

# Blakodizing Salts

## Black Oxide Coating for Steel

<b>Description</b>	A powdered product designed to produce a black lustrous finish to steel items.
<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 or MP2002</b>
<b>Equipment</b>	Mild or stainless steel tank heated by an external source.
<b>Initial Fill</b>	<p>In starting up a new tank, the approximate required amount of Blakodizing Salts are added to the tank containing the approximate volume of water. <b>This addition must be made gradually and cautiously with stirring – this prevents localised boiling.</b> The addition of Blakodizing Salts to the water produces heat therefore, care must be taken to ensure the additions are made slowly.</p> <p>The level of the solution should be 10 - 13 cm from the top of the tank. When the requisite amount of salts has been added to the tank, and it is free from further reaction, then the heating is switched on and the tank brought up to the required temperature.</p> <p>The simmer-boil temperature should be measured with a thermometer and adjusted as appropriate. Small additions of the Blakodizing Salts or water will give the final adjustment. <b>The temperature reading must be taken under simmer-boil conditions.</b></p> <p><b>Note:</b> Extra care must be taken when initially making the tanks up. This is because the Blakodizing Salts react with the inside of the tanks, causing a spray. This spray is irritating to the skin. However, after approximately one day (or less, if work has been put through) the tank will settle down. The solution will tend to thicken, and the spray and the irritation conditions will completely subside.</p> <p>Additionally, after the first couple of days, the solution will gain in strength and the temperature will rise, settling to its true operating temperature.</p> <p>To make a 10 litre solution, use:</p> <p><u>No.1 Blakodizing tank:</u> 8 kg of Salts added to 6 litres of water will give 10 litres. Simmer-boil temperature is 140°C.</p> <p><u>No.2 Blakodizing tank:</u> 9.5 kg of Salts added to 4.5 litres of water will give 10 litres. Simmer-boil temperature is 150°C.</p>

**TECHNICAL DATA SHEET****Blakodizing Salts****Black Oxide Coating for Steel**

<b>Application</b>	The typical process sequence is: <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. Derust if required.</li><li>3. Two cold water rinses.</li><li>4. No.1 Blakodizing tank.</li><li>5. No.2 Blakodizing tank.</li><li>6. Two cold water rinses.</li><li>7. Hot water rinse.</li><li>8. Dewatering tank.</li></ol>		
<b>Control Points</b>		<b><u>No.1 tank</u></b>	<b><u>No.2 tank</u></b>
	Temperature	Simmer-boil 140° - 143°C	Simmer-boil 150° - 153°C
<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>	Aug 2021.		

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