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ANTIQUER BLACK® M220 Antiquing Solution
Operating Instructions

PRODUCT DESCRIPTION

ANTIQUER BLACK® M220 Antiquing solution is a general purpose browning and blackening solution for use on copper, brass & bronze surfaces, and works on both solid and electroplated parts. Supplied as a liquid concentrate, the product is diluted with water to make up an immersion solution that operates at room temperature to produce medium-dark browns and black finishes. The finish can be highlighted for pleasing antique black, brown or US10B finishes.

OPERATING CONDITIONS

Bath Make-Up Concentration	20-25% by volume for dark brown and black 10-15% by volume for lighter brown shades.
Equipment Construction	Acid-proof tank: plastic or PVC lined.
Ventilation	None required. No fumes.
Filtration	Desirable for production-scale tanks. Use acid-proof pump and 50-100 micron polypropylene filter element.

PROCESSING GUIDELINES

1. CLEAN solid brass parts to remove oils and soils, as needed, using a mild alkaline cleaning solution, such as SAFE SCRUB® M Multi-Metal cleaner, mixed at 10-20% by volume; 130° F; 5 minutes. Alternatively, solid parts can be cleaned by bead blasting. OR, if parts are to be plated, process them through a normal electroplating cycle, depositing a minimum of 0.0002” of plating thickness.
2. RINSE thoroughly in clean, flowing water; 30 seconds.
3. NEUTRALIZE CYANIDE residue by immersing parts in 5% sulfuric acid (or sulfuric acid salts at 1 oz/gal) at room temp for 20-30 seconds. If there is any tarnish on the surface, stronger acid may be needed, such as 10-20% sulfuric acid.
4. RINSE thoroughly in clean, flowing water; 20 seconds.
5. OXIDIZE surface by immersing parts in ANTIQUER BLACK® M220 solution for 1-3 minutes, or until desired color is achieved. Gentle agitation helps to ensure good contact.
6. RINSE thoroughly in clean, flowing water; 30 seconds.

7. DRY parts and apply appropriate topcoat sealant. OR, DRY & HIGHLIGHT the surface with a Scotchbrite® wheel or abrasive pad, or equivalent, to produce an antique or distressed surface. Then, SEAL with lacquer, wax or oil, as appropriate to the end-use of the article.

BATH MAINTENANCE

The ANTIQUE BLACK® M220 bath can be operated as a semi-permanent bath in the process line and can be controlled by total acid titration or atomic absorption (using a selenium lamp). Maintain bath strength at 80% of original make-up or higher. Use a particle filter to keep the bath clean.

Before Using This Product – Please Read, Understand and Follow all the Precautions shown on the Product Label and on the Safety Data Sheet.

The Safety Data Sheet can be found on our website: www.birchwoodtechnologies.com

Use Appropriate Warning Labels on any Container used to Store or Apply this Product.

PACKAGING

55 gallon non-returnable drums. Store in closed containers.

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