: 7 kg of Salts SS1, plus 220 gm of Salts SS2, added to 7 litres of water. Rolling boil temperature is 121° – 127°C.</p>
<b>Application</b>	<p><b><u>300 series stainless steels</u></b></p> <p>The general process sequence is:</p> <ol style="list-style-type: none"><li>1. Clean in hot alkaline cleaner, such as S86 Degreasing Salts (<b>TT/S86DG</b>) or Target AB14 (<b>TARG/AB14</b>) (25 – 50 g/l at 60° – 70°C).</li><li>2. Two cold water rinses.</li><li>3. Pickle in 10% sulphuric acid at 80°C for 30 seconds until even overall gassing occurs.</li><li>4. Cold water rinse.</li><li>5. Blakodizing SS tank at 121° – 127°C for 10 – 15 min.</li><li>6. Two cold water rinses.</li><li>7. Hot water rinse and dry.</li><li>8. Optional post-treatment if required.</li></ol>

**TECHNICAL DATA SHEET****Blakodize SS1/SS2****Black Oxide Coating for Stainless Steel****400 series stainless steels**

The process sequence for is:

As for 300 series, except:

3. Pickle in 50% hydrochloric acid at room temperature for 1 min.

<b>Control Points</b>	Temperature	Rolling boil 121° - 127°C
	Time	10 - 15 min, to achieve the required depth of colour.
<b>Shelf Life</b>	2 years from date of manufacture when correctly stored in unopened containers.	
<b>Storage</b>	The product should be stored in cool, dry, frost-free conditions, in sealed containers.	
<b>Health &amp; Safety</b>	<b>Refer to the product's Safety Data Sheet and safety advice on the product label before use.</b>	
<b>Technical Support</b>	For technical support in using this product, please contact: e: <a href="mailto:birminghamtech@trimite.com">birminghamtech@trimite.com</a> , or t: 0121 554 7000.	
<b>Date of Issue</b>	July 2021.	

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