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PRESTO BLACK® MKP/RPL
Room Temperature Blackening Process for Iron & Steel
Operating Instructions

PRODUCT DESCRIPTION

PRESTO BLACK® MKP is a room temperature blackening solution for all iron and non-stainless steels. Supplied as a liquid concentrate, the MKP is mixed with water to make an immersion blackening solution. The MKP bath mix contains all the ingredients necessary to form a clean black finish on a wide variety of steel surfaces. During normal blackening operation, the bath gradually gets weaker, and will require replenishment to bring it back to normal operating strength. Smaller tanks, under 20 gallons, can be replenished with the same PRESTO BLACK® MKP used for the initial mix. Larger tanks, over 20 gallons, should be replenished with a separate product, called PRESTO BLACK® RPL Replenisher. This product maintains the optimum balance of ingredients needed to ensure long-term bath stability and good performance.

OPERATING CONDITIONS

Initial Bath Make-Up	Mix at 10%, by volume, in tap water.
Bath Replenishment	Smaller tanks: Use PRESTO BLACK® MKP. Larger tanks: Use PRESTO BLACK® RPL Replenisher.
Equipment Construction	Tank: Polypropylene, PVC, or other acid-proof material. Racks, baskets, barrels: Polypro or PVC coated steel.
Ventilation	Not necessary. No fumes produced.
Filtration/Recirculation	Desirable on larger tanks. Use acid-proof pump and 50-100 micron polypropylene filter element.

BLACKENING PROCEDURES

For best results, the parts require thorough cleaning, surface conditioning, blackening and sealing with an appropriate rust preventive compound, as follows:

1. CLEAN the parts to remove oils and shop soils.
 - 1.1. For lighter oils and soils, use SAFE SCRUB® ST biodegradable liquid cleaner, mixed at 20% by volume and operate at 150° F. Typical immersion time of 8 minutes.
 - 1.2. For heavy-duty cleaning, use PRESTO KLEEN® HP, mixed at 8 – 12oz/gal and operated at 150° F. Typical immersion time of 8 minutes.
2. RINSE thoroughly in clean water; 30 seconds.
3. ACTIVATE SURFACE by immersing parts SAFE PREP® Surface Conditioner, mixed at 10% by volume, and operated at room temperature. Typical immersion time of 1 – 2 minutes.
4. RINSE thoroughly in clean water; 30 seconds.
5. BLACKEN parts by immersing in the PRESTO BLACK solution for 1 – 3 minutes, or until parts are uniformly black.
6. RINSE thoroughly in clean water; 30 seconds.
7. SEAL the black finish in DRI TOUCH® AMBER IRP2 dry-to-touch finish, or other appropriate rust preventive topcoat.

BATH MAINTENANCE

As the MKP bath operates, its concentration will gradually diminish and the reaction will slow down. The bath can be replenished by adding fresh MKP concentrate or RPL Replenisher. The bath can be tested by using a simple CCK – 1 Color Change Kit, available from Birchwood Technologies®. This test will determine how much Replenisher needs to be added to the bath.

PACKAGING

1, 5 and 55 gallon plastic, non-returnable containers. Store indoors in closed container.

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.

NOTE: The information contained herein is provided in good faith and is believed to be correct as of the date below. However, Birchwood Laboratories LLC makes no representation as to the comprehensiveness or accuracy of the information. It is expected that individuals receiving the information will exercise their independent judgment in determining its appropriateness for a particular purpose. Accordingly, Birchwood Laboratories LLC will not be responsible for damages of any kind resulting from the use of or reliance upon such information.

PRESTO BLACK® MKP Makeup Concentrate (Product Numbers: 560250, 560252, 560258)

PRESTO BLACK® RPL Replenisher Concentrate (Product Numbers: 560550, 560551, 560558)

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