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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.
Use at room temperature
with a 5-8 minute immersion time.
Tank: Plastic or acid-proof
Not needed. No fumes.
Desirable for densely loaded racks

Equipment Construction
Ventilation
Solution Agitation

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 alkaline cleaner (mixed at 8 oz/gallon; operated at 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; 30 seconds.
3. **APPLY PRIME COAT** by immersing parts in OXYPRIME® POWDER solution (operated at 70-140° F, for 5-8 minutes).
4. **RINSE** in clean water; 30 seconds.
5. **BLACKEN** in TRU TEMP® Black Oxide bath (operated at 200-205°F; 10-15 minutes).
6. **RINSE** in clean water; 30 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 finish;
Or in SHEATH® RB1 water-displacing oil, for a slightly oily finish;
Or in SHEATH® WS12 water-soluble oil for fast-drying, slightly oily finish.
Or in SHEATH WS12 water-soluble oil for fast-drying, slightly oily finish.

BATH MAINTENANCE

The OXYPRIME® POWDER solution can be maintained by testing for acid content, using the Go/NoGo Test Kit (available from Birchwood Technologies®). 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 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.

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